

Technical Data Sheet

PUR PRIMER 320

Polyurethane Primer

RELATED PRODUCTS

PUR HARD-TOPCOAT 120
THIN 50
THIN UNIVERSAL BASIC


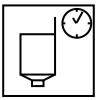
Hardener for 2K polyurethane topcoat
Universal thinner
Thinner


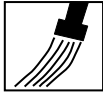



USE

- Means of transport
- Machines and equipment

PROPERTIES

- Perfect hiding power and flowability
 - High yield
 - Perfect filling properties
 - Good chemical resistance
 - Good mechanical resistance
- Possibility of the application up to 150 μm wet in a single layer

SUBSTRATES				
Steel and cast iron	The steel/cast iron substrate shall be dry and free of oils, grease, dust, loose old coatings, milling scale, loose rust and foreign bodies. The surface shall exhibit bare metallic gloss. Mat smooth and shining metallic surfaces with P120 sand paper to produce sufficient substrate roughness.			
Old paint coatings	Mat and degrease. If the coating adheres poorly, remove it completely. Test coat a small area of the old coating. If the dry coat finish is unsatisfactory, remove the old coating completely and pretreat the substrate as instructed above.			
Plastics, except for PP, PE, PTFE and mixtures thereof	Degrease with the PLUS 780 silicone degreaser and mat with an abrasive finishing pad. Degrease again and apply the PLUS 700 adhesion increasing agent and the PLUS 770 elasticity increasing agent.			
Wash primers	Without preparation, after 15 minutes.			
Polyester putties	Dry sand, for final sanding P240 ÷ P320.			
Polyester laminates	Dry sand P280, degrease again.			
Epoxy primers	Up to 12 hours without sanding, sand P320 after 12 hours			
Note: Dry sanding generates dust. Proper respiratory protection is recommended.				
MIXING RATIO				
	Coating method	Product	Volume ratio	Weight ratio
	Airless spraying / filling version	PUR PRIMER 320 PUR HARD TOPCOAT 120 THIN 50/THIN UNIVERSAL BASIC	4 1 10 %	100 14 6
	Pneumatic spraying, rollers, brushes / filling version	PUR PRIMER 320 PUR HARD TOPCOAT 120 THIN 50/THIN UNIVERSAL BASIC	4 1 20 %	100 14 12
	Pneumatic spraying / wet on wet version	PUR PRIMER 320 PUR HARD TOPCOAT 120 THIN 50/THIN UNIVERSAL BASIC	4 1 30 %	100 14 18
VISCOSITY				
	DIN 4/20°C Airless spraying Pneumatic spraying Pneumatic spraying	100 ÷ 120 s (filling version) 40 ÷ 60 s (filling version) 25 ÷ 35 s (wet on wet version)		

VOC CONTENT				
VOC II/B/c limit*		540 g/l		
Actual VOC content		450 g/l (for 4+1+10%)		
		490 g/l (for 4+1+20%)		
		520 g/l (for 4+1+30%)		
* For ready to apply mixture acc. to EU Directive 2004/42/EC				
APPLICATION CONDITIONS				
<ul style="list-style-type: none"> - The substrate shall be dry. - Min. product temperature: +10°C. - The coat, coated surface and ambient temperatures must be between +5°C and +30°C. - The relative humidity must not exceed 80%. - Do not coat at high humidity (e.g. when rain, snow or fog is forecasted), on hot afternoons and/or in strong wind. The application conditions determine the product layer drying time and the developed coating properties. The substrate temperature shall be 3°C higher than the ambient dew point or more.				
APPLICATION				
 CAUTION: Follow the equipment manufacturer's guidelines	Pneumatic spraying	Nozzle	Pressure	Distance
		1.6 - 2.0 mm	3 - 4 bar	15 - 20 cm
	Airless spraying in air jacket	0.33 - 0.38 mm (0.013" - 0.015")	120 - 160 bar Air jacket 2 bar	10 - 15 cm
	Brush	Natural bristle brushes or natural and synthetic bristle brushes are recommended.		
	Roller	Velour and mohair rollers are recommended.		
The spray application parameters depend on the individual performance and requirements of the tool and must be tested prior to coating. Caution! Verify that all corners and edges have been properly coated. Depending on the roller type, the coating may contain air bubbles which burst and form craters during drying.				
	Recommended number of layers	2 - 3		
	CAUTION: If the polyurethane primer is the only primer in the paint coat, its thickness must not be less than 120 µm.			
	Overall wet layer thickness	100 - 150 µm		
	Overall dry layer thickness	50 - 75 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	5.0 m ² /l at 100 µm		
	Flash-off time between layers	10 ± 15 min		

TECHNICAL DATA		
Solids content by weight PUR PRIMER 320 + PUR HARD TOPCOAT 120: 4+1	73 ÷ 75 %	
Solids content by volume PUR PRIMER 320 + PUR HARD TOPCOAT 120: 4+1	53 ÷ 55 %	
Density PUR PRIMER 320 + PUR HARD TOPCOAT 120: 4+1	1,56 ÷ 1,58 g/cm ³	
Mixture life at 20°C	1 h	
Adhesion, EN ISO 2409	1	
Flexibility, EN ISO 1519	min. 16	
Impact strength, EN ISO 6272-1	min. 40	
Corrosion resistance, salt spray test, EN ISO 9227	Good anti-corrosion properties	
Chemical resistance	intermittent (splashes and sprays)	
CURING TIME		
Time to sand. For the max. dry coating thickness of 120 µm.	20°C	60°C
	4 hours	45 min.
CAUTION: The drying time may vary with temperature and/or humidity.		
EQUIPMENT CLEANING		
THIN 50 / THIN UNIVERSAL BASIC.		
STORAGE CONDITIONS		
Store in a dry and cool room, away from sources of fire and heat at 5°C-25°C. Avoid exposure to sunlight.		
SHELF LIFE		
PUR PRIMER 320	24 months/20°C	
PUR HARD TOPCOAT 120	18 months/20°C	
THIN 50 / THIN UNIVERSAL BASIC	24 months/20°C	
SAFETY		
See the Safety Data Sheet.		
OTHER INFORMATION		
Registration number: 000024104.		
The effectiveness of our systems results from laboratory research and many years of experience. The data contained here in meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.		