

Technical Data Sheet

PT-30 4:1 HS ACRYLIC PRIMER

PRODUCT DESCRIPTION

HS Acrylic Primer / Filler 4+1 a filling primer based on acrylic resins. Thanks to a high spray viscosity, the product can be applied in very thick layers that perfectly repair even relatively large scratches and irregularities of substrate. The product has a very good adhesion to various substrates and short drying time. It is easy to treatment, has excellent sanding and good filling properties - high flexibility and impact resistance which guarantees excellent appearance of top coat.


COMPONENTS

| | |
|--------|----------------------------|
| PT-30 | 2K Primer |
| HT-31 | Hardener |
| ST-10 | Acrylic Thinner (Standard) |
| XST-11 | Acrylic Thinner (Fast) |

SUBSTRATES

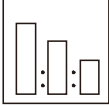

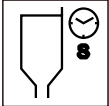


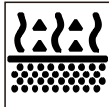
- Old paint coatings (including thermoplastic paints)
- Polyester putties
- Steel
- Aluminium
- Stainless Steel
- Wash Primers
- Epoxy Primers
- Plastics
- Polyester laminates

SURFACE PREPARATION

| | | |
|---|---------------------|--|
|  | Old paint coatings | degrease and sand dry P220 - P360 |
| | Polyester putties | finish sand dry P240 – P320 |
| | Steel surfaces | degrease, sand dry P120 - P240 |
| | Stainless steel | degrease |
| | Plastics | clean with a Silicone Remover and matt using abrasive needled cloth. Again degrease, apply Adhesion Increasing Agent and Elasticity Increasing Agent |
| | Polyester laminates | degrease and sand dry P280 |

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| MIXING RATIO | | | | | |
|---|--|--------------|--|-------------------------|--|
|  | | PT-30 | HT-31 | XST-11 ST-10 | |
| | Volume | 4 | 1 | 0.8 (15-35%) | |
| | Weight | 100g | 16g | 15-30g | |
| POT LIFE (@ 25°C) | | | | | |
|  | Mixture life after mixing primer, hardener | 30min @ 20°C | | | |
| APPLICATION VISCOSITY | | | SPRAY GUN SET UP | | |
|  | 22-30 seconds (DIN 4/20°C) | |  | Pressure | HVLP: 8-10 PSI at the air cap Compliant: 28-35 psi at the gun Please refer to gun manufacturer for proper spray pressure recommendations |
| | | | | Nozzle | 1.6 - 1.8mm or equivalent |
| VOC compliant | | | | | |
| 2004/42/IIB© (540): The EU limit value for this product category: IIB© in ready to use 540 g/l. | | | | | |
| COATS & THICKNESS | | | | | |
|  | Number of layers | | 1-3 coats | | |
| | Thickness (um) | | 40-60 microns | | |
| FLASH OFF TIME (@20°C) | | | | | |
|  | Flash off between layers | | 5-10mins | | |

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DRYING TIME



20°C

2-3 hours

60°C

20 min

READY FOR SANDING



For dry sanding
P360-P500



For wet sanding
P600-P1000

COLOUR

Grey

CLEANING EQUIPMENT

For cleaning equipment, acrylic thinner can be used or cellulose thinner. It is recommended to use thinner for cleaning paint spray guns.

HEALTH AND SAFETY REGULATIONS

See the Safety Data Sheet.

STORAGE TIME AND CONDITIONS

2 years in original sealed can at cool and dry place at 20°C. (Do not store on the floor)

| | |
|-------------------------------------|-------------------------------------|
| PT-30 Acrylic Filler | 24 months at a temperature of 20°C. |
| HT-31 Hardener | 24 months at a temperature of 20°C. |
| XST-11 ST-10 | 24 months at a temperature of 20°C. |

PACKAGING

4L

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PT-30 4:1 HS ACRYLIC PRIMER**WEIGHT OF COMPONENTS READY FOR USE**

| Component | Primer | Hardener | Thinner |
|---------------------|---------------|-----------------|-----------------------|
| Amount (RFU) | PT-30 | HT-31 | XST-11 / ST-10 |
| 100 ml | 92.4g | 15.4g | 23g |
| 200 ml | 184.8g | 30.8g | 46g |
| 300 ml | 277.2g | 46.2g | 69g |
| 400 ml | 369.6g | 61.6g | 92g |
| 500 ml | 462g | 77g | 115g |
| 1000 ml | 924g | 154g | 230g |