

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<h3>ANTICORROSIVE ISOLATION PRIMER 3:1</h3>	
<b>PRODUCTS</b> Wet on Wet Anticorrosive Isolation Acrylic Primer 3:1 Hardener 1:3 for Wet on Wet Acrylic Primer Thinner for acrylic products	
<b>PRODUCT DESCRIPTION</b> High quality 2K acrylic primer with anti-corrosion additives. It is a perfect isolating grounding for car repairs. It is also a perfect protection from corrosion for sanded bare steel. It isolates difficult surfaces and putties from topcoats and protects from mapping effects. Ideal spreading and fast curing allows to apply it with the wet on wet technique as it does not require sanding.	
<ul style="list-style-type: none"> <li>• Perfect anticorrosive protection of steel surfaces.</li> <li>• Strong adhesion to various surfaces.</li> <li>• Very good isolating properties.</li> <li>• Short hardening time.</li> <li>• Applicable with the wet on wet technique.</li> </ul>	
<b>COLOUR:</b> white, lightgrey, black <b>GLOSS GRADE:</b> matt	

<b>VOLATILE ORGANIC COMPOUNDS</b> VOC for mixture = 538 [g/l] This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (C), at 540 g/l.	
<b>SURFACE PREPARATION</b> Wet on Wet Acrylic Primer 3:1 can be applied over:	
<ul style="list-style-type: none"> <li>• Steel and aluminum after flatting and degreasing.</li> <li>• Zinc coated steel and galvanized steel after flatting and degreasing.</li> <li>• Sanded glass polyester laminates (GFK/GRP).</li> <li>• Polyester putties.</li> <li>• Epoxy primers.</li> <li>• Wash primers.</li> <li>• Old finishes in good conditio.</li> </ul>	Good Surface preparation is necessary to achieve the best results of repairs. Recommended abrasive paper with gradation as follows: <ul style="list-style-type: none"> <li>• sanding by hand (dry): P280÷P400.</li> <li>• sanding by hand (wet): P400-P800.</li> <li>• sanding by machine (dry): P240÷P400.</li> </ul>

APPLICATION PROCESS											
	<b>USE</b> For car repairs as an isolation primer for sanding or wet on wet technique.		<b>NUMBER OF LAYERS AND RP GUN PARAMETERS</b> Number of layers for these options: <b>For wet on wet:</b> 1.5 layers; approx. 30µm of dry layer. <b>For sanding:</b> 1+2 layers; approx 50µm of dry layer. <b>RP gun parameters:</b> RP Nozzle: 1.2÷1.6 mm; Pressure of input: 2.0÷2.2 bars. HVLP Nozzle 1.3÷1.5 mm; Inlet pressure: 2.0 bars.								
	<table border="1"> <tr> <th>MIXING RATIO</th> <th>by volume</th> </tr> <tr> <td>Primer</td> <td>3 parts</td> </tr> <tr> <td>Hardener</td> <td>1 part</td> </tr> <tr> <td>Thinner: wet on wet option</td> <td>35%</td> </tr> <tr> <td>option for standing</td> <td>20%</td> </tr> </table> Stir thoroughly until achieving homogenous mixture.		MIXING RATIO	by volume	Primer	3 parts	Hardener	1 part	Thinner: wet on wet option	35%	option for standing
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	<b>SPRAYING VISCOSITY DIN4</b> 17÷19 sec. at 20°C with 35% thinner. approx. 30 sec. at 20°C with 20% thinner.		<b>EVAPORATION TIME</b> <b>Between layers:</b> approx. 5÷10 minutes. <b>Before applying solvent base:</b> approx. 20 minutes. <b>Before applying water base:</b> approx. 30 minutes.								
	<b>POT LIFE</b> Approx. 40 minutes at 20°C.		Evaporation time depends on the temperature and the number of layers.								

	<b>HARDENING TIME</b> Isolation primer (30÷50 µm) <b>Hardening time at 20°C:</b> ready for sanding after 2÷3 hours. <b>Hardening time at 60°C (facility temperature):</b> ready for sanding after baking for about 15÷20 minutes cooling (approx. 1hour). Temperature below 20°C significantly increases the hardening time.		<b>IR DRYING</b>	
			Isolation primer (30÷50µm)	5÷7 minutes of short waves
			Primer for sending (50÷100 µm)	8÷10 minutes of short waves
			Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.	
	<b>DRY SANDING</b> Machine sanding: P360÷P500 Hand sanding: P320÷P500 Wet on wet does not require standing!		<b>WET SANDING</b>	
			Machine sanding: P600÷P1000 Hand sanding: P800÷P1000 Wet on wet does not require sanding!	

**FURTHER WORK**

2K acrylic fillers can be directly over coated with:

- K top coats.
- 1K base coats.

Also:

- 2K polyester putties.
- 2K acrylic primers.

**GENERAL NOTES**

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

**Caution:** To maintain safety, always follow the instructions given in the MSDS for the products.

**STORAGE**

Store the product between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Note:**

1. After each use the container with product should be immediately closed!
2. Protect the hardener from frost and dampness!

**WARRANTY PERIOD**

Wet on Wet Anticorrosive Isolation Acrylic Primer 3:1	– 12 months from the date of production
Hardener 1:3 for Wet on Wet Anticorrosive Isolation Acrylic Primer	– 12 months from the date of production
Thinner for acrylic products	– 12 months from the date of production

PRODUCT	ART. No.
Wet on Wet Anticorrosive Isolation Acrylic Primer 3:1	(0,75l + 0,25l): 2114; 11257; 11258
Hardener 1:3 for Wet on Wet Anticorrosive Isolation Acrylic Primer	
Thinner for acrylic products	300002236; 300002237 (1l; 5l)

**LIMITATION OF LIABILITY**

The information contained in the TDS is up-to-date and correct on the day the information is released.

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