



# TECHNICAL DATA SHEET

## HS 2K PRIMER (HIGH BUILD)

### PRODUCT DESCRIPTION

There are actually two undercoats systems in this high build *Two Component Primer*. Its unique formulation ensures that there's no need to apply a putty and a primer over a prepared surface - the only product that's needed is Concept HS 2K Primer (High Build).

This product has excellent Film Build, Adhesion and Rust inhibiting properties and is easy to sand.

### PRODUCT AND ADDITIVES

- Concept HS 2K Primer (High Build)
- Concept Primer Hardener
- Concept Primer Hardener - Fast
- Concept 2K Thinner Range




### SUITABLE SUBSTRATES

- Sound existing finishes.
- Aluminium surfaces primed with Concept 1K Etch Primer.
- Steel surfaces primed with Concept 1K Etch Primer.
- Polyester spray filler.
- Glass reinforced polyester.

### MIXING RATIO





- 4 parts Concept HS 2K Primer (High Build) by volume.
- 1 part Concept Primer Hardener by volume.
- If needed a 10 - 20% reduction can be made with Concept 2K Thinner.

## SPRAY GUN AND PRESSURE

SPRAY GUN & PRESSURE:	<ul style="list-style-type: none"> <li>2.0mm tip with a suction feed gun</li> <li>Pressure is 350 – 450 kPa. (The same condition applies for gravity feed)</li> </ul>	
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## APPLICATION

- Stir thoroughly before use.
- All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept Light Rust & Metal Conditioner.
- Two to three, even coats are needed to obtain a 50 - 80 Micron Dry Film Thickness. 100 microns can be obtained after three to four coats.

SPRAYING VISCOSITY:	<ul style="list-style-type: none"> <li>25 - 27 seconds B4 cup at 25°C.</li> </ul>	
FLASH-OFF TIME:	<ul style="list-style-type: none"> <li>5 minutes between coats at 25°C.</li> </ul>	
DRYING:	<ul style="list-style-type: none"> <li>3 - 4 hours at 25°C for a Dry Film Thickness of 50 – 80 Micron.</li> <li>16 – 24 hours at 25°C for a Dry Film Thickness of 100 Micron.</li> <li>Low Bake for 30 - 40 minutes at 50°C.</li> </ul>	
SANDING:	<ul style="list-style-type: none"> <li>Wet sand thoroughly with either P600 - P800 before applying finish coat.</li> </ul>	

## TECHNICAL INFORMATION

<b>COLOUR:</b>	Beige or Grey
<b>COVERAGE:</b>	5 m <sup>2</sup> /L @ 80 Micron Dry Film Thickness.
<b>POT LIFE:</b>	2 - 3 hours at 25°C.
<b>VOC:</b>	Beige: 425 g/L, Grey: 419 g/L Hardener Normal: 522 g/L, Fast: 572 g/L
<b>PACKAGING:</b>	1LT, 4LT, 5LT Kit Hardeners: 250ML, 1LT
<b>ITEM CODE:</b>	A03C/2KPRIM (Hardeners: A04C/PRIMH)
<b>SHELF LIFE:</b>	12 Months (Hardeners: 6 months)

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The above information is reliable and accurate to the best of our knowledge at the time of preparation. Any recommendations or suggestions made are without warranty or guarantee. Users assume all responsibility since the conditions of use are beyond our control.

**REVISED: 05 April 2013**

**REPLACES ISSUE: 6 March 2009**