


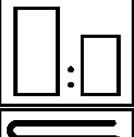
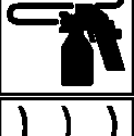
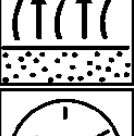
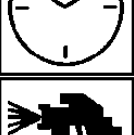
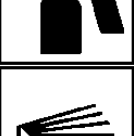




## FOR PROFESSIONAL USE ONLY

Quick Ref:	PrimeBuild Primer II	
         	<p>Wash with hot water and/or degrease with GreaseBuster AS Degreaser</p> <p>P180-280</p> <p>Degrease with GreaseBuster AS Degreaser</p> <p>1:1 PrimeBuild Primer II PrimeBuild Activator II</p> <p>2 x 1 coat (Suction feed) 1.8 – 2.2 mm (Pressure feed) 1.2 – 1.4 mm</p> <p>5-10 min.</p> <p>30 min. 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><b>Description:</b> Primebuild Primer II is a specially formulated 2K etching and passivating primer designed to provide an excellent key to ferrous and non-ferrous substrates including aluminium and galvanised surfaces. 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 780 VOC g/litre. The VOC content of this product in ready to use form is max 750 g/litre.</p> <p><b>Product and Additives:</b> PrimeBuild Primer II PrimeBuild Activator II</p> <p><b>Basic Raw Materials:</b> PrimeBuild Primer II : Resin, solvents and anti-corrosive pigments PrimeBuild Activator II : Phosphoric acid</p> <p><b>Suitable Substrates:</b></p> <ul style="list-style-type: none"> <li>▪ Steel</li> <li>▪ Aluminium</li> <li>▪ Zinc-coated surfaces</li> <li>▪ Stainless steel</li> <li>▪ Polyester Laminates / Plywood</li> <li>▪ Existing Finishes</li> </ul> <p><b>Surface preparation:</b></p> <ul style="list-style-type: none"> <li>▪ <b>Steel:</b> Degrease with GreaseBuster AS Degreaser and dry sand with P180-P280 grit. If necessary, blast clean to Sa 2,5 – 3</li> <li>▪ <b>Zinc-coated steel, Aluminium and Stainless steel:</b> Degrease with GreaseBuster AS Degreaser and abrade with Scotch Brite Type A (Red).</li> <li>▪ <b>Polyester Laminates / Plywood:</b> Degrease with GreaseBuster AS Degreaser and abrade with Scotchbrite Type A (Red).</li> <li>▪ <b>Existing Finishes:</b> Degrease with GreaseBuster AS Degreaser and dry sand with P280-P360.</li> </ul> <p><b>Mixing ratio by volume:</b> PrimeBuild Primer II : 1 part PrimeBuild Activator II : 1 part</p> <p><b>Spraying viscosity:</b> 19-21 sec. DIN 4 Cup at 20°C</p> <p><b>Pot life:</b> After the components have been mixed, the pot life is 5 days at 20°C if mixture is in a plastic container.</p>

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		<p><b>HVLP / Compliant:</b></p> <p>Gravity feed Suction feed Airless spray Pressure feed</p>	<p><b>Fluid Tip</b></p> <p>1.6 – 1.8 mm 1.8 – 2.2 mm 4.11 / 5.13 1.2 – 1.4 mm</p>	<p><b>Working pressure:</b></p> <p>Max. 3-5 bar Max. 3-5 bar 140-160 bar (2000 – 2300 psi) 3-5 bar atomisation pressure 1.0 bar material pressure</p>								
		<p><b>Application process:</b> Apply 2 full wet coats with a flash-off time of 5 - 10 minutes between coats.</p> <p><b>Note:</b> 1. The maximum time for PrimeBuild II Primer to recoat with filler / topcoat is 24 hours. 2. PrimeBuild Primer II can be exposed in the open for up to three months, when a minimum film build of 25 µm is applied. Cleaning and application of a fresh layer of the washprimer is necessary prior to the application of the filler/ topcoat.</p>										
		<p><b>Film thickness:</b> Dry film: 25-30 µm (2 coats)</p> <p><b>Note:</b> Minimum dry film build 25 µm</p>										
		<p><b>Cover rate:</b> 4,1 m<sup>2</sup> / litre at 25 µm dry film thickness</p> <p><b>NOTE:</b> The practical cover rate depends on many factors ie: shape of the object, roughness of the surface, application method and application circumstances.</p>										
		<p><b>Cleaning of equipment:</b> Compliant Gunwash SuperThane 2K Primer Thinner T5-Standard or SuperThane 2K Primer Thinner T7-Slow</p>										
		<p><b>Drying time:</b></p> <table border="0"> <tr> <td></td> <td><b>20°C</b></td> <td><b>40°C</b></td> <td><b>60°C</b></td> </tr> <tr> <td>Recoat after:</td> <td>30 min.</td> <td></td> <td></td> </tr> </table>				<b>20°C</b>	<b>40°C</b>	<b>60°C</b>	Recoat after:	30 min.		
			<b>20°C</b>	<b>40°C</b>	<b>60°C</b>							
		Recoat after:	30 min.									
<p><b>Recoat with:</b> QDP 1K Topcoat P Type 1K Topcoat SuperThane 2K S2000 Topcoat</p>												
<p><b>Packaging:</b> 5L can</p>												

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		<p><b>Colour:</b> Beige</p>
		<p><b>HEALTH &amp; SAFETY DATA concerning PrimeBuild Primer</b></p> <p>For professional use only (see <b>Material Safety Data Sheet</b>) 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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