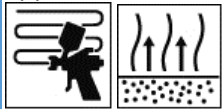


Features:	Versatile Primer, fast drying & good filling properties, easy to sand	
Benefits:	Allows fast throughput in the body shop, ensures good top coat finish	
Recommended Use:	Multi Purpose Primer that has outstanding sanding properties, fast drying and excellent top finish.	
Required Materials:	<ul style="list-style-type: none"> • Karbon Primer • Karbon Hardeners • Karbon Reducer • Mixing stick, mixing container, spray gun 	<ul style="list-style-type: none"> • PR50 • H2M, H2F • R2M
Physical Properties/ Technical Data:	<ul style="list-style-type: none"> • Specific Gravity(kg/l): • Flash Point: • Solids Vol %: • Solids Wt. %: • Coverage m²: • Viscosity (RTS) at 20°C: • Gloss: • Color: • V.O.C. Regulatory RTS (g/L) (less water, less exempts): • V.O.C. Regulatory RTS (lbs/Gal) (less water, less exempts): • Applicable Use Category: 	<ul style="list-style-type: none"> • 1.536 • Closed cup: >25°C (>77°F) • 68.2% • Ca. 8 m²/L at 40 μm • 2" as ready to use • Matt • Grey • 485 g/l • 4.05 lbs/gal • Primer
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"> • High Build Primer 4:1 • 100% by vol. Karbon PR50 Primer • 25% by vol. Karbon Hardeners • Primer Filler 4:1:1 • 100% by vol. Karbon PR50 Primer • 25% by vol. Karbon Hardener • 25% by vol. Karbon Reducer • Primer Filler 4:1:2 • 100% by vol. Karbon Primer • 25% by vol. Karbon Hardener • 50% by vol. Karbon Reducer 	<ul style="list-style-type: none"> • PR50 • H2M,H2F • PR50 • H2M, H2F • R2M • PR50 • H2M, H2F • R2M
Nozzle Size:	High Build Primer: Primer-Filler: Sealer:	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, 65% R.H. :	3-4 hours	
At 60°C, 65% R.H. :	30 minutes	



Hardener Selection Guide:			Temperature Range		
	Product#	Description	+80°F (+26°C)	70°F-80°F (21°C-26°C)	55°F-70°F (12°C-21°C)
	H2S	Slow			
	H2M	Medium			
	H2F	Fast			
Pot Life at 20°C (68°F):	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				
Packaging: Size	1L, 3.5L				
Case Quantity	6, 2				