

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

ALL SET 1K 1K ACRYLIC PRIMER PRODUCTS ALL SET 1K Acrylic primer Urethane Reducer INTER TROTON PRODUCT DESCRIPTION 1K primer with good adhesion to different surfaces such as steel and aluminum after flatting and degreasing. Features very good leveling and exceptional filling properties. It is easy to use, has short drying time and excellent coverage. Available in grey and beige.	 COLOURS: grey, beige GLOSS GRADE: matt
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VOLATILE ORGANIC COMPOUNDS VOC for mixture = 533 [g/l] – 4.449 [lb/gal] This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (C), at 540 g/l.	
SURFACE PREPARATION ALL SET 1K can be applied on: - Steel and aluminum after flatting and degreasing. - Sanded polyester-glass laminates (GFK/GRP). - Polyester putties. - Plastic after grounding with 1K Plastic Primer. - Old finishes in good condition after flatting and degreasing. Good surface preparation is necessary for achieving best results. Following sandpaper gradations are recommended: - by hand (dry or wet): P280÷P320 (GRP P400). - by machine (dry): P180÷P220.	

APPLICATION PROCESS				
	USE			DRYING TIME
	For minor car repairs.			Depending on the coat thickness: • Approx. 40 minutes at 20°C (68°F) • Approx. 15 minutes at 60°C (140°F) Temperature below 20°C (68°F) significantly increases the hardening time.
	MIXING RATIO by volume			NUMBER OF COATS & SPRAY GUN SETTINGS
	Primer: 1 Reducer: 10÷15%	Stir thoroughly until achieving homogenous paste.		2÷3 coats Compliant (RP) spray gun: 1.6÷2.0 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar)
	SPRAYING VISCOSITY			HVLP spray gun: 1.5÷1.9 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar).
	FLASH-OFF TIME			DRY SANDING
	Between coats:	approx. 5 minutes		Machine sanding: P360÷P500. Hand sanding: P280÷P320.
	Before banking:	approx. 10 minutes (to matt)	WET SANDING	
	Evaporation time depends on the temperature and the number of layers.			Machine sanding: P600÷P1000. Hand sanding: P800÷P1000

FURTHER WORK

1K acrylic primers can be directly over coated with:

- 2K acrylic top coats.
- 1K basecoats.

GENERAL NOTES

- The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- When working , 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 components between 15 to 25°C (59 to 77°F) in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: *Close the container immediately after use.*

WARRANTY PERIOD

ALL SET 1K – 12 months from the date of production

PRODUCT	ART. No.
ALL SET 1K	14552; 14553 (0,8l; 3,75l)
Urethane Reducers INTER TROTON	300009942; 300009943 (1l; 5l)

LIMITATION OF LIABILITY

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

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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