

CT Coatings Technical Data Sheet



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Product Name	HS Rapidbuild 2K Primer 2K High Build Primer Filler
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Issue date	17/04/2003
Formula Number	
Product code	PRIHSRAP

Packaging
 HS Rapidbuild 2K Primer is available in 5 litre pack size.

Product Description & Function
 HS Rapidbuild 2K PU Primer is ultra high quality primer for high performance applications to Commercial Vehicles. HS Rapidbuild 2K Primer can be used as a first choice primer filler / surfacer under all HMG 2K Topcoats.
 HS Rapidbuild contains high levels of Zinc Phosphate and gives excellent corrosion and impact resistance.
 HS Rapidbuild has been specifically developed to show faster drying and ease of sanding.
 HS Rapidbuild can be used as a surfacer by varying the amount of thinner used.



Substrates & Preparation

Aluminium - Scuff with Scotchbrite 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 HS Rapidbuild primer being applied.**

Steel - Sand with P180-P320g

OEM / 2K / Aged Sand with P180-P320g

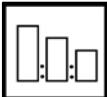





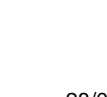
Synthetic Finishes -

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 Thinner (see options)	4 Parts 1 Part 0.5 - 1 Part	4 Parts 1 Part 0.5 - 1 Part	4 Parts 1 Part 0 - 0.5 Part
 Spray Viscosity	25 - 35 secs @ 20c (DIN 4)		
 Gun Set Up	1.8 Fluid tip	1.2 - 1.4 Fluid Tip	11 - 13 thou / 40 - 50 degree
 No of Coats	2 - 3 coats		1 -2 coats
 Flash Off	10 - 15 mins between coats		
 Drying	4 - 6 hrs @ 20c / 30 mins @ 70c		
Pot Life	8 hrs @ 20c		
Film Build	100 microns WFT gives 50 microns DFT		
 Overcoating	Once hard dry and pre flatted using P320 - P500g. Overcoat with any HMG 2K Topcoat system.		
VOC (Ready for Use)	<590 g/l		

Thinner Options

2601 Thinner	Fast
2602 Thinner	Medium
2603 Thinner	Slow
2604 Thinner	Extra Slow Thinner



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.

Hardener Options

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. 55% by weight
Flashpoint	Below 22c
Storage	12 Months in Original sealed containers
Equipment Cleaning	HMG Gun Cleaning Thinner
Coverage	10 sq metres per litre (Theoretical)
VOC (Unmixed)	

Special Properties

Health & Safety

Refer to "Material Safety Data Sheet" and tin label prior to use.

Wear suitable respiratory equipment.

THIS INFORMATION RELATES ONLY TO SPECIFIC MATERIAL DESIGNATED AND MAY NOT BE VALID FOR SUCH MATERIAL USED IN COMBINATION WITH ANY OTHER MATERIALS OR IN ANY OTHER PROCESS. Such information is to the best of HMG's knowledge and belief, accurate and reliable as of the date indicated. HOWEVER, NO REPRESENTATION, WARRANTY OR GUARANTEE IS MADE AS TO IT'S ACCURACY, RELIABILITY OR COMPLETENESS. IT IS THE USERS RESPONSIBILITY TO SATISFY HIMSELF AS TO THE SUITABILITY AND COMPLETENESS OF SUCH INFORMATION FOR HIS OWN PARTICULAR USE. For Professional Use Only.