



P45 - 2K Rapid Primer Red

Description:

A VOC compliant, high build, two component sanding primer surfacer with good vertical stability, fast air drying and force drying, good filling properties in combination with excellent application and sanding properties. Direct to plastic with addition of plastic additive A230.

Suitable Substrates:

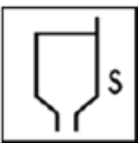
- Existing Finishes except TPA
- OEM Primer or EDP, sanded
- “Hymax” Polyester Putties
- Bare metal substrates must be pre-primed with wash primer P97.
- Available colors (Beige P40, Grey P42, Black P43, White P44, Red P45, Dark Grey P46)



STIR P45 well before mixing



Mix 100:25% : 5-25%
- H050 Fast
- H060 Normal
5-25% Hymax Thinners
Potlife 45 to 60 min / 20 °C (68 °F)



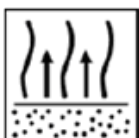
22-24 sec / DIN 4 mm / 20 °C (68 °F) @ 5% reducer
18-19 sec / DIN 4 mm / 20 °C (68 °F) @ 25% reducer



Compliant 1.6 – 1.8 mm
2.0 – 2.5 bar inlet pressure
HVLP 1.7-2.0 mm ; maximum 0.7 bar at the air-cap



2-3 coats
50-60 microns per coat



5-6 minutes at 20 °C (68 °F) between coats

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2-3 hours at 20 °C (68 °F)
20 mn. at 60 °C (140 °F)



10 – 15 mn. Short Wave
The object should be maintained at greater than 60cm from source



Initial Sanding with P500 - P600 grit
Final Sanding with P800 - P1000 grit



Initial Sanding with P320 grit
Final Sanding with P400 - P500 grit



Clean Surface to remove contamination prior to application of top coat



HyMax T-series & B-series Top Coat
Hydrobase Basecoats



Wear suitable protection

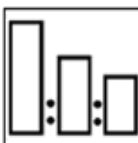
Tinting the Primer for Limited Opacity Colors

NB:

Poor opacity solid colors: When the HyMix Pro system informs you that the solid color has poor opacity, we recommend the following: Add the relevant T-series color formula into the appropriate primer which will assist you in achieving a background that will enhance the color and save on unnecessary coats of the selected color thus allowing you to keep costs to a minimum. Use Beige primer for Yellow colors, use Grey primer for Orange and Red colors

Process:

Using the appropriate primer from our range mix:



2:1:1:0.5
Appropriate Primer 2 Parts.
Selected T-Series color formula 1 Part.
Hardener 1 Part.

All other processes remain the same as per the P45 TDS sheet on application, drying and sanding.



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P45 Primer Direct on Plastics:

With the addition of A230, P45 can be applied direct to plastics without the need for a 1k plastic adhesion promotor (plastic primer)



- Mix 4:1
- H060 H050 Hardeners.
 - 10 – 25% Reducer “ Hymax”
 - Add 15% plastic additive A230
 - Potlife 45-60 mins / 20°C (68°F)

P45 Primer Plasticized:

Soft Plastic Application

Product	Parts	Weight(g)
P45	100.0	1633.0
C100	50.0	501.3
H050/H060	50.0	513.4/490
Reducer	5.0- 25.0	64.0-348. approx.

Hard Plastic Application

Product	Parts	Weight(g)
P45	100.0	1633.0
C100	15.0	150.39
H050/H060	32.5	333.76/ 318.5
Reducer	5.0- 25.0	49.0- 266.5 approx.

Process Notes:

To optimize the sanding properties, the plasticized primers should be dried 45 min. @ 60-65 °C panel temperatures. All other processes remain the same as per the P45 TDS sheet on application, drying and sanding.

	15 - 20° C.				20 - 25° C.				25 - 30° C.				+ 30° C.			
	Thinner 711				Thinner 721				Thinner 721				Thinner S2040			
	Hardenener	Time to sanding			Hardenener	Time to sanding			Hardenener	Time to sanding			Hardenener	Time to sanding		
	20° C.	60° C.	IR		20° C.	60° C.	IR		20° C.	60° C.	IR		20° C.	60° C.	IR	
Full paint	H500	2.5HRS	20 MINUTES	15 MINUTES	H500	2.5HRS	20 MINUTES	15 MINUTES	H600	2.5HRS	20 MINUTES	15 MINUTES	H700	2.5HRS	20 MINUTES	15 MINUTES
Vertical areas	H500	2.5HRS	20 MINUTES	15 MINUTES	H500	2.5HRS	20 MINUTES	15 MINUTES	H500 H600	2.5HRS	20 MINUTES	15 MINUTES	H700	2.5HRS	20 MINUTES	15 MINUTES
Fast Repair	H200 H500	2.5HRS	20 MINUTES	15 MINUTES	H200 H500	2.5HRS	20 MINUTES	15 MINUTES	H500	2.5HRS	20 MINUTES	15 MINUTES	H600	2.5HRS	20 MINUTES	15 MINUTES
Soft plastics																
30 % - 810 Plasticizer	H500	3.5 HRS	30 MINUTES	NA	H200 H500	3.5 HRS	30 MINUTES	NA	H500 H600	3.5 HRS	30 MINUTES	NA	H700	3.5 HRS	30 MINUTES	NA
Hard plastics																
15 % - 810 Plasticizer	H500	3 HRS	25 MINUTES	NA	H200 H500	3 HRS	25 MINUTES	NA	H500 H600	3 HRS	25 MINUTES	NA	H700	3 HRS	25 MINUTES	NA



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Wet on Wet Version

100/P45: 100/C061 or C060R clearcoat: 75/ H060 hardener: 30/ hymax thinner S11.

Application: 1 light coat followed by 1 full. No flash off in between

Flash off 30 minutes before application of top coating material

Spray gun: 1.3—1.4 mm needle size

VOC (2004/42/EC): 2004/42/IIB (c) (540)540. The EU limit value for this product (product category IIB.c) in ready to use form is max 540g/ltr. The VOC content of this product in ready for use form is max. 540 g/l.

Flash Point: 20-25°C (77°F)

Specific Gravity: 1633 g/L (13.63 lbs/gal)

Solids Content: 67.8 % by weight – ready to spray

Coverage: 5.7-5.8 m²/l at 80 micron film thickness (theoretical)

SDS: Refer to the safety data sheet

Product Data Sheet