

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### ANTICORROSIVE ISOLATION PRIMER Acrylic Primer 3:1

#### PRODUCTS

Wet on Wet Anticorrosive Isolation Acrylic Primer 3:1  
Hardener 1:3 for Wet on Wet Acrylic Primer  
Thinner for acrylic products

#### PRODUCT DESCRIPTION

High quality 2K acrylic primer with anti-corrosion additives. It is a perfect isolating grounding for car repairs. It is also a perfect protection from corrosion for sanded bare steel. It isolates difficult surfaces and putties from topcoats and protects from mapping effects. Ideal spreading and fast curing allows to apply it with the wet on wet technique as it does not require sanding.

- ✓ Very good anticorrosive protection of steel surfaces.
- ✓ Strong adhesion to various surfaces.
- ✓ Very good isolating properties
- ✓ Short hardening time.
- ✓ Applicable with the wet on wet technique.

Color - Light grey, white, black  
Gloss Grade – Matt.  
Density – 1,42 kg/l.

#### VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 538 [g/l]

The share of VOC is below 540 g/l. These products meet the EU directive (2004/42/EC) that sets the VOC value for its category (IIIB), at 540 g/l.

## SURFACE PREPARATION


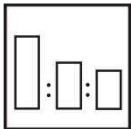
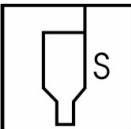
Wet on Wet Acrylic Primer 3:1 can be applied over:

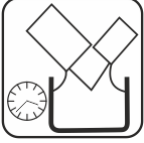






- ✓ Steel and aluminum after flatting and degreasing.
- ✓ Zinc coated steel and galvanized steel after flatting and degreasing.
- ✓ Sanded glass polyester laminates (GFK/GRP).
- ✓ Polyester putties
- ✓ Epoxy primers.
- ✓ Wash primers.
- ✓ Old finishes in good condition.

Good Surface preparation is necessary to achieve the best results of repairs. Recommended abrasive paper with gradation as follows:

- sanding by hand (dry) : P280÷P400; (wet) P400-P800.
- sanding by machine (dry) : P240÷P400.

## APPLICATION PROCESS

	<p><b>USE</b> For car repairs as an isolation primer for sanding or wet on wet technique.</p>
	<p><b>Mixing ratio</b>                      <b>by volume</b></p> <p>Primer                                      3 parts          Hardener                                 1 part          Thinner                                     35% for wet on wet              20% for sanding</p> <p>Stir thoroughly until achieving homogenous mixture.</p>
	<p><b>Spraying viscosity</b>          17÷19 sec. at 20°C with 35% thinner          approx. 30 sec. at 20°C with 20% thinner</p>

	<p><b>Pot life</b></p> <p>Approx. 40 minutes at 20°C</p>
	<p><b>Number of layers:</b>          For wet on wet: 1,5 layer; approx. 30µm of dry layer.          For sanding: 1÷2 layers; approx 50µm of dry layer</p> <p><b>RP gun parameters:</b>          Nozzle: 1,2÷1,6 mm, Pressure: 2,0÷2,2 bar</p> <p><b>HVLP gun parameters:</b>          Nozzle: 1,3÷1,5 mm; Pressure: 2,0 bar</p>
	<p><b>Evaporation time</b></p> <p>between layers approx. 5÷10 minutes          before applying solvent base approx. 20 minutes          before applying water base: approx.. 30 minutes</p> <p>Evaporation time depends on the temperature and the number of layers</p>
	<p><b>Hardening time at 20°C:</b>          Isolation primer /30÷50 µm/ ready for sanding ater 2÷3 hours.</p> <p><b>Hardening time at 60°C</b>          Isolation primer /30÷50 µm/ ready for sanding after baking for about 15÷20 minutes cooling (approx. 1hour)          Temperature below 20°C significantly increases the hardening time.</p>
	<p><b>IR Drying:</b>          Isolation primer /30-50 µm/: 8-10 minutes of short waves.          IR drying proces time may change depending on the IR dryer type.</p>
	<p><b>Dry sanding</b></p> <p>Machine sanding: P360÷P500.          Hand sanding: P320÷P500.          Wet on wet does not require sanding</p>
	<p><b>Wet sanding</b></p> <p>Hand sanding: P800÷P1000.          Wet on wet does not require sanding</p>

**FURTHER WORK**

2K acrylic fillers can be directly over coated with:

- ✓ 2K top coats.
- ✓ 1K base coats.
- ✓ 2K polyester putties
- ✓ 2K acrylic primers

#### 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.
- ✓ 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 in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

#### Note

1. *Close the container after use.*
2. *Protect the hardener from frost and dampness*

#### WARRANTY PERIOD

Wet on Wet Acrylic Primer 3:1- 12 months from the date of Manufacture.

Hardener 1:3 for Wet on Wet Acrylic Primer – 9 months from the date of Manufacture.

**Important Information:**

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The information contained in this document corresponds to our present knowledge and is a guide to our products and their uses.

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