


Features:	Versatile Primer, fast drying & good filling properties, easy to sand	
Benefits:	Allows fast throughput in the body shop, ensures good top coat finish	
Recommended Use:	Multi Purpose Primer that has outstanding sanding properties, fast drying and excellent top finish.	
Required Materials:	<ul style="list-style-type: none"> <li>• Karbon Primer</li> <li>• Karbon Hardeners</li> <li>• Karbon Reducer</li> <li>• Mixing stick, mixing container, spray gun</li> </ul>	<ul style="list-style-type: none"> <li>• PR50</li> <li>• H2M, H2F</li> <li>• R2M</li> </ul>
Physical Properties/ Technical Data:	<ul style="list-style-type: none"> <li>• Specific Gravity(kg/l):</li> <li>• Flash Point:</li> <li>• Solids Vol %:</li> <li>• Solids Wt. %:</li> <li>• Coverage:</li> <li>• Viscosity (RTS):</li> <li>• Gloss:</li> <li>• Color:</li> <li>• V.O.C. Regulatory RTS (g/L) (less water, less exempts):</li> <li>• V.O.C. Regulatory RTS (lbs/Gal) (less water, less exempts):</li> <li>• Applicable Use Category:</li> <li>• Sq. Ft. Coverage / US Gal. 1 mil at 100% transfer efficiency:</li> <li>• Sq. Ft Coverage m<sup>2</sup>/ L (x-y μm)</li> </ul>	<ul style="list-style-type: none"> <li>• 1.536</li> <li>• Closed cup: &gt;25C (&gt;77F)</li> <li>• 68.2%</li> <li>•</li> <li>• Ca. 8 m<sup>2</sup>/L/40 μm</li> <li>• 2" as ready to use</li> <li>• Matt</li> <li>• Grey</li> <li>• 485 g/l</li> <li>• 4.05 lbs/gal</li> </ul>
Pretreatment:	Clean with a universal cleaner, sand surface to promote adhesion and clean one more time with Universal Cleaner	
Cleaning the Equipment:	Lacquer Thinner	
Mixing Ratio:	<ul style="list-style-type: none"> <li>• <b>High Build Primer 4:1</b></li> <li>• 100% by vol. Karbon PR50 Primer</li> <li>• 25% by vol. Karbon Hardeners</li> <li>• <b>Primer Filler 4:1:1</b></li> <li>• 100% by vol. Karbon PR50 Primer</li> <li>• 25% by vol. Karbon Hardener</li> <li>• 25% by vol. Karbon Reducer</li> <li>• <b>Primer Filler 4:1:2</b></li> <li>• 100% by vol. Karbon Primer</li> <li>• 25% by vol. Karbon Hardener</li> <li>• 50% by vol. Karbon Reducer</li> </ul>	<ul style="list-style-type: none"> <li>• PR50</li> <li>• H2M,H2F</li> <li>•</li> <li>• PR50</li> <li>• H2M, H2F</li> <li>• R2M</li> <li>•</li> <li>• PR50</li> <li>• H2M, H2F</li> <li>• R2M</li> </ul>
Nozzle Size:	<b>High Build Primer:</b> <b>Primer-Filler:</b> <b>Sealer:</b>	2.0mm 1.7mm 1.3-1.7mm
Spraying Pressure:	HVLP/RP: 2.0-3.0 bar (30-45 psi) High Pressure: 3-4 bar (45-65 psi)	
Application:	Apply with spray gun using normal spraying motion. Apply two spray coats with a flash time of 5 to 15 minutes.	
		
Flash-Off time:	5 to 15 minutes	
Drying Time:	At 20 C: At 60 C:	3-4 hours 30 minutes
Pot Life at 20 C (68F):	30 minutes	
Sanding	600-800 wet by hand	

	400-500 Orbital sander
Remarks:	As primer filler on flexible plastics always use flexing agent to make it flexible.
Warnings:	Use directly on to TPA thermoplastic acrylics, galvanized sheet, aluminum may result in cracking, lifting, blistering