
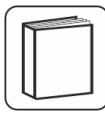

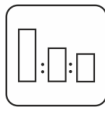



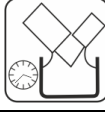

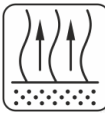



TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

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| <p>V2018 2K Urethane Primer HS 4:1</p> |  |
| <p>PRODUCTS</p> <p>Fast Acrylic Filler HS 4:1 V2018 Hardener 1:4 for Fast Acrylic Filler V2018. Thinner for acrylic systems.</p> | |
| <p>PRODUCT DESCRIPTION</p> <p>The highest quality 2K acrylic primer with excellent adhesion to steel, aluminum, galvanized steel, polyester putties and old finishes. Destined for automotive repair.</p> <ul style="list-style-type: none"> • Excellent adhesion to difficult surfaces. • Short time drying • Easy to mix and apply. • Exceptional vertical stability. • Good filling properties. | <p>COLOURS: White, Light Grey, Black. GLOSS GRADE: Matt.</p> |

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| VOLATILE ORGANIC COMPOUNDS | |
| VOC = 2.1 lb/gal | |
| SURFACE PREPARATION | |
| <p>Acrylic Primer V2018 can be applied over:</p> <ul style="list-style-type: none"> • Steel and aluminum after flattening and degreased. • Galvanized steel after flattening and degreased. • Sanded polyester glass laminates (GFK/GRP). • 2K polyester putties, polyester spraying fillers. • Wash primers. • 2K acrylic primers. • 2K epoxy primers. • Old finishes in good condition after sanding and degreasing. | <p>Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended:</p> <ul style="list-style-type: none"> • by hand (dry or wet): P280÷P320 (GRP P400), • by machine (dry): P180÷P220. |

| APPLICATION PROCESS | | | |
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|  | APPLICATION |  | NUMBER OF LAYERS |
| | For car repairs as a filling primer. | | 2÷3 layers. Approximately 70÷90µm for one layer. Gun parameters: RP nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars. |
|  | MIXING RATIO |  | HARDENING TIME |
| | by volume Primer 4 parts Hardener 1 part Thinner 5÷10% | | Curing time for thick layer 150÷180 µm Approx 1hour in 20°C. Approx 10min in 60°C Curing time for thick layer 180÷250 µm Approx 2÷3 hours in 20°C. Temperature below 20°C significantly increases the hardening time. |
|  | SPRAYING VISCOSITY |  | IR DRYING |
| | 30÷40 seconds at 20°C (68°F)/DIN4. | | 150÷180 µm: 10÷15 minutes under short wave. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying. |
|  | POT LIFE |  | DRY SANDING |
| | Approx. 65 minutes at 20°C (68°F). | | Grinding Machine: P360÷P500. Hand Sanding: P280÷P320. |
|  | EVAPORATION TIME |  | WET SANDING |
| | Between layers: 5÷10 minutes Before baking: approx. 10 minutes | | Hand Sanding: P800÷P1000. Grinding Machine: P600÷P1000. |

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| | film thickness. | | |
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FURTHER WORK

V2018 2 2K acrylic filler can be directly over coated with:

- 2-pack acrylic topcoats.
- 1-pack basecoats.

GENERAL NOTES

- Do not exceed recommended doses of hardener!
- The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- Clean the guns and equipment immediately after use.
- The rooms should be well ventilated.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

1. Close the container after use.
2. Protect the hardener from frost and dampness.

Note: *After each use the container with products shall be immediately closed! Protect hardener against freeze and humidity!*

WARRANTY PERIOD

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| Fast Acrylic Primer HS 4:1 V2018 | – 12 months from the date of production |
| Hardener 1:4 for Fast Acrylic Primer V2018 | – 12 months from the date of production |
| Thinner for acrylic systems | – 12 months from the date of production |

| PRODUCT | ART. No. |
|--|------------------------------------|
| Fast Acrylic Primer HS 4:1 V2018 | 15603; 15604; 15605 |
| Hardener 1:4 for Fast Acrylic Primer V2018 | 15606 |
| Thinner for acrylic systems | 8562; 8561; 7868; 8557; 2289; 9235 |

LIMITATION OF LIABILITY

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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