

Technical Data Sheet

Product Name	
Full Product Name	138 ISO Free Primer
Type of Product	2K High Build Isocyanate Free Primer Surfacer.
Description	Concept 138 ISO Free Primer is a high build primer surfacer, which uses an isocyanate free curing agent. It is characterized by high film build, easy to sand, excellent adhesion and gives a smooth finish with excellent hold out properties.

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
138 ISO Free Primer	42.2	65.5	1.463	12.21	504.3	4.21
138 ISO Free Hardener	21.7	28.3	0.894	7.46	641.1	5.35
831 2K Thinner Slow	0.0	0.0	0.893	7.45	892.7	7.45
831 2K Thinner Normal	0.0	0.0	0.882	7.36	881.9	7.36
831 2K Thinner Fast	0.0	0.0	0.872	7.27	871.5	7.27

Properties
<ul style="list-style-type: none"> High Film Build per coat Excellent hold out Excellent adhesion and durability Easy to sand with reduced paper clogging Fast drying when compared to other similar products

Substrates

- Mild Steel
- Aluminium and other paintable non-ferrous metals primed with Concept 103 Etch Primer
- Sound, cured, cleaned and sanded existing surfaces

Substrate Preparation



All Substrates












All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept 025 Rust Converter.

Product Preparation

	Mixing Ratio 4:1 (by volume)	Concept 138 ISO Free Primer		Concept 138 ISO Free Hardener
		4 parts		1 part
	Reducer	Up to 25% (v/v) of Concept 831 2K Thinner, if required.		
	Pot life @ 25°C (77°F)	4-5 hours		
	Spray viscosity @ 25°C (77°F)	BSB 4 Cup Ford 4 Cup	19-21 s 17-18 s	

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Product Preparation cont

   	Spray equipment	Gun type	Fluid tip	Spray pressure	Spray Distance
	Gravity feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
	Suction feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
	HVLP	1.5-1.8 mm 0.059-0.071"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch	
	Airless Air Assisted Electrostatic	Consult the manufacturer's instructions.			
	Number of coats	2-3 coats	Apply one coat followed by two even full coats. Avoid heavy wet coats.		
	DFT Recommended	50-70 µm 2.0-2.8 mils			
	Flash off time @ 25°C (77°F)	5 min between coats			
 	Drying	Air Dry @ 25°C (77°F)	3-4 hours	50-80 µm (2.0-3.2 mils)	
			16-24 hours	100 µm (4 mils)	
		Low Bake @ 50°C (122°F)	30-40 min		
	Infra-Red Dry	12-15min short wave or 18-22 min medium wave			
	Sanding	Wet sand with P600-P800 before applying finish coat or Dry sand with P240 followed by P400-P500 using an orbital sander			

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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Version:02

Remarks



Stir all products thoroughly each time before use.
Stir the mixture well after the weigh-out of the components.



Surface temperature must always be a minimum of 3°C
(5°F) above dew point.

NOTE:

Ensure the complete removal of any residue of Rust
Converter before applying this primer.

Equipment Cleaning

Use recommended Concept Paints 035 Gunwash

Dry Film Properties

After 7 days drying,
when compared to similar technology products.

Hardness

Excellent

Flexibility

Excellent

Chemical and water resistance

Excellent

Corrosion protection

Excellent

Sanding

Excellent

Product Data

Colour

Grey, Black

Theoretical Coverage

Approx. 5 m²/L (205 ft²/US gal) @ recommended DFT

Shelf Life

36 months in an unopened container
at room temperature away from sunlight.

Product Packaging

Product Code	Product Name	Package Size
IN138620000XX	138 ISO Free Primer - Grey	4L, 5L(Kit), 16L, 20L(Kit)
IN138700000XX	138 ISO Free Primer - Black	16L, 20L(Kit)
IN13892000001	138 ISO Free Hardener	1L
IN83191000020	831 2K Thinner Slow	20L
IN83192000020	831 2K Thinner Normal	20L
IN83193000020	831 2K Thinner Fast	20L

Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

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This Technical Data Sheet supersedes all previous issues.

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