

# ALPHAGAM

## TECHNICAL DATA SHEET

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PRIMER

**APP10004 2K PU PRIMER SURFACER  
RAL7035**

**2K PU PRIMER SURFACER 4:1 (7035)**

Product Code: APP10004

**PRODUCT INFO**

**2K PU Primer Surfacer** has very good filling properties and is very easy to sand. This filler can be used as compact as well as high-build filler. The combination with **2K PU Etch Primer** allows a very quick processing followed by heat-drying or drying at room temperature. This offers saving potentials in terms of spray booth occupancy, stoving times as well as working time. It is also suitable to fill partial areas (Spot repair) without shrinkage or visible marks in the outer rim.

**Approx Coverage: 6,0 - 7,0 m<sup>2</sup>/l (for 50 - 70 μm DFT)**

**SURFACE PREPARATION**

The substrate must be clean, dry and free from grease. Sand surfaces slightly. Remove old paintworks and priming coats. Prime beforehand bare metal surfaces with Etch Primer. In case of one-layer topcoat use sanding paper P 320 for dry sanding or 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper P 320 for dry sanding and 600/ 800 for wet sanding. Can apply on thermoplastic substrates (eg. Plastic Adhesion Promoter)



**Application Method**

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Gravity spray gun (sanding filler)	2.5 - 3	1.6 - 1.8	2 - 3	0 - 25
HVLP (sanding filler)	2.5 - 3	1.6 - 1.8	2 - 3	0 - 25

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.

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#### Pot life :

50 - 60 min with 1-UP 2K PU MS Fast Hardener @ 30°C  
2h with 1- UP 2K PU MS Standard Hardener @ 30°C



#### Hardener:

*For complete paint work :*

1-UP 2K PU MS Standard Hardener

1-UP 2K PU HS Standard Hardener

*For partial paint work :*

1-UP 2K PU MS Fast Hardener

1-UP 2K PU HS Fast Hardener



#### Thinner:

1-UP 2K PU Standard Thinner @ 0 – 25%

1-UP 2K PU Medium Thinner @ 0 – 25%




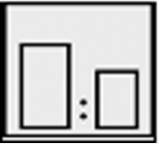

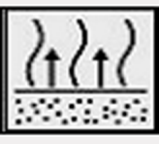

#### Drying time :

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatable
30°C	10 - 15 min	NA	8 h	6 h	NA
60°C (30min)	10 - 15 min	NA	NA	30 min	NA

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**Technical Information**

	<b>Colour :</b> Grey /Off White / Beige (approx. RAL 7035)
	<b>Mixing Ratio :</b> 4 : 1
	<b>Spraying Viscosity :</b> 20 - 22 s 4mm DIN (sanding filler) 25 - 30 s 4mm DIN (high-build filler)
	<b>Flash Off Time :</b> 5 - 8 min between coats 10 - 15 min before oven drying
	<b>Dry Coat Thickness :</b> 50 - 70 µm (sanding filler) 100 - 120 µm (high-build filler)
<b>Storage :</b>	<b>1year from the date of manufacturing at 30° C, if stored in a dark / dry place in a tightly closed container.</b>
<b>VOC Regulation :</b>	EU limit value for this product (category B/c): 540 g/l This product contains max. 500 g/l of VOC.
<b>Processing Conditions :</b>	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.

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