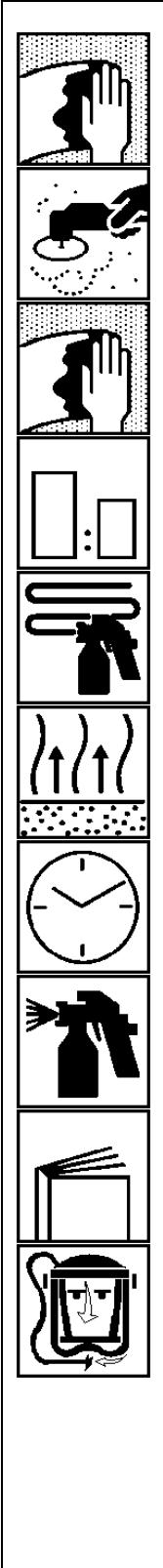


FOR PROFESSIONAL USE ONLY

| Quick Ref: | Rapid Excel Primer | | | | | |
|---|--|--|--------------------|----------|---|--------|
|  | <p>Wash with hot water and/or degrease with GreaseBuster AS Degreaser</p> <p>P180 – P280</p> <p>Degrease with GreaseBuster AS Degreaser</p> <p>10:1 Rapid Excel Primer 1K Thinner M571 T5-Standard</p> <p>2 x1 (Pressure feed) 1.0 - 1.4 mm 3 bar</p> <p>10-20 min.</p> <p>Touch dry: 30 min. 1½ hrs minimum at 20°C</p> <p>QDP 1K Topcoat P Type 1K Topcoat S2000 2K Topcoat</p> <p>CONSULT TECHNICAL DATA SHEET BEFORE USE</p> <p>Wear suitable protection</p> | <p>Description: High build, 1K fast drying anti-corrosive alkyd primer surfacer for application on various substrates. This product can be used under either 1K or 2K Topcoats. The target use for this product is refinishing and refurbish of existing vehicles and the painting of newly build commercial vehicles and trailers. The EU VOC limit for this product (product category: IIB.C) in ready to use form is max 540 g/litre. The VOC content of this product in ready to use form is max 539 g/litre</p> <p>Product and Additives: Rapid Excel Primer 1K Thinner M571 T5-Standard 1K Thinner M572 T7-Slow</p> <p>Basic Raw Materials: Rapid Excel Primer : Alkyd resin, anti-corrosive pigments and Solvents</p> <p>Suitable Substrates:</p> <ul style="list-style-type: none"> Steel Existing Finishes Polyester Bodyfillers Polyester laminates / Plywood Aluminium, pre-coated with EtchGard Primer Zinc-coated steel, pre-coated with EtchGard Primer <p>Surface Preparation:</p> <ul style="list-style-type: none"> Steel: Degrease with GreaseBuster AS Degreaser and dry sand with P180 grit. If necessary blast clean to Sa 2,5 -3 Existing finishes: Degrease with GreaseBuster AS Degreaser and dry sand with P180 -280 grit Polyester Bodyfillers: Degrease with GreaseBuster AS Degreaser and dry sand with P180-280 grit Polyester laminates / Plywood: Degrease with GreaseBuster AS Degreaser and dry sand with P280 grit or abrade with Scotch Brite Type A (Red) <p>Note: Aluminium or Zinc-coated steel: Large areas of aluminium sheet, hardened aluminium or zinc coated steel, should be suitably prepared and etch primed prior to application of Rapid Excel primer.</p> <p>Mixing ratio by volume: Conventional Spray:</p> <table border="0"> <tr> <td>Rapid Excel Primer</td> <td>10 parts</td> </tr> <tr> <td>1K Thinner M571 T5-Standard or 1K Thinner M572 T7-Slow</td> <td>1 part</td> </tr> </table> <p>Airless Spray: Rapid Excel Primer Use unthinned</p> <p>Spraying viscosity: The thixotropic nature of the material renders the product hard to measure with the use of flow cups.</p> | Rapid Excel Primer | 10 parts | 1K Thinner M571 T5-Standard or 1K Thinner M572 T7-Slow | 1 part |
| Rapid Excel Primer | 10 parts | | | | | |
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|---|-------------------|---|---------------------|-------------------|--------------------------|------------------------|-----------|--------|---------------|--------------|--|--------------|--------------|---------------------------------|---------|-------------|---------------------------------|--------|-------------|--|
