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TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

V2012 HS 4:1

2K URETHANE PRIMER HS 4:1

COLORS: white, grey, black

GLOSS GRADE: matt

PRODUCTS

V2012 HS 4:1 Urethane Primer– HS Filler primer for galvanized steel
Hardener 1:4 for V2012 HS Urethane Primer
Urethane Reducers MASTER

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.

- Excellent adhesion to difficult substrates.
- Easy to mix and apply.
- Very good vertical stability.
- Good filling and insulating properties.
- Easy sanding.

VOLATILE ORGANIC COMPOUNDS

VOC with 10% of reducer = 460 [g/l], VOC with 20% of reducer = 510 [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.

SURFACE PREPARATION

Urethane primer V2012 HS 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

For car body repairs as an isolating (thin-coat) or filling primer.

MIXING RATIO by volume

Primer	4 parts
Hardener	1 part
Reducer:	
Filling version	10%
Priming version	20%

Stir thoroughly until achieving homogenous mixture.

SPRAYING VISCOSITY

Filling version: 40÷50 sec. at 20°C (68°F)
Priming version: 25÷30 sec. at 20°C (68°F)

HARDENING TIME

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):

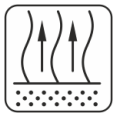
- **at 20°C (68°F)::** ready for sanding after 3÷4 h.
- **at 60°C (140°F):**ready for sanding after baking for 25÷30 minutes and cooling the coating (about 2 hours).

Temperature below 20°C (68°F) significantly increases the hardening time.

NUMBER OF COATS & SPRAY GUN SETTINGS

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).

	**POT LIFE** Approx. 60 minutes at 20°C (68°F)/DIN4.		**IR DRYING** **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** Between layers: 5÷10 minutes Before baking: 5÷15 minutes Evaporation time depends on the temperature and the thickness of coats		
	**DRY SANDING** Machine sanding: P360÷P500. Hand sanding: P280÷P360.		**WET 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

V2012 HS 4:1 Urethane Primer	– 12 months from the date of production
Hardener 1:4 for V2012 HS Urethane Primer	– 12 months from the date of production
Urethane Reducers MASTER	– 24 months from the date of production

PRODUCT	ART. No.
V2012 HS 4:1 Urethane Primer	(0.8l + 0.2l): 15608, 15609, 15610 (3.6l): 15611, 15612, 15613
Hardener 1:4 for V2012 HS Urethane Primer	(0.9l): 15614
Urethane Reducers MASTER	Medium - 300010232; 300009053 (1l; 5l) Fast- 15305; 13414 (1l; 5l) Slow- 15306; 15307 (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.
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