



2020

HS PRIMER FILLER

Is a high solids two component acrylic coating, which can be used as multi-role coating:

1. High Solids Filler for spot repairs.
2. Primer Surfacer for large areas
3. A Non Sand (wet on wet) sealer.
4. Tintable up to 10% with acrylic mixing base.

2020 has excellent film build and surface levelling properties.

2020 can be air dried, low baked or I.R. cured.

2020 is easy to sand and gives perfect gloss holdout.

Ready for use V.O.C. value:

2020 HS Primer Filler = 475g/l

Preparation of the surface:

Step:1 Degrease.

Step:2 **Original paint:** Wet flat P320 or Dry flat P280.

Bare metal: Abrade with P120 Steel, aluminium or zinc coated steel.

Apply 2 light coats of ACID #8 1K etch primer, allow to dry for 20 mins.

GRP Glass fibre, Polyester Filler: Dry flat P240.

Step:3 Degrease.

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PRODUCTS

Colour	Beige, Grey or White		
Mixing Ratio	Spray Filler	Primer Surfacer	Wet on Wet Surfacer
2020:2030:2041	3:1	3:1:10%	3:1:20%
Spray Tip	2.0-2.2	1.6-1.8	1.4-1.6
Viscosity DIN 4/sec.	45-55	30-35	20-25
Air Pressure/Bar	4	4	4
Coats	1-2	2-3	1-2
Build/microns.	180	100-120	30-60
Flash Off/min.	15	10	10
Dry to Sand Air/hours	8-10	5-6	2-3
Dry to Sand 60°C/min.	20-30	20-30	0-30
Dry to Sand I.R./min.	15	15	15
Pot-Life/hours	2-3	2-3	2-3
Wet Sanding/abrasive	600-800	600-800	600-800
Dry Sanding/abrasive	320-400	320-400	320-400

Temperature Range for Use of System 20 2030 Series Hardeners

Temp °C	-5	0	5	10	15	20	25	30	35	40	+45
Hardener											
2031											
2030											
2032											
2033											

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