# Technical Data Sheet Primers Surfacer

# LUXOL 2K PRIMER SURFACER



FOR PROFESSIONAL USE ONLY

# **Description:**

Quick drying, Two-pack, Chromate-free PU Primer Surfacer for BUS BODY, CHASSIS, etc. Developed for new work and repairs. It is easy to apply, sand and offers good Film built and Excellent Gloss hold out.

#### **Product and Additives:**

2K PU Primers Surfacer
2K PU Primer Surfacer Hardener
Plus Reducer/Thinner – Fast Thinner up to 25 deg C,
Slow Thinner above 25 deg C

#### **Basic Raw Materials:**

Base paint: Acrylic resins

Hardener: Aliphatic Isocyanide resins

Colour : Cream Finish: Semi Glossy (30-40 at 60 deg gloss head.)

#### Suitable Substrates:

- ✓ Aluminium surfaces
- ✓ Mild Steel surfaces
- ✓ Zinc-coated Galvanised surfaces
- ✓ FRP laminates

# **Surface Preparation:**

Aluminium Surface & Galvanised steel surface: Degrease and Dry sand with P220-P300. Then clean with solvent. Aluminium and galvanised steel must be etch primed before applying.

Bare Mild Steel: Degrease and Dry sand with P220-P300. Then clean with solvent.

FRP : Degrease and Dry sand with P220-P300. Then clean with solvent.

# **Application Process:**

To be applied over Luxol 2K Epoxy primer after minimum 8 hours maturation with dry sanding (P220- P300) / wet sanding (P 400-P 600).

Apply 2-3 single coats, allowing a flash -off time of 5 -10 minutes between coats.

# **Dry Film Thickness:**

Recommended D.F.T - 25-35 micron. D.F.T Build per coat- 12 micron

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PROCESS	
PAINTING AFTER	Luxol 2K Epoxy Primer
DRY SANDING	DRY SANDING WITH EMERY P220-P320
WET SANDING	WET SANDING WITH EMERY P400-P600
MIXING RATIO	BASE : HARDENER : THINNER :: 5 :1 : 50 % VOLUME BY VOLUME
MIXING	MIXING OF BASE, HARDENER & THINNER WITH MIXING ROD
APPL VISC	APPLICATION VISCOSITY – 16-19 SECONDS B4FC AT 30 DEG C
GUN P	GUN PRESSURE: 3-5 BAR (CONVENTIONAL) 2 BAR (HVLP)
FLASH OFF	APPLY 2-3 COATS, ALLOWING A FLASH OFF TIME OF 5 TO 10 MINUTES BETWEEN COATS
DRYING TIME	Air Drying At 30 Deg C Dust Free: 15 Mins Tack Free: 45 Mins Hard Dry: 8 Hours Baking Temp: 70 -80 Deg C EMT / 30 Mins
POT LIFE	MINIMUM 4 HOURS
RECOATS	Luxol 2K PU primer Surfacer can be recoated with Luxol 2K PU Topcoat system. 2K PU Primer Surafcer must be Flatted (Sanded) before recoat.
TESTING	All Testing must be done after 72 -96 Hours of Maturation

# Material usage:

Taking into account a transfer efficiency of 100%, the theoretical material usage (Coverage) for 30 micron D.F.T is 15.6 m<sup>2</sup>/l ready to spray mixture thinned paint.

Note: The practical material usage depends on many factors i.e. shape of the object, temperature, roughness of the surface, application method and application circumstances.

# Cleanliness of the Equipment:

With Luxol 2K PU Thinner.

# Shelf life:

Luxol 2K PU Primer Surfacer - 1 year Hardener for Luxol 2K PU Primer Surfacer - 1year

# Packaging: 4 lts/1lt pack

HEALTH & SAFETY DATA concerning Luxol 2K PU Primer Surfacer and Hardener: For professional use only.(See Material Safety Data Sheet).