

Technical Data Sheet



5+1 HS Acrylic Primer

Field of application:	Passenger cars and commercial vehicles. Suitable for repair and new construction and plastic surfaces.
Chemical bases:	2-Component high quality hydroxy acrylic resin and polyolefin blend
General qualities:	5+1 HS Acrylic Primer can be applied on every kind of surfaces. (Zinc plated steel, bear metal, bronzes, aluminium ve plastic surfaces, etc.) This product meets the VOC-requirements of 540 g/L. HINT: It should be necessary to heat surfaces when applied on PE or/and PP-PE blend
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):	5:1 (5: 5+1 HS Acrylic , 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 every kind of surfaces (Zinc plated steel, bear metal, bronzes, aluminium ve plastic surfaces, etc.)
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.

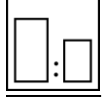
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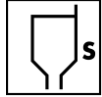
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APPLICATION DATA



Mixing ratio:

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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

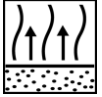


Spray coats/

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:

2-3 hours (in combination with e Hardener Standard and H 18-30 Hardener Standard)

1-2 hours (in combination with e Hardener Fast and H 8-18 Hardener Fast)

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