684 PRM-PUR 2K HS Primer Filler

Resin base: 2-component PU resin



Products	needed:
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Converter GK14-2370
Converter/Pastes tintable with max. 5% GJ50- pastes
Hardener SC29-0863 Normal
SC29-0823 Normal
SC27-0500 Fast
Thinner SV13-0732 Fast
SV13-0701 Normal
SV15-0339 Slow

Application and properties:

2K HS Primer Filler

- suitable for use as high-build primer (up to 120 μm)
- colour shade ~RAL7035
- flame-retardant according to IMO Res. MSC.307(88) (FTP code 2010), Annex 1, part 5. The surface material with low flame-spread characteristics does not apply to pipes, pipe coverings or cables

Substrates/Pre-treatment: Well-cured old paintwork Bare steel Galvanised steel Aluminium Plastics (pls. see 3.13)

Cleaning	Sanding	Final cleaning
SV20-0505	P240-360	SV20-0505
SV22-0500	P80-150	SV22-0500
SV22-0500	abrasive pad	SV22-0500
SV22-0500	P150-180	SV22-0500
SV20-0530	abrasive pad	SV20-0530

Can be overcoated with:

TPC-ACR, TPC-PUR, TPC-EPX, TPC-AKD, BCT-MPS

Product details:

For airless application, we recommend using hardener SC29-0823. Remove corrosion (e.g., rust) by fine sanding or blasting before applying the product. Adhesion depends on Aluminium alloy, pls. check before.

Special Remark:

2004/42/IIB(cII)(540)500 The EU limit value for this product (product category: c II) in ready to use form is max. 540 g/l. The VOC content of this product is 500 g/l. It cannot be ruled out that this product contains particles $< 0.1 \ \mu m$

The products are suitable for professional use only.

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Germany

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Technical Information 5.3.19

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Resin base: 2-component PU resin



Application: 2C Primer Filler

Remarks: Values reg. VOC, coverage, solid content and viscosity are based on a mixing ratio by Vol. mit SC29-0823. Select thinner acc. ambient temperature and size of object to be painted.

	Paint system	684 PRM-PUR 2K HS Primer Filler						
	VOC	Theor. Coverage at 1 µm			Solid Content			
	<540 g/l	342 m²/kg		506 m²/L	70 % Gew.			
	Mixing ratio	684 PRM-PUR	100 % by weight		7 Vol.	10 Vol.		
	Hardener	SC29-0863 SC27-0500	10 % by weight	-	1 Vol.	-		
		SC29-0823	-	7 % by weight	-	1 Vol.		
	Thinner	SV13-0732 SV13-0701 SV15-0339	20 % by weight	15 % by weight	20 % Gew.	15 % Gew.		
S	Viscosity at 2	23°C DIN 4	Film Thickness (DFT)		Potlife 20°C	Gloss at 60°		
	7:1+20% Vol. 20-25 10:1+15% Vol. 30-4		~80 µm (2 coats) flash off 5-10 min. between		2-3 h	matt		
	Application		Viscosity (sec)	Mixing ratio	Spraying Pressure (bar)	Nozzle (mm)		
***	Compliant Gun		20-25	7:1+20%	<2.5	1.6-1.8		
**	HVLP		20-25	7:1+20%	2-3	1.6-1.9		
****	Suction Cup		20-25	7:1+20%	3-4	1.6-1.9		
	Airless / Airmix		30-40	10:1+15% (SC29-0823)	80-180	0.28-0.38		
	Double Diaphragm or Pressure Pump		-	-	-			
	Brush & Roll	Brush & Roll without thinner						
	Drying at Object Temp.		dust-dry	Flash Off (wet-on-wet)	Touch Dry	Recoatable		
	20°C		1 h	1 h	4 h	max. 72 h		
	60°C		-	-	-	-		

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