MASTER
TROTON

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# TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

## V2012 HS 4:1

2K URETHANE PRIMER VOC 2.1


**COLORS:** white, light grey, black

**GLOSS GRADE:** matt

### 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.

### 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

For car refinish as a filling primer or isolating coating.

#### MIXING RATIO by volume

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| Primer | 4 parts |
| Hardener | 1 part |
| Reducer | 10÷15% |

Mix well until smooth mixture is achieved.

#### SPRAYING VISCOSITY

30÷40 seconds at 20°C (68°F)/DIN4.

#### POT LIFE

Approx. 60 minutes at 20°C (68°F)/DIN4.

#### EVAPORATION TIME

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| Between coats: | 10÷15 minutes |
| Before baking: | 15 minutes |

Evaporation time depends on the temperature and the thickness of coats.

#### 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).

#### HARDENING TIME

**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.

**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).

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

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

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| V2012 HS 4:1 Urethaen 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)<br>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.

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