



Art.-No.:6.4370.1000

4370

1K-WB Primer

Characteristics

This 1K waterborne primer-surfacer is designed for automotive finishes. Recoatable with all common solvent-borne and water-borne 1K and 2K finishing paints. Fast drying and easy to sand. Can be used as insulating groundcoat for thermoplastic old coatings. High anti-corrosive protection. Adhesivity to iron, steel, aluminium, galvanized substrates and plastic. According to regulations on VOC.

Consumption: 6 - 8 m² / liter (approx. 50 mm dry coat thickness)

V.O.C. Value

EC limiting value for product (cat. B/c): 250 g/l (2007)

This product contains max. 1 g/l VOC [0.008 lbs/gal]

Tech Tip

First coat very thin second coat normal. Use a drying comb then it will be dry within 30 sec. After one minute it can be sanded with P800, then ready for painting.

Be used as wet on wet for new parts.

Application

Process conditions:

From +10°C and up to 75% relative air humidity. The product should only be used in well ventilated rooms.

Recommendation for end-use:

A noticeable acceleration of the drying time is achieved by increasing the air speed and by lower relative air humidity. Over 50 % reduction in drying time by using air blowers. Store protected against frost. During the operation, keep the spray gun cup closed to avoid the hardening. Deep the spray gun nozzle in water after use.

Optimal process conditions:

Air temperature: 20 - 25°C; object temperature > 15°C; rel. air humidity: 40 - 60 %, air speed: > 0,3 m/s

HVLP:

pressure: 2- 2,5 bar / nozzle: 1,4 – 1,7 / operations: 2 (thin first, then normal)

High pressure:

pressure: 2- 2,3 bar / nozzle: 1,4 / operations: 2 (thin first, then normal)

Technical Data

Colour	dark-grey (approx. RAL 7011)
Dilution	5 – 7% 0660 demineralised water



Spraying viscosity 20° C	35 - 40 s 4 mm DIN
Coat thickness / dry film	50 - 70 µm
Curing time / Flash off time	1 - 5 min. between the spraying operations (surface)

Storage and Transportation

Keep dry an frost-protected. In tightly closed original containers at least 12 months shelf life.