TRADE CAR PAINTS TECHNICAL DATA SHEET

Trade Car Paints BRAND 2K NON ISO PRIMER (GREY)

DESCRIPTION

2K Non Iso Primer:
1 NON ISO PRIMER is a top quality, 2 pack acrylic primer filler, available in grey, it contains anticorrosive pigments and is chromatefree. It has excellent application properties, is quick drying and is easy to sand. It is suitable for many different substrates including correctly prepared bare steel, fibre glass and sound original finishes. For maximum adhesion to aluminium an etch primer should first be applied. It is suitable for use under a wide variety of topcoats particularly 2K acrylics and basecoat / clear systems.

PREPARATION OF SUBSTRATE

1: Bare Steel Clean with pre-cleaning solvent, sand with P180 and clean again with pre-cleaning solvent
2: Aluminum and Galvanized Substrates - as for bare steel but then apply an etch primer and allow to dry for 1 hour prior to application of the 2K NON ISO PRIMER.
3: Fibre Glass - Remove release agent with warm soapy water. Rinse, dry and clean with pre-cleaning solvent. Sand surface with P180. Clean again with pre-cleaning solvent.
4: Previously Painted Surfaces in sound condition Clean with suitable Pre-cleaning solvent, sand with P180 and clean again with pre-cleaning solvent

MIXING

Mix by volume 2 parts 2K NON ISO PRIMER: 1 part NON ISO HARDENER.
Up to 10% by volume of 2K FAST thinner may be added as required. The recommended spray viscosity is 18 sec. DIN 4 @ 20^0C.

SPRAY PRESSURE 50 60 PSI (34 bar) at gun.
GUN SET UP 1.4 1.7 mav nozzle e.g. SATA MSH, MSB or DEVILBISS JGA FW/86

APPLICATION

1: As a high build primer use minimum amount of thinner and apply 2-3 coats with 10 mins. Flash off between coats to give 100150 microns dry film thickness.
2: As a conventional primer-filler add up to 30% thinner and apply 2 coats to give approx. 50 microns dry film thickness.
POT LIFE Approximately 2 hrs. at 20^0C depending upon the amount of thinner used.
DRYING
AIR DRYING:-When used as a high build primer-filler the film can be wet flatted after air drying for approx. 3hrs.and when used as a conventional primer-filler after air drying for 2hrs. depending upon temperature and conditions. N.B. Primer must be fully cured before flatting.
STOVING:-When used as a high build primer-filler stove for 30mins. at 60^0C panel temperature. When used as a conventional primer-filler stove for 20 mins. at 60^0C panel temperature.
INFRARED 10-15 mins. using conventional infrared.
FLASH POINT 22^0c 32^0c