

GlobalStar

6I.4.70133

2K Acrylic Primer Filler

GlobalStar
INDUSTRIAL



EU/ROW082520166I.4.70133

Technical Data Sheet

Description

6I.4.70133 is a 2K, high build, high production, acrylic urethane primer filler with excellent hold out and easy to sand properties. Light Gray color makes it easy to achieve opacity with a minimum number of color coats.

Suggested Uses

As a wet on wet sealer or a full bodied sand-able primer, where body repair, scratches or imperfections need to be filled, machinery, furniture, heavy industrial applications.

- Excellent hold out with minimal shrinkage is needed.
- Excellent sand-ability is needed.
- High productivity is required.
- Excellent performance when applied with air-assist airless pressure pot, Conventional, HVLP, siphon or gravity feed cup gun.

Components

6I.4.70133

OG.013

OA.H3

Base

Standard Polyurethane Reducer

Hardener

Field Applications

- Semi-trucks
- Coachworks (Buses)
- Work panel trucks
- Cement trucks and snow plows
- Many OEM applications
- Aircraft and marine
- Heavy machinery
- Furniture

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Mixing Ratio

Mix:

Five (5) parts 6I.4.70133 Base to one (1) part 0A.H3 Hardener. Reduce 0-10% with selected reducer for sanding filler and 20-40% for non sanding filler.

Application

Apply:

One to three medium wet coats, allow 10-20 minutes flash between coats.

Spray Gun:

HVLP Gravity Feed – 1.4 – 1.7mm tip and needle
Pressure Pot HVLP – 1.0 – 1.2mm tip and needle
Air Assist Airless – 1.0 – 1.2mm tip and needle
Conventional – 1.5 – 1.8mm tip and needle

Film Build:

50-60 microns per cross coat

Dry Times

Dust Free:

15 – 20 minutes @ 20° C (68° F)

Dry to Touch

12 – 24 Hrs @ 20° C (68° F) (depending on film build)

Force Dry

45 minutes @ 60° C (140° F) sand before painting

Surface Preparation

Ferrous metals:

Best Case

SA2 sandblast Blow all dust and contaminates off and apply 2I.2.K1 epoxy primer within 8 hours. Allow epoxy primer to cure for at least 24 hours, then sand before applying 6I.4.70133 filler primer.

Second Best Case

Hot Phosphate wash system, blow dry and apply 2I.3.70121 epoxy primer within 8 hours. Allow epoxy primer to cure for at least 24 hours, then sand before applying 6I.4.70133 filler primer.

Third Best Case

Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal

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solvent making sure all residue is removed then apply 2I.3.70121 epoxy primer within 4 hours. Allow epoxy primer to cure for at least 24 hours, then sand before applying 6I.4.70133 filler primer.

Aluminum:

Sand surface, then clean surface with clean drying wax and grease remover. Apply 2I.3.70121 Epoxy Primer, allow to cure, sand then apply 6I.4.70133 primer.

Galvanized Steel:

Clean all dust, oil residue, and contaminants from surface using a Clean drying wax and grease remover. Light Sanding (320P grit) Clean again with clean drying wax and grease remover using a wipe and dry process. Apply 2I.3.70121 Epoxy Primer, allow to cure, sand and apply 6I.4.70133 primer.

VOC

Regulatory VOC

540 g/l

Actual VOC

435 g/l

Solids

By Volume

45% + or - 2%

By Weight

72% + or - 2%

Specific Gravity

1.6 kg/l

Coverage

4.5 to 4.8 m²/l at RFU

Repainting

Recoat after 2 Hours.

After 12 hours @ 20° C (68° F) light sanding needed.

Storage Stability

On year, stored in closed package, in cool dry place, away From any sources of heat.

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