| | | <p>Spray gun fluid tip and working pressure:</p> <table border="0"> <tr> <td>Spray gun:</td> <td>Fluid tip:</td> <td>Working pressure:</td> </tr> <tr> <td>HVLP/Compliant:</td> <td></td> <td></td> </tr> <tr> <td>Pressure feed</td> <td>1.0 - 1.4 mm</td> <td>± 1 bar material pressure Max. 3 bar atomisation pressure Max. 3 bar</td> </tr> <tr> <td>Suction feed</td> <td>1.8 - 2.6 mm</td> <td>140 – 160 bar (2000 – 2300 psi)</td> </tr> <tr> <td>Airless</td> <td>4.11 / 4.13</td> <td>100 – 120 bar (1450 – 1700 psi)</td> </tr> <tr> <td>Airmix</td> <td>4.11 / 4.13</td> <td></td> </tr> </table> | Spray gun: | Fluid tip: | Working pressure: | HVLP/Compliant: | | | Pressure feed | 1.0 - 1.4 mm | ± 1 bar material pressure Max. 3 bar atomisation pressure Max. 3 bar | Suction feed | 1.8 - 2.6 mm | 140 – 160 bar (2000 – 2300 psi) | Airless | 4.11 / 4.13 | 100 – 120 bar (1450 – 1700 psi) | Airmix | 4.11 / 4.13 | |
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| Airmix | 4.11 / 4.13 | | | | | | | | | | | | | | | | | | | |
| <p>Application process: To a suitably prepared surface apply one full coat of Rapid Excel Primer to give a minimum dry film of 50 microns. On blast cleaned surfaces a minimum of two coats is recommended to give a dry film of 50 microns above the peaks. Allow drying for a minimum of 1½ hours before overcoating. If more than one coat of Rapid Excel Primer is applied, allow a short flash off (10-20 mins) between coats to allow for solvent evaporation.</p> | | | | | | | | | | | | | | | | | | | | |
| <p>Film thickness:</p> <table border="0"> <tr> <td>Wet film:</td> <td>140 µm per coat</td> </tr> <tr> <td>Dry film:</td> <td>50 µm per coat</td> </tr> </table> <p>Note: Minimum dry film build 50 µm Blasted surfaces Ensure 50 µm above peaks by using two coats</p> | | | Wet film: | 140 µm per coat | Dry film: | 50 µm per coat | | | | | | | | | | | | | | |
| Wet film: | 140 µm per coat | | | | | | | | | | | | | | | | | | | |
| Dry film: | 50 µm per coat | | | | | | | | | | | | | | | | | | | |
| <p>Cover rate: 8 m² / litre at 50 µm dry film thickness.</p> <p>Note: The practical cover rate depends on many factors i.e.: shape of the object, roughness of the surface, application method and application circumstances.</p> | | | | | | | | | | | | | | | | | | | | |
| <p>Cleaning of equipment: Compliant Gunwash 1K Thinner M571 T5-Standard or 1K Thinner M572 T7-Slow</p> | | | | | | | | | | | | | | | | | | | | |
| <table border="0"> <tr> <td>Drying time:</td> <td>20°C</td> <td>40°C</td> <td>60°C</td> </tr> <tr> <td>Touch dry</td> <td>30 min</td> <td></td> <td></td> </tr> <tr> <td>Recoat after</td> <td>1½ hours</td> <td></td> <td></td> </tr> </table> | | | Drying time: | 20°C | 40°C | 60°C | Touch dry | 30 min | | | Recoat after | 1½ hours | | | | | | | | |
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| Touch dry | 30 min | | | | | | | | | | | | | | | | | | | |
| Recoat after | 1½ hours | | | | | | | | | | | | | | | | | | | |
| <p>Recoat with: QDP 1K Topcoat P Type 1K Topcoat SuperThane 2K S2000 Topcoat</p> <p>Note: If Rapid Excel Primer is flatted prior to overcoating, an extended period should be allowed for the flatted surface to “heal up” before application of subsequent coats. Failure to do this can result in lifting of crazing</p> | | | | | | | | | | | | | | | | | | | | |

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| | | <p>Packaging: 5L</p> |
| | | <p>Colour: Light Grey</p> |
| | | <p>HEALTH & SAFETY DATA concerning Rapid Excel Primer</p> <p>For professional use only (see Material Safety Data Sheet) See text on the label of this product. The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.</p> |

AkzoNobel Coatings LTD, Car Refinishes

Address: 136 Milton Park, Abingdon
Oxfordshire OX14 4SB

Tel: 00 44 (0)1235 862226

AkzoNobel CR Ireland

Address: Avonbeg Industrial Estate
Long Mile Road, Dublin 12

Tel: 00 353 (0)1450 1344

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.masonct.com

