

## Technical Data Sheet PT30 MULTIPRIMER 4+1 HS Acrylic Primer

### PRODUCT DESCRIPTION

MULTIPRIMER HS 4+1 Acrylic Primer ( Acylfiller ) is a filling primer based on acrylic resins. Due to the high spray viscosity, the product can be applied in very thick layers that perfectly repair even relatively large scratches and irregularities of the substrate. The primer has very good adhesion to various substrates and a short drying time. It is easy to use and has good high build and excellent sanding capabilities. Flexibility and impact resistance guarantees an excellent finish of the repair. Thanks to high-quality components and special additives, it provides anticorrosion and fast-drying properties. This primer can also be used in a wet-on-wet application.

### COMPONENTS

PT-30	2K Primer
HT-31	Hardener
ST-10	Acrylic Thinner (Standard)
ST-11	Acrylic Thinner (Slow)

### SUBSTRATES

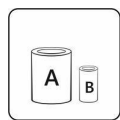
- Old paint coatings (including thermoplastic paints)	- Aluminium
- Polyester putties and laminates	- Wash Primers
- Steel	- Epoxy Primers
- Stainless Steel	- Plastics

### SURFACE PREPARATION



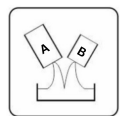
Old paint coatings	Degrease and sand dry P220 - P360
Polyester putties	Finish sand dry P240 - P320
Steel	Degrease and sand dry P120 - P240
Stainless steel	Degrease
Plastics	Clean with a Silicone Remover and matt using an abrasive needled cloth. Again degrease, apply Adhesion Increasing Agent and Elasticity Increasing Agent.
Polyester laminates	Degrease and sand dry P280

### MIXING RATIO



	PT-30	HT-31	ST-10 / ST-11
Volume	4	1	0.8 (15-25%)
Weight	100g	16g	15-25g

### POT LIFE

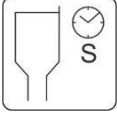



Mixture life after mixing primer with hardener	30min @ 20°C
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### APPLICATION VISCOSITY

### SPRAY GUN SET UP


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	22-30 seconds (DIN 4/20°C)		Pressure	HVLP: 8-10 PSI at the air cap. Compliant: 28-35 psi at the gun. Please refer to the gun manufacturer.
			Nozzle	1.3 - 1.8mm or equivalent


### VOC COMPLIANT

2004/42/IIIB© (540): The EU limit value for this product category: IIB© in ready to use 540 g/l.


### COATS & THICKNESS

	Number of layers	1-3 coats
	Thickness (um)	40-60 microns

### FLASH OFF TIME (@20°C)

	Flash off between layers	5-10mins
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### DRYING TIME

	20°C	2-3 hours
	60°C	20 min

### READY FOR SANDING

	For dry sanding P360-P500		For wet sanding P600-P1000
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### COLOUR

WHITE, GREY & BLACK

### CLEANING EQUIPMENT

For cleaning equipment, acrylic thinner or cellulose cleaner can be used. It is recommended to use thinner for cleaning paint spray guns.

### HEALTH AND SAFETY REGULATIONS

See the Safety Data Sheet.

### STORAGE TIME AND CONDITIONS

2 years in the original sealed can in a cool and dry place at 20°C. Do not store on the floor.

### PACKAGING

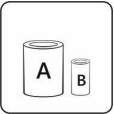
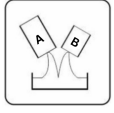
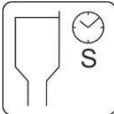



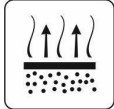
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### WET-ON-WET APPLICATION INFORMATION

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### PT-30 4:1 HS ACRYLIC PRIMER WET ON WET

Wet-on-wet variant is for use in industrial plants and in states where the Directive 2004/42/EC of the European Parliament and of the Council of 21 April 2004 (limiting emissions of volatile organic compounds due to use of organic solvent material in paints and refinishing products) do not apply.

MIXING RATIO				
		<b>PT-30</b>	<b>HT-31</b>	<b>ST10 / ST11</b>
	<b>Volume</b>	4	1	30-35%
	<b>Weight</b>	100g	16g	30-35g
POT LIFE				
	Mixture life after mixing primer with hardener	20 min		
APPLICATION VISCOSITY		SPRAY GUN SET UP		
	13-20 seconds (DIN 4/20°C)		Pressure	Refer to gun manufacturer
			Nozzle	1.2 - 1.4 mm
VOC				
Ready to use 540g				
COATS & THICKNESS				
	Number of layers	2-3 coats		
	Thickness (um)	25-35		
DRYING TIME		FLASH OFF TIME		
	Spray topcoats after the primer paint film turns matt (10-15 min).		Flash off between layers	≤1 min

WEIGHT OF COMPONENTS READY FOR USE

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Component	Primer	Hardener	Thinner
<b>Amount (RFU)</b>	<b>PT-30</b>	<b>HT-31</b>	<b>ST-10 / ST-11</b>
100 ml	113.3g	15.6g	14.2g
200 ml	226.6g	31.3g	28.3g
300 ml	340.0g	47.0g	42.5g
400 ml	453.3g	62.6g	56.7g
500 ml	566.6g	78.3g	70.8g
1000 ml	1133.3g	156.6g	141.7g

### WEIGHT OF COMPONENTS READY FOR USE (WET-ON-WET)

Component	Primer	Hardener	Thinner
<b>Amount (RFU)</b>	<b>PT-30</b>	<b>HT-31</b>	<b>ST-10 / ST-11</b>
100 ml	106.2g	14.7g	18.6g
200 ml	212.4g	29.4g	37.2g
300 ml	318.7g	44.0g	55.8g
400 ml	424.9g	58.7g	74.4g
500 ml	531.1g	73.4g	92.9g
1000 ml	1062.2g	146.8g	185.9g

#### Remarks

1. Use slow or extra slow thinner for Spot/Rapid process at shop temperature over 35°C.
2. Pot life may be considerably shorter when the temperature is over 25°C. Use the material after mixing as soon as possible. Clean equipment immediately after each use.