

TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

V2018 HS 4:1

FAST 2K URETHANE PRIMER VOC 2.1

PRODUCTS

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

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, light grey, black.

GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS

VOC = 246.00 g/l – 2.053 lb/gal (<2.1 lb/gal)

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.

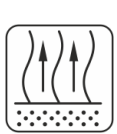
Good preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

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

APPLICATION PROCESS

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	APPLICATION		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		HARDENING TIME
	by volume Primer 4 parts Hardener 1 part Reducer 15÷20% Stir thoroughly until achieving homogenous mixture.		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÷3 hours at 20°C (68°F). Temperature below 20°C (68°F) significantly increases the hardening time.
	SPRAYING VISCOSITY		IR DRYING
	30÷40 seconds at 20°C (68°F)/DIN4.		150÷180 µm (5.9–7.1 mils): 10÷15 minutes under short wave. 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 Approx. 65 minutes at 20°C (68°F)/DIN4.		DRY SANDING Grinding Machine: P360÷P500. Hand Sanding: P280÷P320.
	EVAPORATION TIME Between coats: 5÷10 minutes Before baking: approx. 10 minutes Evaporation time depends on temperature and film thickness.		WET SANDING Hand Sanding: P800÷P1000. Grinding Machine: P600÷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 VOC ZERO	– 24 months from the date of production

PRODUCT	ART. No.
V2018 HS 4:1 2K Urethane Primer	15600; 15601; 15602 (0,8l + 0,2l) 15603; 15604; 15605 (3,6l)
Hardener 1:4 for 2K Urethane Primer V2018 HS	15606 (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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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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