

## K513

27.08.2014

### TRANSLUCENT SEALER

#### DESCRIPTION

2K polyurethane non-sanding isolating primer.  
Composition based on hydroxylated acrylic copolymers.

#### PRODUCTS

|       |                          |
|-------|--------------------------|
| K513  | Translucent Sealer       |
| 125S  | 2K Standard Activator    |
| 255MS | Universal Fast Activator |
| AB380 | Basecoat Thinner         |
| XB383 | Standard Thinner         |

#### PROPERTIES

- Excellent isolation and good filling.
- Can be used as:
  - non-sanding primer sealer;
  - tintable non-sanding primer sealer.

#### SUBSTRATES









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

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### PRODUCT PREPARATION

|                                                                                                                                                                                                                                                                          |                                |                                                                                   |                                                                |                                                 |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|-----------------------------------------------------------------------------------|----------------------------------------------------------------|-------------------------------------------------|
| <br>                                                                                                   | <b>Mixing ratio</b>            | K513<br>125S / 255MS<br>AB380 / AB385                                             | <b>Volume</b>                                                  | <b>High Temp.</b>                               |
|                                                                                                                                                                                                                                                                          |                                |                                                                                   | 2<br>1<br>1                                                    | 100<br>41<br>38                                 |
|                                                                                                                                                                                                                                                                          | <b>VOC</b>                     | 618 - 625 g/l                                                                     |                                                                |                                                 |
|                                                                                                                                                                                         | <b>Pot life at 20°C</b>        | 2 h 30 min                                                                        |                                                                |                                                 |
|                                                                                                                                                                                        | <b>Spray viscosity at 20°C</b> | <b>DIN 4</b><br><b>FORD 4</b>                                                     | 16 s<br>16 s                                                   |                                                 |
|                                                                                                                                                                                       | <b>Spray equipment</b>         | <b>Gravity feed</b><br><b>Suction feed</b><br><b>HVLP</b><br><b>Pressure feed</b> | <b>Fluid tip</b>                                               | <b>Distance</b>                                 |
|                                                                                                                                                                                                                                                                          |                                |                                                                                   | 1.4 – 1.6 mm<br>1.6 – 1.8 mm<br>1.2 – 1.4 mm<br>1.2 mm         | 15 - 25 cm<br>15 - 25 cm<br>15 cm<br>15 - 25 cm |
|                                                                                                                                                                                       | <b>Spray pressure</b>          | <b>Gravity feed</b><br><b>Suction feed</b><br><b>HVLP</b><br><b>Pressure feed</b> | 3.5 – 4 bar<br>3.5 – 4 bar<br>0.7 bar at nozzle<br>3.5 - 4 bar |                                                 |
|                                                                                                                                                                                       | <b>Number of coats</b>         | 1 - 2                                                                             |                                                                |                                                 |
|                                                                                                                                                                                       | <b>Flash time at 20°C</b>      | Till flat between coats<br>30 min before topcoating                               |                                                                |                                                 |
|                                                                                                                                                                                                                                                                          | <b>DFT</b>                     | 20 – 25 µm                                                                        |                                                                |                                                 |
| 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 repair finishes

- Clean surface with water and soap. Rinse and dry.
  - Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
  - Wet sand with P600 - P800.  
Dry sand with P280 - P320.  
Clean with 3920S using clean Sontara® wipes.  
Before priming, wipe dry using clean Sontara® wipes.
- Treat bare metal spots with 1 coat 825R (see specific TDS).

#### RECOATABILITY

At any time after 30 min at 20°C till maximum 8 hr.

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

#### REMARKS

- K513 is tintable with the AM Centari® MasterTints® up to maximum 10 %.
- Do not use activated K513 beyond the pot life nor reduce it further to get viscosity down again.
- Activated material should not be returned to original can of non-activated material.
- Close can of 125S/255MS tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

#### PRODUCT DATA

Package viscosity: 896 cp  
Theoretical coverage: 5.6 – 9.4 m<sup>2</sup>/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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All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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