

131S

27.08.2014

FILL'N'SAND 1K ACRYLIC PRIMER

DESCRIPTION

1K primer.
Colour: grey.
Composition based on modified acrylic resin.

PRODUCTS

| | |
|-------|-------------------------------|
| 131S | Fill'n'Sand 1K Acrylic Primer |
| 3608S | Thinner |
| 3642S | 1K Multi-purpose Thinner |
| 3989S | Retarder |

PROPERTIES

- Very fast drying.
- Very easy sandability.
- Good filling properties and good adhesion.
- Can be tinted up to 10 % maximum with AM Centari® MasterTints®.
- Ideal spot and panel repair primer
- Recommended to repair thermoplastic acrylic finishes

SUBSTRATES










- OEM finishes, including thermoplastic acrylic finishes
- Cured repaired finishes
- Axalta wash primers

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PRODUCT PREPARATION

| | | | | | | |
|--|--------------------------------|---|--------------------|---------------------|------------------------|--------|
|   | Mixing Ratio | 131S 3642S / 3608S (fast) | Maxi | | Primer Surfacer | |
| | | | Volume | Weight | Volume | Weight |
| | | | 1 | 100 | 1 | 100 |
| | | | 0.8 | 50 | 1.2 | 70 |
| | VOC | 656-687 g/l | | | | |
|  | Pot life at 20°C | Not applicable | | | | |
|  | Spray viscosity at 20°C | DIN 4 | 25 – 28 s | | 16 s | |
| | | FORD 4 | 28 – 30 s | | 18 s | |
|  | Spray equipment | Gravity feed Suction feed HVLP Pressure feed | Fluid Tip | | Distance | |
| | | | Maxi | Primer/Surf. | | |
| | | | 1.6-1.8 mm | 1.2-1.4 mm | 15-20 cm | |
| | | | - | 1.5-1.8 mm | 15-20 cm | |
| | | | 1.8 mm | 1.4-1.6 mm | 15 cm | |
| | | | 1.4 mm | 1.2 mm | 20-25 cm | |
|  | Spray pressure | Gravity feed Suction feed HVLP Pressure feed | Spot repair | | Panel repair | |
| | | | | | | |
| | | | 2-2.5 bar | 2.5-3 bar | | |
| | | | 2-2.5 bar | 2.5-3 bar | | |
| | | | 0.7 bar at nozzle | 0.7 bar at nozzle | | |
| | | | 3 bar | 3 bar | | |
|  | Number of coats | | 1 - 3 | | 1 - 2 | |
|  | Flash time | Between coats till flat | | | | |
| | DFT | | 35 – 100 µm | | 25 – 50 µm | |
|  | Dry to sand at 20°C | | 2 h | | 30 – 45 min | |
| This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use. | | | | | | |

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SURFACE PREPARATION

OEM and cured repaired finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with correct preparatory cleaner. Wipe dry using clean Sontara® wipes
3. Wet sand with P600 or dry sand with P280 - P320.
4. Clean with a correct final cleaner using clean Sontara® wipes
5. Before priming, wipe dry using clean Sontara® wipes

Treat bare metal spots with 1 coat 825R (see specific TDS).

EQUIPMENT CLEANNING

Use a correct solventborne gunwash.

RECOATABILITY

At any time after dry to sand.

REMARKS

- Reduced 131S will settle out over time (1 day). It always has to be mixed thoroughly prior to re-use.
- If temperature is above 25°C, replace maximum 5 % of standard thinner by 3989S.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package Viscosity: 2000 – 2500 cp
Theoretical Coverage: 2 -9 m²/L at recommended DFT – ready-to-spray

Directive 2004/42/EC: 2004/42/IIB(e) (840)695: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 695 g/l.

SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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