

Technical Data Sheet

Product Name	
Full Product Name	334 2K PU Primer Base (Tintable Primer)
Type of Product	2K high build acrylic Polyurethane primer surfacer
Description	Unicote 334 2K PU Primer Base is a high solid 2K acrylic Polyurethane primer surfacer, characterized by excellent film build per coat, adhesion to properly prepared substrates and rust inhibiting properties. This product is designed specifically to give high filling properties with ease of sanding. This base is used with the Unicote 300 system making it tintable with Concentrate tinters by using colour program to achieve all colours.

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
334 2K PU Primer Base	52.7	73.3	1.565	13.30	417.5	3.58
241 PU Hardener (4:1) Slow	37.3	45.3	0.954	7.96	521.9	4.36
241 PU Hardener (4:1) Normal	31.5	38.9	0.938	7.83	572.7	4.78
241 PU Hardener (4:1) Fast	33.9	39.9	0.986	8.23	593.1	4.95
Infra-Red Primer Hardener	0.0	0.0	0.893	7.45	892.7	7.45
831 2K Thinner Slow	0.0	0.0	0.882	7.36	881.9	7.36
831 2K Thinner Normal	0.0	0.0	0.872	7.27	871.5	7.27
831 2K Thinner Fast						

Properties
<ul style="list-style-type: none"> • High film build per coat (high solids)
<ul style="list-style-type: none"> • Excellent adhesion to properly prepared substrates
<ul style="list-style-type: none"> • Easy to sand with reduced paper clogging
<ul style="list-style-type: none"> • Excellent corrosion protection
<ul style="list-style-type: none"> • Excellent drying and sag resistance

Substrates

- Mild Steel surfaces primed with Concept 103 Etch Primer or Concept 110 Metal Etch Grey
- Aluminium surfaces primed with Concept 103 Etch Primer or Concept 110 Metal Etch Grey
- Polyester spray filler
- Glass reinforced polyester (GRP & general types of fibreglass body parts)
- 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)	Unicote 334 2K PU Primer Base		241 PU Hardener (4:1)
		4 parts	1 part	
	Reducer	10-20% (v/v) of Concept 831 2K Thinner, if required.		
	Pot life @ 25°C (77°F)	2-3 hours		
	Spray viscosity @ 25°C (77°F)	BSB 4 Cup Ford 4 Cup	25-27 s	22-23 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 (up to 4)	Apply one coat followed by two even full coats. Avoid heavy wet coats.	
	DFT Recommended	50-80 µm (up to 100 µm) 2.0-3.2 mils (up to 4.0 mils)		
	Flash off time @ 25°C (77°F)	5 min between coats		
	Air Dry @ 25°C (77°F)	3-4 hours	50-80 µm (2.0-3.2 mils)	
	Low Bake @ 50°C (122°F)	16-24 hours	100 µm (4 mils)	
	Infra-Red Dry	30-40 min		
	Infra-Red Dry	12-15min short wave; 18-22 min medium wave Use Infra-Red Primer Hardener		
	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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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.

Equipment Cleaning	
Use recommended Concept Paints 035 Gunwash	

Dry Film Properties	
After 7 days drying, <u>when compared to similar technology products.</u>	
Hardness	Excellent
Flexibility	Excellent
Corrosion protection	Excellent
Sanding	Excellent

Product Data	
Colour	Unicote 300 colour data base
Theoretical Coverage	Approx. 5 m ² /L (205 ft ² /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
IN33490003.60	334 2K PU Primer Base	3.6L
IN2419100000X	241 PU Hardener (4:1) Slow	250mL, 1L
IN2419200000X	241 PU Hardener (4:1) Normal	250mL, 1L
IN2419300000X	241 PU Hardener (4:1) Fast	250mL, 1L
AU22692000001	Infra-Red Primer 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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