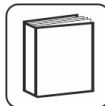
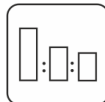


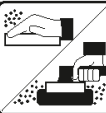
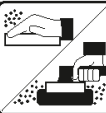
TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

HIGH BUILD 4:1 2K URETHANE PRIMER	 COLORS: white, grey, black GLOSS GRADE: matt
PRODUCTS HIGH BUILD 4:1 Urethane Primer Hardener 1:4 for HIGH BUILD Urethane Primer Urethane Reducers INTER TROTON	
PRODUCT DESCRIPTION	
2K urethane high build primer with maximum adhesion to aluminum and galvanized steel. Can be applied directly over bare metal thanks to its great isolation properties. Shows very good vertical stability with excellent filling. Sands easily wet or dry. Available in grey, white and black.	

VOLATILE ORGANIC COMPOUNDS	
VOC with 20% of reducer = 510 [g/l] – 4,256 [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	
Urethane primer HIGH BUILD 4:1 can be applied over: - Steel and aluminum after flatting and degreasing. - Zinc coated steel after flatting and degreasing. - Sanded polyester-glass laminates (GFK/GRP). - Polyester putties and body fillers - Epoxy primers. - Wash primers. - Old finishes in good condition after flatting and degreasing.	Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended: - Sanding by hand (dry or wet): P280÷P320 (GRP P400). - Sanding by machine (dry): P180÷P220.

APPLICATION PROCESS				
	USE			HARDENING TIME
	For car body repairs as an isolating (thin-coat) or filling primer.			Filling version (130–300 µm / 5.1–11.8 mil): - at 20°C (68°F): ready for sanding after overnight drying. - at 60°C (140°F): ready for sanding after baking for 35÷40 minutes and cooling the coating (about 2 hours). Priming version (60–130 µm / 2.4–5.1 mil): - at 20°C (68°F):: ready for sanding after 3÷4 h. - at 60°C (140°F):ready for sanding after baking for 25÷30 minutes and cooling the coating (about 2 hours). Temperature below 20°C (68°F) significantly increases the hardening time.
	MIXING RATIO by volume			NUMBER OF COATS & SPRAY GUN SETTINGS
	Primer 4 parts Hardener 1 part Reducer: Filling version 10% Priming version 20% Stir thoroughly until achieving homogenous mixture.			2÷3 coats; 130–300 µm (5.1–11.8 mil) DFT, depending on the spray gun nozzle size. Compliant (RP) spray gun: 1.6÷2.0 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar) 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).
	SPRAYING VISCOSITY			
	Filling version: 40÷50 sec. at 20°C (68°F) Priming version: 25÷30 sec. at 20°C (68°F)			

	POT LIFE		IR DRYING
	Approx. 60 minutes at 20°C (68°F)/DIN4.		Filling version (130–300 µm / 5.1–11.8 mil): 10÷15 minutes of short waves. Priming version (60–130 µm / 2.4–5.1 mil): 8÷10 minutes of short waves. Do not exceed 60°C (140°F). Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	EVAPORATION TIME		WET SANDING
	Between layers: 5÷10 minutes Before baking: 5÷15 minutes Evaporation time depends on the temperature and the thickness of coats		Machine sanding: P360÷P500. Hand sanding: P280÷P360.
	DRY SANDING		Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.

FURTHER WORK

2K urethane fillers can be directly over coated with:

- 2K urethane topcoats.
- 1K basecoats.

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 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:

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

WARRANTY PERIOD

HIGH BUILD 4:1 Urethane Primer	– 12 months from the date of production
Hardener 1:4 for HIGH BUILD 4:1 Urethane Primer	– 12 months from the date of production
Urethane Reducers MASTER	– 24 months from the date of production

PRODUCT	ART. No.
HIGH BUILD 4:1 Urethane Primer	(0.8l + 0.2l): 14545, 14543, 14544 (3.75l): 14549, 14548, 14547
Hardener 1:4 for HIGH BUILD 4:1 Urethane Primer	(0.94l): 14550
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.

TROTON Sp. z o.o.
Ząbrowo, Poland.