



TECHNICAL DATA SHEET

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PRODUCT	2K ACRYLIC PRIMER			
MIXING RATIO	MIXING RATIO by weight *	MIXING RATIO by volume	1st COMPONENT	2nd. COMPONENT
	7+1	4+1	312-XXXX	369-0025
DESCRIPTION	Solvent based two pack acrylic polyurethane primer for DTM			
APPLICATION AREAS	It is a primer for metal substrates such as tin plate, galvanize, aluminium etc.			
PROPERTIES	High filler and hiding power Fast curing with a excellent adhesion . Easy sanding High yellowing resistance*			
<i>**: In order to avoid any color changes in the entire process, previous layers should be non-yellowing, as well.</i>				
PHSICAL PROPERTIES	Viscosity (D4/20°C)	70" - 80"		
	Density (g/cm3; 20°C)	1,67±0,02		
DRYING TIME	Pot-Life (hour /20°C, %50 humidity)	max 2 hours	
	Dust Dry (20°C, %50 humidity)	5 - 10 minutes	
	Touch Dry (20°C, %50 humidity)	1 - 1,5 hours	
	Set Dry (20°C, %50 humidity)	24 hours	
	Touch Dry (10 min flash off+ 60°C, %50 humidity)	30 minutes	
DILUTION RATIO	2K Acrylic Primer which prepared according to mixing ratios given above are diluted by Kubilay Acrylic thinner (931-0313) by 30% as weight (%10-15 as volume).			
	312-XXXX	1.Component	7 Part
	369-0025	2.Component	1 Part
	931-0313	Acrylic Thinner	0,25 Part
	*: The expected performance of the product depends on the accuracy of the mixing and dilution process. Since the presentation of the products is made by packing according to the mixing ratio by weight, it is especially recommended to be made by weight by weighing in order to be sensitive to the preparation of the mixture for the application.			
	911-0315 Acrylic slow thinner should be used in hot weather to prevent possible pinhole problem. 911-0314 Acrylic fast thinner can be preferred in winter.			
APPLICATION METHOD :				
Preparation: Before mixing, first component should be stirred well, then first and second component are mixed according to mixing ratio as much as desired amount, mixture is stridded to obtain a homogenous mixture once again. Finally, for adjusting application viscosity, required amount (according to information which is given in mixing ratio) thinner is added by mixing. Make sure a homogenous mixture is obtained before application.				
It is applied directly by spraying on the dry and dust free surfaces previously prepared by cleaned and sanding (180-200). Product which prepared according to mixing ratios given above and is sprayed in one or two cross-wise layers (recommend:~				
When applied as a layer with a thickness of 50-55 microns dry film, 7-10 m2 area can be covered for 1 kg mixture (except for losses).				
Topcoat can be applied after sanding compleated by sand papers first with 180-220 then with 360-400 respectively after 5-6 hours later primer application depending on the ambient conditions.				
STORAGE:				
1st Components will remain stable for at least 12 months and 2nd Component is 6 months when stored in their original packs in a dry place at storage temperatures between 5-35 °C.				
It's recommended to read SDS before applications.				

Important Note: This information is based on our present state of knowledge and is intended to provide general notes on Kubilay Products and their uses. However without guarantee as conditions and methods of end users are beyond our control. We recommend that end users determine the suitability of the materials before adapting them on a commercial scale.