

TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

V2018 HS 4:1

FAST 2K URETHANE PRIMER HS 4:1

PRODUCTS

V2018 HS 4:1 2K Urethane Primer
Hardener 1:4 for 2K Urethane Primer V2018 HS
Urethane Reducers MASTER

PRODUCT DESCRIPTION

2K polyurethane primer with very high solids content. New technology formulation developed to make the repair process quicker and easier. Features great leveling effect and super fast drying, which allows for sanding after only 60 minutes from application at 68°F. Compatible with both waterborne and solvent based paint systems. Can be applied directly to metal. Available in grey, white and black.

- Short drying time.
- Excellent adhesion to difficult surfaces.
- Easy to mix and apply.
- Exceptional vertical stability.
- Good filling properties.



COLORS: white, grey, black

GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 420 [g/l] – 3,505 [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

V2018 HS 4:1 2K Urethane Primer 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

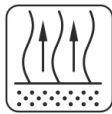
Good preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

- Sanding by hand (dry or wet): P280÷P320 (GRP P400).
- Sanding by machine (dry): P180÷P220.

APPLICATION PROCESS

	USE		NUMBER OF COATS & SPRAY GUN SETTINGS	
	For car repairs as a filling primer.			2÷3 coats. Approximately 70–90 µm (2.8–3.5 mils) per coat. 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).
	MIXING RATIO	by volume		HARDENING TIME Curing time for thick coat 150÷180 µm (5.9–7.1 mils) Approx 1 hour at 20°C (68°F) Approx 10 min at 60°C (140°F) Curing time for thick coat 180÷250 µm (7.1–9.8 mils) Approx 2 hours at 20°C (68°F). Temperature below 20°C (68°F) significantly increases the hardening time.
	SPRAYING VISCOSITY			IR DRYING 10÷15 minutes of short waves for the thickness of 150÷180 µm (5.9–7.1 mils). Do not exceed 60°C (140°F). Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	POT LIFE			DRY SANDING Machine sanding: P360÷P500. Hand sanding: P280÷P320.
	30÷50 seconds at 20°C (68°F)/DIN4.			
	Primer 4 parts Hardener 1 part Reducer 5%			
	Stir thoroughly until achieving homogenous mixture.			
	Approx. 65 minutes at 20°C (68°F).			

	EVAPORATION TIME Between coats: 5÷10 minutes Before baking: approx. 10 minutes Evaporation time depends on the temperature and the number of layers.		WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.

FURTHER WORK

V2018 2K Urethane Primer can be directly over coated with:

- 2-pack urethane topcoats.
- 1-pack 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

V2018 HS 4:1 2K Urethane Primer	– 12 months from the date of production
Hardener 1:4 for 2K Urethane Primer V2018 HS	– 12 months from the date of production
Urethane Reducers MASTER	– 24 months from the date of production

PRODUCT	ART. No.
V2018 HS 4:1 2K Urethane Primer	(0.8l+0.2l): 15615, 15616, 15617 (3.6l): 15618, 15619, 15620
Hardener 1:4 for 2K Urethane Primer V2018 HS	(0.9l): 15621
Urethane Reducers MASTER	300010232; 300009053 (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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TROTON Sp. z o.o.
Ząbrowo, Poland.