



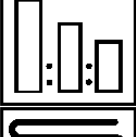
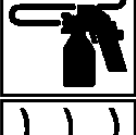
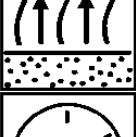
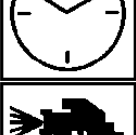

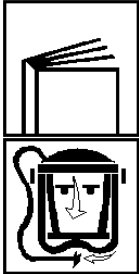


FOR PROFESSIONAL USE ONLY

Quick Ref:	SuperThane 2K HS 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>Use mixing stick</p> <p>Non sanding filler: 5:1:2 Sanding filler: 100:50:25</p> <p>2 x 1 (Suction feed) 1-6 - 2-2 mm 3-5 bar</p> <p>5-10 mins.</p> <p>Non sanding filler 40 min. at 20°C Sanding filler Overnight at 20°C</p> <p>S2000 2K Topcoat</p>	<p>Description: High-build, fast drying, 2K wet on wet and sanding filler. 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 536 g/litre.</p> <hr/> <p>Product and Additives: SuperThane 2K HS Primer SuperThane 2K HS Primer Primer Hardener H5 Standard SuperThane 2K HS Primer Primer Hardener Sanding H5 Standard SuperThane 2K HS Primer Thinner T5 Standard SuperThane 2K HS Primer Thinner T7 Slow</p> <hr/> <p>Basic Raw Materials: SuperThane 2K HS Primer : Acrylic resin SuperThane 2K HS Primer Hardeners : Poly-isocyanate resins SuperThane 2K HS Primer Thinners : Solvent blend</p> <hr/> <p>Suitable Substrates:</p> <ul style="list-style-type: none"> ▪ Existing finishes, including finishes with thermoplastic behaviour ▪ Polyester Bodyfillers ▪ Polyester laminates / Plywood ▪ Wood ▪ EtchGard Primer <hr/> <p>Surface Preparation:</p> <ul style="list-style-type: none"> ▪ 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: Degrease with GreaseBuster AS Degreaser and dry sand with P280 grit or abrade with Scotch Brite Type A (Red) ▪ Wood: Dry sand with P180 grit to achieve a smooth surface and to remove any loose fibres. ▪ EtchGard Primer: Suitably Etch primed aluminium and zinc-coated surfaces. <hr/> <p>Tinting: Up to 10% by volume with SuperThane 2K S2000 Topcoat colours. Stir the mixture well and add hardener and thinner as specified at 'Mixing ratio by Volume'.</p> <p>Superthane 2K HS Primer Dark Grey may not be tinted.</p>

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USE

Wear suitable protection

Mixing ratio by volume:

Mixture A: non sanding filler

SuperThane 2K HS Primer	5 parts
SuperThane 2K HS Primer Hardener H5 Standard	1 parts
SuperThane 2K HS Primer Thinner T5 Standard or T7 Slow	2 parts

Mixture B: sanding filler

SuperThane 2K HS Primer	100 parts
SuperThane 2K HS Primer Hardener Sanding H5 Standard	50 parts
SuperThane 2K HS Primer Thinner T5 Standard / T7 Slow	25 parts

Spraying viscosity:

Mixture A: 16-19 sec. DIN Cup 4 at 20°C
Mixture B: 16-17 sec. DIN Cup 4 at 20°C

Pot life:

Mixture A: 1½-2 hours at 20°C
Mixture B: 1 - 1½ hours at 20°C

Spray gun fluid tip and working pressure:

Spray Gun:	Fluid Tip:	Working Pressure:
Gravity feed HVLP	1.5 – 1.6 mm	max. 0.7 bar
Suction feed HVLP	1.6 – 2.2 mm	max. 0.7 bar
Airless	4.11 / 5.13	140-160 bar (2000 – 2300 psi)
Pressure feed	1.0 – 1.2 mm	3-5 bar atomisation pressure ± 1.0 bar material pressure

Application process:

Non sanding: Spray one or two single wet coats. In case of two coats, allow a flash-off time of 5-10 minutes between coats. Make sure full opacity is reached with the filler before topcoat. Final flash off before Topcoat is minimum 40 mins / 20°C for 1 coat and 50 mins / 20°C for 2 coats.

Sanding: Spray two or three single wet coats, allowing for a flash-off time of 5-10 minutes between coats (depending on temperature and film thickness applied).

Film thickness:	Wet film:	Dry film:	Minimum:
Mixture A:	50 - 65 µm (per coat)	20 - 25 µm (per coat)	20 µm
Mixture B:	50 - 60 µm (per coat)	25 - 30 µm (per coat)	75 µm

Cover rate:

Mixture A: Theoretical 9.1 m²/l ready for use mixture at 40 µm.

Mixture B: Theoretical 5,2 m² / litre at 75 µm dry film thickness

Note:

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

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	<p>Cleaning of equipment: Compliant Gunwash SuperThane 2K HS Primer Thinner T5-Standard or SuperThane 2K HS Primer Thinner T7-Slow</p>									
	<table border="0"> <tr> <td>Drying times:</td> <td>20°C</td> <td>60°C:</td> </tr> <tr> <td>Non sanding filler recoatable after ^{1,2}</td> <td>40 mins</td> <td></td> </tr> <tr> <td>Sanding filler dry to flat:</td> <td>overnight</td> <td>60 mins</td> </tr> </table> <p>Note:</p> <ol style="list-style-type: none"> If 2 coats are applied, minimum 50 mins / 20°C flash off time is required. If the maximum recoat time of 24 hours at 20° C is exceeded, SuperThane 2K HS Primer has to be dry sanded with P360-400 grit prior to overcoating with a finish. If dust ingress occurs in the SuperThane 2K HS Primer, it can be denibbed carefully with sandpaper, either after a drying time of 3 hours at 20°C or 30 minutes at 60° C 	Drying times:	20°C	60°C:	Non sanding filler recoatable after ^{1,2}	40 mins		Sanding filler dry to flat:	overnight	60 mins
Drying times:	20°C	60°C:								
Non sanding filler recoatable after ^{1,2}	40 mins									
Sanding filler dry to flat:	overnight	60 mins								
	<p>Recommended sandpaper grades:</p> <table border="0"> <tr> <td>Wet sanding</td> <td>:</td> <td>P400-600 grit followed by P800-1000 grit</td> </tr> <tr> <td>Dry sanding</td> <td>:</td> <td>P280 grit followed by P360-400 grit</td> </tr> </table> <p>Recoatable with: SuperThane 2K S2000 Topcoat</p> <p>Packaging: Beige, Dark Grey , Light Grey: 5L can Beige, Dark Grey, Light Grey, White: 3.75 L can</p> <p>Colour: Beige/ Dark Grey / Light Grey / White</p> <p>HEALTH & SAFETY DATA concerning SuperThane 2K HS 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>	Wet sanding	:	P400-600 grit followed by P800-1000 grit	Dry sanding	:	P280 grit followed by P360-400 grit			
Wet sanding	:	P400-600 grit followed by P800-1000 grit								
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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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