


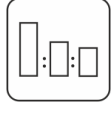

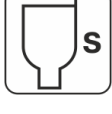





TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>RAPID HS 4:1 ACRYLIC PRIMER</p>	
<p>PRODUCTS</p> <p>RAPID HS 4:1 - Fast Acrylic Filler Hardener RAPID HS 1:4 for Acrylic Filler Thinner for acrylic systems</p>	
<p>PRODUCT DESCRIPTION</p> <p>High quality 2K fast-drying acrylic primer with added anti-corrosive agents, designed for automotive body repairs. The primer features high solids content, excellent filling properties and very short curing time - ready for sanding just 1 hour after application (at 20°C). Additionally, it offers excellent adhesion to difficult substrates and easy application.</p> <ul style="list-style-type: none"> • Very short curing time (1h/20°C after application). • Excellent filling properties. • Excellent adhesion to difficult substrates. • Anti-corrosive properties. • Easy application. 	<p>COLOUR: white,, grey, black</p> <p>GLOSS GRADE: matt</p>

<p>VOLATILE ORGANIC COMPOUNDS</p> <p>VOC for mixture = 420 [g/l] This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l.</p>	
<p>SURFACE PREPARATION</p> <p>Acrylic Primer RAPID HS 4:1 can be applied over:</p> <ul style="list-style-type: none"> • Steel and aluminum after flatting and degreasing. • Zinc coated steel after flatting and degreasing. • Sanded polyester-glass laminates (GFK/GRP). • Polyester putties. • Epoxy primers. • Wash primers. • Old finishes in good condition after flatting and degreasing. 	
<p>Good preparation is necessary for achieving best results.</p> <p>Following sandpaper gradations are recommended:</p> <ul style="list-style-type: none"> • Sanding by hand (dry or wet): P280÷P320 (GRP P400). • Sanding by machine (dry): P180÷P220. 	

APPLICATION PROCESS									
	<p>USE</p> <p>Filling acrylic primer designed for car body repairs</p>		<p>NUMBER OF LAYERS</p> <p>2÷3 layers. Approx. 70÷90 µm for one layer.</p> <p>Gun parameters: RP nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.</p>						
	<p>MIXING RATIO by volume</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>Primer</td> <td style="text-align: center;">4</td> </tr> <tr> <td>Hardener</td> <td style="text-align: center;">1</td> </tr> <tr> <td>Thinner</td> <td style="text-align: center;">0÷5%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>	Primer	4	Hardener	1	Thinner	0÷5%		<p>HARDENING TIME</p> <p>For thickness of 150÷180 µm:</p> <ul style="list-style-type: none"> • at 20°C: approx. 1 h. • at 60°C: approx. 10 minutes. <p>For thickness of 180÷250 µm:</p> <ul style="list-style-type: none"> • at 20°C: approx. 2 h. <p>Temperature below 20°C significantly increases the hardening time.</p>
Primer	4								
Hardener	1								
Thinner	0÷5%								
	<p>SPRAYING VISCOSITY</p> <p>30÷50 seconds at 20°C/DIN4.</p>		<p>IR DRYING</p> <p>10÷15 minutes of short waves for the thickness of 150÷250 µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.</p>						
	<p>POT LIFE</p> <p>Approx. 65 minutes at 20°C.</p>		<p>DRY SANDING</p> <p>Machine sanding: P360÷P500. Hand sanding: P280÷P320.</p>						

	EVAPORATION TIME Between layers: 5÷10 minutes Before baking: approx. 10 minutes Evaporation time depends on the temperature and the number of layers.		WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.

FURTHER WORK 2K acrylic fillers can be directly over coated with: <ul style="list-style-type: none"> • 2K acrylic topcoats. • 1K base coats.
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GENERAL NOTES <ul style="list-style-type: none"> • Do not exceed recommended doses of the hardener! • The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar. • When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system. • The rooms should be well ventilated. • Clean the guns and equipment immediately after use. <p>Caution: <i>To maintain safety, always follow the instructions given in the MSDS for the products.</i></p>

STORAGE Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight. Note: 1. <i>After each use the container with product should be immediately closed!</i> 2. <i>Protect the hardener from frost and dampness!</i>

WARRANTY PERIOD RAPID HS 4:1 - Fast Acrylic Filler – 12 months from the date of production Hardener RAPID HS 1:4 for Acrylic Filler – 12 months from the date of production Thinner for acrylic systems – 12 months from the date of production

PRODUCT	ART. No.
RAPID HS 4:1 - Fast Acrylic Filler	(0,8l + 0,2l) : 16512; 16513; 16514 (3,6l) : 16516, 16517, 16518
Hardener RAPID HS 1:4 for Acrylic Filler	(0,9l) : 16522
Thinner for acrylic systems	300002258; 300002260 (1l; 5l)
Thinner for acrylic systems - slow	14712 (5l)
Thinner for acrylic systems - fast	14713 (5l)

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