


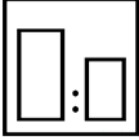

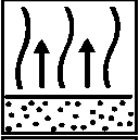



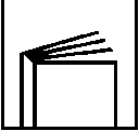


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Quick Ref:

Rapid SuperBuild Primer

| | | |
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|  | <p>Wash with hot water and/or degrease with GreaseBuster AS Degreaser</p> | <p>Description: A high-build, one-pack, fast drying anti-corrosive primer. Rapid SuperBuild Primer can be used under one or two-pack topcoats. The use of this product is targeted at the painting of newly build vehicles and trailers only.</p> |
|  | <p>P180 280</p> | <p>Product and Additives: Rapid SuperBuild Primer 1K Thinner M571 T5-Standard 1K Thinner M572 T7-Slow</p> |
|  | <p>Degrease with GreaseBuster AS Degreaser</p> | <p>Basic Raw Materials: Rapid SuperBuild Primer : Alkyd resin, anti-corrosive pigments and solvents</p> |
|  | <p>5:1 Rapid SuperBuild Primer 1K Thinner M571 T5-Standard</p> | <p>Suitable Substrates:</p> <ul style="list-style-type: none"> ▪ Steel ▪ Existing Finishes ▪ Polyester Bodyfillers ▪ Polyester laminates / Plywood ▪ Aluminum, pre-coated with EtchGard Primer ▪ Zinc-coated surfaces, pre-coated with EtchGard Primer |
|  | <p>(Pressure feed) 1-0 - 1-4 mm 3 bar</p> | <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: Aluminum and Zinc-coated surfaces: Large areas of aluminum sheet, hardened aluminum and zinc coated surfaces should be suitably prepared and etch primed prior to application of Rapid SuperBuild primer.</p> |
|  | <p>10-20 mins.</p> | <p>Mixing ratio by volume: One-pack primer: Rapid SuperBuild Primer 5 parts 1K Thinner M571 T5-Standard or 1 part 1K Thinner M572 T7-Slow</p> |
|  | <p>Touch dry 30 mins 1½ hours minimum at 20°C</p> | <p>Airless spray: Rapid SuperBuild Primer Use unthinned</p> |
|  | <p>P280 P360-P400</p> | <p>Wear suitable protection</p> |
|  | <p>QDP 1K Topcoat P Type 1K Topcoat S80 2K Topcoat S1050 2K Topcoat S2000 2K Topcoat</p> | |
|  | <p>CONSULT TECHNICAL DATA SHEET BEFORE USE</p> | |

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Mixing ratio by volume:

Note:

To increase flow the mixing ratio can be adjusted to 4:1 or 3:1 when using conventional spraying equipment. Apply a minimum dry film build of 50 microns.

Spraying viscosity:

The thixotropic nature of the material renders the product hard to measure with the use of flow cups

Spray gun fluid tip and working pressure:

| Spray gun: | Fluid tip: | Working pressure: |
|------------------------|-------------------|--|
| HVLP/Compliant: | | |
| Pressure feed | 1.0 - 1.4 mm | ± 1 bar material pressure Max. 3 bar atomization pressure |
| Suction feed | 1.8 - 2.6 mm | Max. 3 bar |
| Airless | 4.11 / 4.13 | 140 – 160 bar (2000 – 2300 psi) |
| Airmix | 4.11 / 4.13 | 100 – 120 bar (1450 – 1700 psi) |

Application Process:

To a suitably prepared surface apply one full coat of Rapid SuperBuild 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. If more than one coat of Rapid SuperBuild Primer is applied, allow a flash off (10-20 min.) between coats.

Film thickness:

| | |
|-----------|-----------------|
| Wet film: | 150 µm per coat |
| Dry film: | 50 µm per coat |

Note:

| | |
|------------------------|---|
| Minimum dry film build | 50 µm |
| Blasted surfaces | Ensure 50 µm above peaks by using two coats |

Cover rate:

6.6 m² / liter at 50 µm dry film thickness.

Note:

The practical cover rate depends on many factors i.e.: shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of equipment:

Compliant Gunwash
1K Thinner M571 T5-Standard or 1K Thinner M572 T7-Slow

Drying time:

Touch dry Recoatable
after

20°C
30 min
1½ hours

40°

60°



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| | | |
|--|--|---|
| | | <p>Recoatable with: QDP 1K Topcoat P Type 1K Topcoat SuperThane 2K S80 Topcoat SuperThane 2K S2000 Topcoat</p> <p>Note: If Rapid SuperBuild Primer is denibbed or 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 and crazing.</p> |
| | | <p>VOC: The VOC content of this product in ready to use form is max 588 g/litre.</p> |
| | | <p>Packaging: 5L, 20L can (Light Grey)</p> |
| | | <p>Colour: Buff Beige Off White Light Grey Dark Grey Red</p> |
| | | <p>HEALTH & SAFETY DATA concerning Rapid SuperBuild 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> |

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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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