4465 - 2K Rapid Primer White

Product Description

This is a sanding 2K VOC high build primer. 446X series is a fast dry 2K primer with excellent sand ability and gloss holdout. It can be applied directly to plastic parts when combined with plastic additive 8230 and 810 plasticizer.

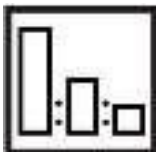
Suitable Substrates:

- Existing Finishes except thermoplastic acrylic
- "General" Polyester Putties/body fillers
- Bare metal substrates must be pre-primed with Etch primer 9700.
- Available colors (Beige 4460, Grey 4462, Black 4463, White 4465, Red 4465, Dark Grey 4466).

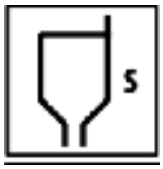
Extra Comments

Stir well before mixing.

Product Application



100%	25%	5-25%
4465	H500 - Fast	S719 - FAST
	H600 - Normal	S711 - NORMAL
		S721 - SLOW



35 sec / DIN 4 mm / 20°C (68°F) @ 5% reducer
18-19 sec / DIN 4 mm / 20°C (68°F) @ 25% reducer
Potlife 45 to 60 min / 20 °C (68 °F)



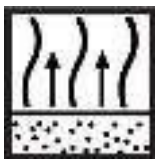
HVLP 1.6 – 1.8 mm
2.0 – 2.5 bar inlet pressure



2-3 coats
50-60 microns/coat

Disclaimer: Users assume full responsibility for any consequences resulting from the incorrect usage of our products.

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	5-6 minutes at 20 °C (68 °F) between coats
	2-3 hours at 20 °C (68 °F) 20 min. at 60 °C (140 °F)
	10 – 15 mn. Medium - long Wave The object should be maintained at greater than 80 cm from source
	Initial Sanding with P400 grit Final Sanding with P500 grit
	Clean Surface using Genclean 8241 degreaser to remove contamination prior to application of top coat.
	GenRock Top Coat Gen_2O Basecoats
	Wear suitable protection

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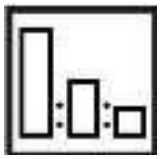
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Tinting the Primer for Limited Opacity Colors

Nb: please refer to genmix comments to select the needed color f the prime that matches with the top coat color.

Process

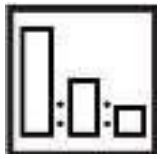
Using the appropriate primer from our range mix:



2:1:1:0.5
Appropriate Primer 2 Parts.
Selected 600 Series Color Formula 1 Part.
Hardener 1 Part.

4465 Primer Direct to Plastics

With the addition of 8230. 4465 can be applied direct to plastics without the need for a 1k plastic adhesion promotor (plastic primer)



100%	15%	25%	5-25%
4465	Plastic Additive 8230	H500 – FAST H600 - NORMAL	S719 - FAST S711 - NORMAL S721 - SLOW

4465 Primer Plasticized:

Soft Plastic Application		
Product	Parts	Weight(g)
4465	100	1633
810	50	501.3
H500/H600	50	513.4/490
S719/ S711	5.0- 25.0	64.0-348.

Hard Plastic Application		
Product	Parts	Weight(g)
4465	100	1633
810	15	150.39
H500/H600	32.5	333.76/ 318.5
S719/ S711	5.0- 25.0	49.0- 266.5

	15-20ºc				20-25ºc				25-30ºc				+30ºc			
	Thinner 711				Thinner 721				Thinner 721				Thinner S2040			
	Hardener	Time to Sanding			Hardener	Time to Sanding			Hardener	Time to Sanding			Hardener	Time to Sanding		
		20ºc	60ºc	IR		20ºc	60ºc	IR		20ºc	60ºc	IR		20ºc	60ºc	IR
Full Paint	H500	2.5 HRS	20 MINS	15 MINS	H500	2.5 HRS	20 MINS	15 MINS	H600	2.5 HRS	20 MINS	15 MINS	H700	2.5 HRS	20 MINS	15 MINS
Vertical Areas	H500	2.5 HRS	20 MINS	15 MINS	H500	2.5 HRS	20 MINS	15 MINS	H500 H600	2.5 HRS	20 MINS	15 MINS	H700	2.5 HRS	20 MINS	15 MINS
Fast Repair	H200 H500	2.5 HRS	20 MINS	15 MINS	H200 H500	2.5 HRS	20 MINS	15 MINS	H500	2.5 HRS	20 MINS	15 MINS	H700	2.5 HRS	20 MINS	15 MINS
soft plastics 30%-810 Plasticizer	H500	3.5 HRS	30 MINS	N/A	H200 H500	3.5 HRS	30 MINS	N/A	H500 H600	3.5 HRS	30 MINS	N/A	H700	3.5 HRS	30 MINS	N/A
Hard plastics	H500	3 HRS	25 MINS	N/A	H200	3 HRS	25 MINS	N/A	H500	3 HRS	25 MINS	N/A	H700	3 HRS	25 MINS	N/A
15%-810 Plasticizer					H500				H600							

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Wet on wet

100%	100%	75%	30%
Primer: 4465	Clear: 6100 or 6000SR	Hardener: H500 H600	Thinner: S719 - FAST S711 - NORMAL S721 - SLOW

Application: 1 light coat followed by 1 full. No flash off in between.
Flash off: 30 minutes before application of topcoating
Spray gun: 1.3—1.4 mm needle size

Product Characteristics

VOC(2004/42/EC):	2004/42/IIB (c) (540)540. The EU limit value for this product (product category IIB.c) in ready to use form is max 540g/ltr. The VOC content of this product in ready for use form is max. 540 g/l.	
Specific Gravity:	4460 = 1633 g/L (13.63 lbs/gal) 4462 = 1633 g/L (13.63 lbs/gal) 4463 = 1465 g/L (12.22 lbs/gal)	4465 =1630 g/L (13.6 lbs/gal) 4465= 1633 g/L (13.63 lbs/gal) 4466 = 1487 g/L (12.41 lbs/gal)
Flash Point:	20-25°C (77°F)	
Solid Content:	67.8 % by weight – ready to spray	
Coverage:	5.7-5.8 m2/l at 80-micron film thickness (theoretical)	
SDS:	Refer to the Safety Data Sheet	

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