



PRODUCT INFORMATION SHEET

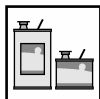
Process 540 2K HS Primer

Description

Tetrosyl Process 540 2K HS Primer is a fast drying acrylic primer for use under basecoats and topcoats. When used with aqua-t basecoat it provides excellent adhesion and appearance. At less than 540 g/L VOC when ready for use, it is fully compliant with all relevant EU legislation for 2007 and beyond.

N.B. Etch Primer is recommended for use on Aluminium and Galvanised surfaces.

Components



| | | | |
|--------------------|------------------|--------------------|--------------------|
| 2K HS Primer | GLG010 (1 litre) | GLG005 (5 litre) | |
| Fast Activator | GPF200 (250ml) | GPF001 (1 litre) | GPF002 (2.5 litre) |
| Standard Activator | GPM001 (1 litre) | GPM002 (2.5 litre) | |
| Thinner | GPT001 (1 litre) | | |



Surface Preparation

Prepare panel before application using Tetrosyl Pre-Wipe degreaser PWD005 to remove any contaminants.



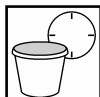
Mixing Instructions (Wet-on-Wet)

Volume: Mix 4 parts Primer with 1 part Activator (Fast or Standard) and 1 part Thinner
 Weights for 1kg: Mix 760g Primer with 130g Activator (Fast or Standard) and 110g Thinner



Mixing Instructions (Primer Filler)

Volume: Mix 4 parts Primer with 1 part Activator (Fast or Standard) and 0.5 parts Thinner
 Weights for 1kg: Mix 805g Primer with 135g Activator (Fast or Standard) and 60g Thinner



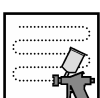
Pot Life (Sprayable Life At 20 - 25°C)

| | |
|---------------------------------------|---------|
| 2K HS Primer with Fast Activator: | 2 hours |
| 2K HS Primer with Standard Activator: | 3 hours |



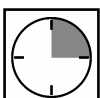
Gun Set-Up

1.6 - 1.8 Tip, 28 - 30 Psi (2 bar) spray pressure



Application

2 full coats with 5 - 10 minutes flash off between coats, 15 minutes flash off at 20 - 25°C before baking.
 Clean with Tetrosyl Gunwash.



Baking / Curing Time

| | |
|-----------|----------------------------------------------------------------------|
| Oven: | 15 - 30 minutes at 60°C metal temperature (depending on film build) |
| Infrared: | 10 - 20 minutes (depending on film build) |
| Air Dry: | Overnight (at least 16 hours at 20 - 25°C). |



Sanding

400 - 500 Dry.
 800 - 1000 Wet.

Availability – GLG010, GLG005, GPM001, GPM002, GPF200, GPF001, GPF002, GPT001

ENVIRONMENTAL PROTECTION/SAFETY PRECAUTIONS

Dispose of empty packs in a responsible manner. Store container in an upright position and secure when transported. Activator contains Isocyanates, wear suitable PPE.

**DISCLAIMER**

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Product Information Sheets are updated from time to time and inquiries should be made on a regular basis to ensure that this is the latest version available.

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