

4004S

27.08.2014

ULTRA PRODUCTIVE PRIMER

DESCRIPTION

2-component primer surfacer with very fast drying for spot and panel repair..
Colour: medium grey.
Composition based on functional acrylic copolymer. Non-isocyanate primer.

PRODUCTS

4004S	Ultra Productive Primer - medium grey
4075S	Activator
XB387	HI-Temp Thinner

PROPERTIES

- High productive primer: easy wet and dry sandability after 1 hr air dry, very short flash time between coats..
- Requires no wash primer on sand throughs to steel or zinc.
- Excellent filling properties and perfect sagging resistance.
- High solids technology: same build with fewer coats, resulting in less consumption.
- Superior topcoat hold-out.
- Can be coated with all Cromax topcoats.

SUBSTRATES










- Bare steel and zinc on sand throughs.
- OEM finishes.
- Cured repair finishes.
- Polyester putties.
- Cromax wash primers: 825R, 840R.

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PRODUCT PREPARATION

	Mixing ratio	4004S	Volume	Weight
		4075S	4	100
	Mixing ratio At temp. >30°C	4004S	1	15
		4075S	4	100
		XB387	1	15
			0.25	4
	VOC (RFU)	538 g/l		
	Pot life at 20°C	45 min		
	Spray viscosity at 20°C	DIN 4 FORD 4	19 – 23 s 19 – 23 s	
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip	Distance
			1.4 – 1.8 mm	20 – 25 cm
			1.4 – 1.8 mm	20 – 25 cm
			1.2 – 1.4 mm	15 cm
			1.2 – 1.4 mm	20 – 25 cm
	Spray pressure	Gravity feed Suction feed HVLP Pressure feed	3 - 3.5 bar 3 - 3.5 bar 0.7 bar at nozzle 4 - 6 bar	
	Number of coats	2		
	Flash time	Between coats till flat 10 min before bake		
	DFT	30 - 50 µm/coat		
	Drying	Dry to sand at 15°C at 20°C at 40°C at 60°C	1 h 30 min 1 h 30 min 20 min	
	IR Drying *	Distance Half power Full power	80 cm 2 min 4 min	* Guideline for short/medium wave IR equipment

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 3919S. Wipe dry using clean Sontara® wipes.
3. Sand:
 - dry: start with P220, finish with P280;
 - wet: start with P360, finish with P500.
 - Clean surface with 3920S using clean Sontara® wipes.
 - No wash primer required on steel or zinc.

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with 3608S.
2. Sand and eliminate all rust or corrosion.
3. Clean with 3920S using clean Sontara® wipes.
4. Before priming, wipe dry using clean Sontara® wipes.
5. Apply 1 coat of 825R or 840R (see specific TDS) and proceed with 4004S application

PRIMER APPLICATION

Apply 2 coats and flash till flat between coats.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

PRODUCT DATA

Package viscosity: 1475 cp
Theoretical coverage: 4 - 8 m²/l at recommended DFT - ready-to-spray

SAFETY

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

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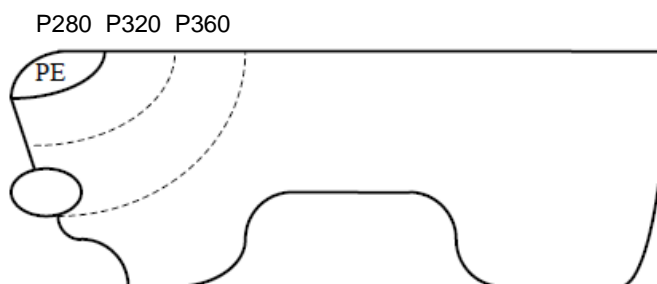
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REMARKS

- Do not use activated 4004S beyond the pot life nor reduce it further to get viscosity down again.
- If 4004S is applied over thermoplastic acrylic finishes, complete panel or overall car has to be primed. Spot priming, or sand throughs of the primer can result in spot marking or lifting, when applying basecoat.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of 4075S tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

REPAIR SYSTEMS

Preparation method for spot repair:



1. Sand through, end with P280.
2. Fill the spot with polyester putty and sand with P280.
3. Sand the surrounding area with P320 and finish on the OEM finish with P360.
4. Apply 1 coat of 825R or 840R over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1st coat of primer surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of primer surfacer, staying inside the 1st-coat area. Flash till flat.

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