

304 PRM-EE

1K Epoxy Ester Primer Filler

Resin base: 1-component Alkyd / Epoxyester resin

Technical Information 5.3.2

Products needed:	<table><tr><td>Pastes</td><td>GJ50-</td></tr><tr><td>Converter</td><td>GK15-1301</td></tr><tr><td>Converter/Pastes</td><td>90 : 10</td></tr><tr><td>Thinner</td><td>SV12-0360 Nitro</td></tr><tr><td></td><td>SV13-0732 Fast</td></tr><tr><td></td><td>SV13-0701 Medium</td></tr></table>			Pastes	GJ50-	Converter	GK15-1301	Converter/Pastes	90 : 10	Thinner	SV12-0360 Nitro		SV13-0732 Fast		SV13-0701 Medium
Pastes	GJ50-														
Converter	GK15-1301														
Converter/Pastes	90 : 10														
Thinner	SV12-0360 Nitro														
	SV13-0732 Fast														
	SV13-0701 Medium														
Application and properties:	1K Epoxy Ester Primer Filler <ul style="list-style-type: none">• good leveling• good sagging resistance• many different colors possible• good corrosion protection as appropriate for 1K epoxy ester primer filler.• min. ambient temp. +15°C for application														
Substrates/Pre-treatment: Well-cured old paintwork Bare steel Electrolytically galv. Steel Sendzimir galv. Steel Glass-fibre reinforced plastics	Cleaning SV20-0505 SV22-0500 SV22-0500 SV22-0500 SV20-0530	Sanding P240-360 P80-150 abrasive pad abrasive pad P240-360	Final cleaning SV20-0505 SV22-0500 SV22-0500 SV22-0500 SV20-0530												
	* Other substrates could be possible. Please refer to matrix 3.9														
Can be overcoated with:	TPC-AKD, TPC-ACR, TPC-PUR, TPC-EPX														
Product details:	Not suitable for use under polyester body filler. Remove corrosion (e.g., rust) by fine sanding or blasting before applying the product.														
Special Remark:	It cannot be ruled out that this product contains particles < 0.1 µm. The products are suitable for professional use only.														

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












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Application: 1K Primer Filler

Remarks: Values reg. VOC, coverage, solid content and viscosity are based on a mixing ratio by Vol.
Select thinner acc. ambient temperature and size of object to be painted.

	Paint system	304 PRM-EE 1K Primer Filler				
	VOC	Theor. Coverage at 1 µm (RAL3000/9010)		Solid Content		
	590-600 g/l	316/304 m²/kg		345/341 m²/L	44-47 % Gew.	
	Mixing ratio	304 PRM-EE	100 % by weight		2 Vol.	
	Hardener	-				
	Thinner	SV12-0360 SV13-0732 SV13-0701	40 % by weight		1 Vol.	
	Viscosity at 23°C DIN 4		Film Thickness (DFT)		Potlife 20°C	Gloss at 60°
	2:1 Vol. 18-20 sec. 3:1 Vol. 28-32 sec. 4:1 Vol. 36-40 sec.		40-60 µm (2-3 coats) flash off 5-10 min. between		-	matt
	Application		Viscosity (sec)	Mixing ratio	Spraying Pressure (bar)	Nozzle (mm)
	Compliant Gun		18-20	2:1	< 2.5	1.6-1.8
	HVLP		18-20	2:1	~ 2	1.6-1.8
	Suction Cup		18-20	2:1	2-3	1.6-1.8
	Airless / Airmix		28-32	3:1	120-150	0.28-0.33
	Double Diaphragm or Pressure Pump		18-20	2:1	< 4	1.0
	Brush & Roll		with less thinner; only brush application possible			
	Drying at Object Temp.		dust-dry	Flash Off (wet-on-wet)	Touch Dry	Recoatable
	20°C		10 min	1 h	1 h	max. 72 h
	60°C		-	30 min	30 min	-