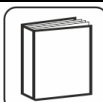
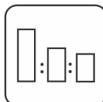
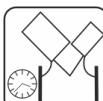
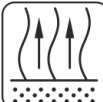


TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

V2012 HS 4:1 2K URETHANE PRIMER VOC 2.1	
PRODUCTS V2012 HS 4:1 2K Urethane primer – Filling and isolating primer for galvanized steel. Hardener 1:4 for 2K Urethane Primer V2012 HS Urethane Reducers VOC ZERO	
PRODUCT DESCRIPTION High quality 2-pack urethane anticorrosive undercoat with excellent adhesion to steel, aluminum, galvanized steel, polyester body fillers and putties, and old coatings. Designed especially for car refinish. - Excellent adhesion to difficult substrates. - Easy to mixing and apply. - Exceptional vertical stability. - Good filling and isolation properties. - Easy to sanding.	
	
COLORS: white, light grey, black GLOSS GRADE: matt	

VOLATILE ORGANIC COMPOUNDS VOC = 236.26 g/l – 1.973 lb/gal (<2.1 lb/gal)	
SURFACE PREPARATION V2012 urethane primer can be applied over: - Steel and aluminum after sanding and degreasing. - Galvanized steel after sanding and degreasing. - Sanded polyester glass laminates (GFK/GRP). 2-pack polyester putties/body fillers, polyester spraying fillers. - Wash primers. 2-pack urethane primers. 2-pack epoxy primers. - Old finishes in good condition after sanding and degreasing.	
Good Surface preparation is necessary to achieve the best results of repairs. Recommended abrasive paper with gradation as follows: - grinding by hand (dry or wet) : P280÷P320 (GRP P400). - grinding by machine (dry) : P180÷P220.	

APPLICATION PROCESS				
	USE			NUMBER OF COATS & SPRAY GUN SETTINGS
	For car refinish as a filling primer or isolating coating.			2÷3 coats; 130–300 µm (5.1–11.8 mil) DFT, depending on the spray gun nozzle size.
	MIXING RATIO by volume			Compliant (RP) spray gun: 1.6÷2.0 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar)
	Primer 4 parts Hardener 1 part Reducer 10÷15%			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			HARDENING TIME
	30÷40 seconds at 20°C (68°F)/DIN4.			Curing time at 20°C (68°F): Thick coating 130–300 µm (5.1–11.8 mil) DFT is ready to sand after drying overnight. Thin film 60–130 µm (2.4–5.1 mil) DFT is ready to sand after 3÷4 h.
	POT LIFE			Curing time at 60°C (140°F) object temperature: Thick coating 130–300 µm (5.1–11.8 mil) is ready for sand after baking for 35÷40 minutes and cooling down (about 2 h). Thin film 60–130 µm (2.4–5.1 mil) is ready to sand after baking for 25÷30 minutes and cooling down (about 2 h).
	Approx. 60 minutes at 20°C (68°F)/DIN4.			Temperature below 20°C (68°F) significantly decreases the hardening time.
	EVAPORATION TIME			
	Between coats: 10÷15 minutes Before baking: 15 minutes Evaporation time depends on the temperature and the thickness of coats.			

	IR DRYING		DRY SANDING	
	Thick coating (up to 180µm/7.1 mil): 15÷20 minutes of short waves. Thin coating (up to 130µm/5.1 mil): 10÷15 minutes of short waves. Drying time may change depending on the type of heater.		Machine sanding: P360÷P500. Hand sanding: P280÷P360.	
			WET SANDING	
			Hand sanding: P600÷P1000.	

FURTHER WORK

V2012 HS 4:1 2K urethane primer can be directly over coated with:

- 2-pack topcoats.
- 1-pack basecoats.

GENERAL NOTES

- Do not exceed recommended doses of hardener!
- The best repair results you can achieve at room temperature. Temperature in body shop and temperature of a product should be the same.
- When working with 2K products, clean the guns and equipment immediately after use.
- The rooms should be well ventilated.

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 Urethane Primer V2012	– 12 months from the date of production
Urethane Reducers VOC ZERO	– 24 months from the date of production

PRODUCT	ART. No.
V2012 HS 4:1 2K Urethane Primer	9528 (0,8l + 0,2l) 9407; 10003; 9409 (3,6l)
Hardener 1:4 for Urethane Primer V2012	9408 (0,9l)
Urethane Reducer MEDIUM VOC ZERO	8562; 8561 (1l; 5l)
Urethane Reducer FAST VOC ZERO	7868; 8557 (1l; 5l)
Urethane Reducer SLOW VOC ZERO	2289; 9235 (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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