

TECHNICAL DATA SHEET

Item number: 0103-201-XXX0

Product name: 5+1 EURODUR HS PRIMER-FILLER

5+1 HS PRIMER-FILLER

Description: Two-component acrylic primer with very good filling properties as well as enhanced chemical and anti-corrosion properties. This enhanced hardness product exhibits very good adhesion and good sanding properties. Thanks to short curing time it prohibits absorption of resin base from the topcoat – which in turn prevents loss of gloss and helps to create depth of color. It does not exhibit yellowing tendency during exposition.

RECOMMENDED USE

- ▲ versatile use in the automotive industry
- ▲ for coating restoration
- ▲ levelling of the surface
- ▲ for filling of the surface in order to achieve appropriate smoothness before top-coating

TECHNICAL PROPERTIES

• Density, (approx) kg/dm ³	1,5
• Recommended film thickness per one coat, dry, µm	60
• Recommended film thickness per one coat, wet, µm	95
• Cure time at 20°C, h	24
• Cure time at 60°C, h	1
• Theoretical coverage at film thickness 60 µm dm ³ /m ²	0,09
• Pot life at 20°C, h	1
• Non-volatile ingredients (approx),% by volume	65
• VOC (category B/5) permitted, g/l	540
• VOC in a ready-to-use product, depending from amount of thinner g/l	510-540
• Recommended number of coats	2-3

GLOSS: matte

COLOR: **0104**-light beige **0107**-dark beige **0300**-red **0700**-graphite
0702-hoary **0708**-dark gray **0959**-black **0900**-white

PRODUCT APPLICATION

Contents should be stirred after opening the cans

PREPARATION OF MIXTURE – precisely mix part I with part II (part II number - 0104-201-0000) in the following ratio: by volume

- part I 5
- part II 1

Apply with a conventional sprayer after mixing and thinning to spraying viscosity.

Application tools

Airless sprayer, brush, conventional sprayer

- △ tip size 1,8– 2,5 mm
- △ spraying pressure 2,5 – 3,5 atm

Primer: add 15% of 8002 solvent – DIN4 viscosity – **30-35 sec**

VOC content in ready-to-use mixture: =**510g/l**

Filling primer: add 20% of 8002 solvent – DIN4 viscosity – **20-25 sec**

VOC content in ready-to-use mixture: = **540g/l**

SOLVENT: item number 8002

Hardware cleaning: 8002

APPLICATION

Surfaces – Degreased surface – free from oils, grease, dust, flaking coatings, mill scales, rust and any other contaminants. The surface should be sanded with 120-220 grid paper – free from dust, corrosion and dry.

- △ Dry steel surface, free from any contaminants, degreased – cleaned to at least **Sa 2** (stream treated) cleanliness degree for exterior surfaces. It is allowed to clean exterior surfaces to **Sa 3** cleanliness degree (manual cleaning or with mechanical tools according to PN-ISO 12944-4)
- △ Old coatings must be degreased and sanded with 220-360 grid paper
- △ Aluminum, galvanized steel – should be primed with ALMA-COLOR's REACTIVE PRIMER 5+1+1 (item number 0103-202-XXX0)
- △ Properly prepared surface should be dry, free from salts, oil, grease, dust and any other contaminants.

Painting and curing conditions

- surface temperature higher than 5°C and at least 3°C higher than dew point
- relative humidity less than 90%
- good ventilation

Re-coat time:

shortest	at 20°C – 10-15 min
	at 15°C – 15-25 min
top-coating	at 20°C – 5h
	at 15°C – 8h

Given times concern a coat with recommended coat thickness that dries in good ventilation. The times may vary depending from temperature, ventilation conditions, number of coats and coat thickness.

FOLLOWING COATINGS

Acrylic coatings, polyurethane coatings (one and multiple)

Additional information

- ⚠ VOC content in ALMA-COLOR products complies to Minister of Economy Regulation from 16.02.2007 and UE Directive 2004/42/CE from 24.04.2004.

SHELF LIFE: 12 months from the production date in original unsealed container in temperature 5-35°C. 6 months for part II.

WARNING! This product is designed for professional use in the given industry. Detailed information regarding product safety can be found in the MSDS.