TECHNICAL DATA SHEET

Acrylic filling primer 4:1 HS FAST PROFESSIONAL



FAST 4:1 acrylic primer is the highest quality 2-component acrylic primer with the addition of anti-corrosive agents with excellent adhesion to steel, aluminium, galvanized steel, polyester fillers and old paint coatings.

FOR PROFESSIONAL USE!

SUBSTRATE

- old paint coats,
- polyester fillers,
- steel,
- reactive primers (wash primers),
- epoxy primers,
- plastics,
- polyester laminates.

SURFACE PREPARATION

- old paint coats should be degreased and dry sanded with P220 - P360 paper,
- polyester fillers should be dry sanded with P240 – P320 paper for final smoothing,
- steel surfaces should be degreased and dry sanded with P120 - P240,
- plastic surfaces should be wiped with Silicone Remover RANAL and matted with an abrasive cloth. Degrease again and apply Adhesion increasing agent and Elasticity increasing agent,
- polyester laminates should be degreased and dry sanded with P280.

MIXING RATIO



	By volume
Primer	4
Hardener	1
Thinner	5% - 10%

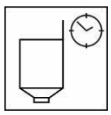
ATTENTION! Acrylic thinner RANAL is recommended.

INSTRUCTION FOR USE:

Apply two or three wet single layers with evaporation time of 5-10 minutes after each layer. Evaporation time depends on the temperature and layer thickness. 10 minutes after the application of the last layer the coat can be cured at higher temperature.

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SPRAYING VISCOSITY



DIN 4/20^{O}C app.30-50s

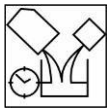
SPRAY GUN NOZZLE, WORKING PRESSURE:



Filling system:
0-5% Acrylic thinner Ranal
∅1.6÷1.8mm, 1,8÷2,2 bar
Priming system:
10% Acrylic thinner Ranal
∅1.6÷1.8mm, 1,8÷2,2 bar

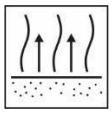
ATTENTION! Layer thickness app. 60 – 70 μm of each one.

POT LIFE ONCE MIXED WITH HARDENER



60 minutes at the temperature of 20ºC

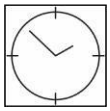
EVAPORATION TIME:



5 – 10 min.

DRYING TIME:

For the thickness of 150 – 180 μm



1h at 20ºC
10 min. at 60ºC.

For the thickness of 180 – 250 μm
1,5-2 h at 20C

SANDING:



Dry sanding: P360 – P500



Wet sanding: P600 – P1000

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CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC for the mixture = 430 [g/l]

THEORETICAL PERFORMANCE

A set (1 litre of the primer + hardener in adequate proportions) allows obtaining app. 6 m^2 of a dry film 100 μm thick.

TOOLS CLEANING

NITRO or Acrylic thinner RANAL.

STORAGE CONDITIONS

Store in a dark and dry place away from the sources of fire and heat. The shelf life in original package at 20˚C is 24 months for the primer and 24 months for the hardener .

HEALTH AND SAFETY RECOMMENDATIONS

According to Safety Data Sheet of Dangerous Substance for particular product.

Item. No 11011	Packages / l
Primer	0.8 l
+	+
Hardener	0.2 l
Set Primer+Hardener	1 l

This information is based on careful laboratory research and many years of experience. Strong market position does not absolve us from constant control of the quality of our products. However, we are not responsible for the final results after incorrect use of the product.

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