

CT Coatings Technical Data Sheet



Product Name	AMC 4 - 2K Primer Wet on Wet 2K Surfacers (3713)
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Issue date	22/08/2006
Formula Number	3713
Product code	PRIAMC4

Packaging
AMC 4 Primer is available in a 5 ltr pack size (5 ltrs = 4 ltrs Primer Base + 1 ltr 9004 Std Hardener) AMC 4 Primer is Pale Grey in colour. AMC 4 Primer can be tinted with upto 10% with Acrythane XSC21 topcoat colour.

Product Description & Function
AMC 4 - 2K Polykote Primer is a 2 pack polyurethane wet on wet primer surfacer with very good adhesion and anti-corrosive properties. AMC 4 can be topcoated with HMG 2K topcoats without flattening or may be dried and denibbed. It has very low sinkage properties with superlative flattening properties.
By using this primer, the ultimate gloss finish is possible with the most cost effective process time.



Substrates & Preparation
Aluminium - Scuff with Scotbrite pad or 240g-320g depending on grade of Aluminium. **Must be preprimed with HMG 2K Etch primer (NT2000) or 2K Washfiller (High Build Etch Primer) prior to AMC 4 primer being applied.**
Steel - Sand with P180-P320g
OEM / 2K / Aged Sand with P180-P320g
Synthetic Finishes -
GRP - Sand with P180-P320g being careful not to abrade through the Gel coat.



Cleaning
All surfaces should be pre cleaned prior to preparation and prior to application of primer with a suitable HMG Prep Cleaner.

Application

	HVLP	Pressure Pot	Airless/AirAssisted
Mixing Ratio Base Hardener (see options) Thinner (see options)	4 Parts 1 Part < 1 Part	4 Parts 1 Part < 1 Part	4 Parts 1 part < 0.5 Part
Spray Viscosity	19 - 21secs (DIN 4 @ 20c)		25 - 28 secs (DIN4 @ 20c)
Gun Set Up	1.8 fluid tip	1.1 - 1.4 fluid tip	11 thou / 40 - 50 degree
No of Coats	1 - 2 full coats dependant on application equipment and technique.		1 full coat
Flash Off	10 - 15 mins between coats		
Drying	60 mins @ 20c, 30 mins @ 70c		
Pot Life	approx. 2 hrs		
Film Build	65 microns WFT gives approx. 40 microns DFT		
Overcoating	minimum 30 mins with HMG 2K Topcoats		
VOC (Ready for Use)	<540g/l		

Thinner Options

2601 Thinner	Fast	Dependant on temperature or size of vehicle to enable a Wet Edge to be retained. The choice of correct thinner will give optimum lay down of product and ease of application.
2602 Thinner	Medium	
2603 Thinner	Slow	
2604 Thinner	Extra Slow Thinner	

Hardener Options

XSC21 HS Hardener 9044	High Solids hardener for higher build option
2K Standard Hardener 9004	Standard hardener for medium / large size jobs
Wintermix Hardener 9027	For small to medium size jobs or in cold temperatures.

Technical Information

Solids	Approx. 60% when mixed.
Flashpoint	Between 22 to 32c
Storage	12 Months in Original sealed containers
Equipment Cleaning	HMG Gun Cleaning Thinner
Coverage	15 sq. metres per litre theoretical
VOC (Unmixed)	537 g/l

Special Properties

Compliant as a wet on wet primer surfacer to PG6/34 & CE42

Health & Safety

Refer to "Material Safety Data Sheet" and tin label prior to use.
Wear suitable respiratory equipment.