

Technical Data Sheet



3+1 HS Acrylic Primer

Field of application:	Passenger cars and commercial vehicles. Suitable for repair and new construction.
Chemical bases:	2-Component high quality hydroxy acrylic resins.
General qualities:	3+1 HS Acrylic Primer is a high-solid 2-pack primer with easy application, high filling power and sagging limit. This product meets the VOC-requirements of 540 g/L.
Auxiliary materials:	H 8-18/18-30/30+ Hardeners, e-Slow/Standard/Fast Hardeners and T 8-18/18-25/25-35 /35+ Universal Thinners.
Mixing ratio (volume):	3:1 (3: 3+1 HS Acrylic Primer, 1: e or P line hardeners) if needed add max. 15 % universal thinners.
Physical properties	
Density:	1.500-1.510 kg/L
Flash Point:	>21 °C
Vol. % solids:	56
Gloss:	Matt
Economy:	Approx. 8 m ² /L/60 µm
Substrates:	Applied on sanded and cleaned fully cured old coatings and plastic surfaces coated with plastic primer.
Undercoats:	Irrelevant
Finishing materials:	All Polaron Finishes.
Cleaning the equipment:	Universal Acrylic Thinners and Nitro Cellulose Thinners
Colour:	Grey, White and Black.
Storage life:	Under normal storage conditions and unopened tins up to 2 years.

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APPLICATION DATA

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**Application viscosity:**

18-22 sec. (DIN CUP 4 mm/20 °C)

**Gravity feed**Spray nozzle (mm)Pressure (bar)

1.4-1.8

3.5-4.5

**Suction feed**

1.6-1.8

3.5-4.5

HVLP/LVLP

1.4-1.8

see info
manufacturer

**Spray coats/**

1-3

Coat thickness:

60-180 µm

**Flash-off time:**

5-10 min.

**Drying:**

20 °C 4-5 hours per layer

60 °C 20-30 min. per layer

May be sprayed over wet-on-wet after approx.
20 min at 20 °C Thick coats after 16 hours at 20 °C

**Pot life:**

45-60 min. (in combination with e Hardener
Standard and H 18-30 Hardener Standard)

30-35 min. (in combination with e Hardener Fast
and H 8-18 Hardener Fast)

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