

Technical Data Sheet

XPT-20 3:1 RAPID PRIMER PLUS

PRODUCT DESCRIPTION

Multi-purpose two pack fast drying primer, with strong filling power and great adhesion between coats. It has excellent flexibility and impact resistance which can increase gloss and build of topcoats. Available with different hardeners and thinners, it can be used for rapid repair, medium area repair and total resprays.

SUBSTRATES

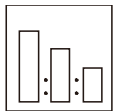
- steel
- aluminium
- stainless steel
- wash etch primers
- epoxy primers
- polyester fillers
- old or original paintwork well sanded and cleaned (including thermoplastic paints)
- plastics (it depends on material components always test first)

SURFACE PREPARATION



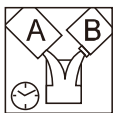
Remove wax, silicon or other contaminations with a good quality degreaser

MIXING RATIO



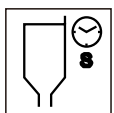
Ratio	Rapid Repair (1-2 panels)	Medium Repair (3-5 panels)	Overall Repair (More than 6 panels)
3 Parts Primer	XPT-20	XPT-20	XPT-20
1 Part Hardener	XHT-21	XHT-21	HT-211
1.5 Part Thinner (35-40 %)	XST-22	ST-11	ST-12

POT LIFE (@25°C)



Mixture life after mixing primer. hardener	Rapid Repair (1-2 panels)	Medium Repair (3-5 panels)	Overall Repair (More than 6 panels)
	20 min	40 min	1.5 h

APPLICATION VISCOSITY



22-25 seconds (DIN 4/20°C)

SPRAY GUN SET UP




Pressure	1.8-2.0 bar
Nozzle	1.6mm-1.8mm

VOC compliant

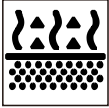
2004/42/IIB(c)(540): The EU limit value for this product category: IIB(c)) in ready to use 540 g/l

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COATS & THICKNESS

	Number of layers	2-3
	Thickness (um)	40-50 microns



FLASH OFF TIME

	Flash off between layers	Rapid Repair (1-2 panels)	Medium Repair (3-5 panels)	Overall Repair (More than 6 panels)
		0-1 min	2-3min	3-5min

DRYING TIME

	Temperature	Rapid Repair (1-2 panels)	Medium Repair (3-5 panels)	Overall Repair (More than 6 panels)
	20°C	25min	40-50min	1.5-2hr
	25°C	20min	35-40min	1.5-2hr
	60°C	5min	10min	20min

READY FOR SANDING

	For dry sanding P320-P600		For wet sanding P500-P1000
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CLEANING EQUIPMENT

For cleaning equipment, acrylic thinner can be used or cellulose thinner. 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 original sealed can at cool and dry place at 20°C. (Do not store on the floor)

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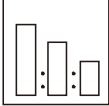
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OTHER INFORMATION


XPT-20 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.

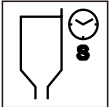
MIXING RATIO

	Ratio	CODE
	3 Parts Primer+8% Colour	XPT-20+2K Solid Colour
	1 Part Hardener	XHT-21
	2.5-3 Part Thinner (60-75 %)	ST-12


POT LIFE (@25°C)

	Mixture life after mixing primer with hardener	20 mins
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APPLICATION VISCOSITY

	13-15 seconds (DIN 4/20°C)
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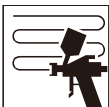
SPRAY GUN SET UP

	Pressure	1.8-2.0bar
	Nozzle	1.3mm-1.5mm


VOC

Actual ready to use 618g


COATS & THICKNESS

	Number of layers	2-3
	Thickness (um)	25-35

FLASH OFF TIME

	Flash off between layers: ≤1 min
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DRYING TIME

	Non-Sanding for Wet on Wet Application.
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Remarks:

Spray topcoats after the primer paint film turns matt (10-15 min).

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WEIGHT OF COMPONENTS READY FOR USE			
Rapid Repair (1-2 panels)			
Component	Primer	Hardener	Thinner
Amount (RFU)	XPT-20	XHT-21	XST-22
100 ml	61.5g	15.38g	23.06g
200 ml	123.0g	30.76g	46.12g
300 ml	184.5g	46.14g	69.18g
400 ml	246.0g	61.52g	92.24g
500 ml	307.5g	76.9g	115.3g
1000 ml	615.0g	153.8g	230.6g
Medium Repair (3-5 panels)			
Component	Primer	Hardener	Thinner
Amount (RFU)	XPT-20	XHT-21	ST-11 @ 15-25 °C ST-12 @ 25-35 °C
100 ml	61.5g	15.38g	23.06g
200 ml	123.0g	30.76g	46.12g
300 ml	184.5g	46.14g	69.18g
400 ml	246.0g	61.52g	92.24g
500 ml	307.5g	76.9g	115.3g
1000 ml	615.0g	153.8g	230.6g
Overall Repair (more than 5 panels)			
Component	Primer	Hardener	Thinner
Amount (RFU)	XPT-20	HT-211	ST-11 @ 15-25 °C ST-12 @ 25-35 °C
100 ml	61.5g	15.38g	23.06g
200 ml	123.0g	30.76g	46.12g
300 ml	184.5g	46.14g	69.18g
400 ml	246.0g	61.52g	92.24g
500 ml	307.5g	76.9g	115.3g
1000 ml	615.0g	153.8g	230.6g

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WEIGHT OF COMPONENTS READY FOR USE				
WET ON WET VERSION				
Component	Primer	2K Solid Colour	Hardener	Thinner
Amount (RFU)	XPT-20	Similar 2K colour as top colour	XHT-21	ST-11 @ 15-25 °C ST-12 @ 25-35 °C
100 ml	53.2g	4.2g	13.33g	33.32g
200 ml	106.4g	8.4g	26.66g	66.64g
300 ml	159.6g	12.6g	39.99g	99.96g
400 ml	212.8g	16.8g	53.32g	133.28g
500 ml	266.0g	21.0g	66.65g	166.6g
1000 ml	532.0g	42.0g	133.3g	333.2g

Remarks:
<ol style="list-style-type: none"> 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 temperature is over 25°C. Use the material after mixing as soon as possible. Clean equipment immediately after each use. 3. For Wet-on-Wet process, the addition of 2K solid color is not to exceed 8% of primer.