

## 131SR

26.02.2018

### FILL'N'SAND 1K ACRYLIC PRIMER

#### DESCRIPTION

1K primer.  
Colour: grey.  
Composition based on modified acrylic resin.

#### PRODUCTS

131SR	Fill'n'Sand 1K Acrylic Primer
3608S	Thinner
3642S	1K Multi-purpose Thinner
3989S	Retarder

#### PROPERTIES

- Very fast drying.
- Very easy sandability.
- Good filling properties and good adhesion.
- Can be tinted up to 10 % maximum with AM Centari® MasterTints®.
- Ideal spot and panel repair primer
- Recommended to repair thermoplastic acrylic finishes

#### SUBSTRATES










- OEM finishes, including thermoplastic acrylic finishes
- Cured repaired finishes
- Axalta wash primers

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#### PRODUCT PREPARATION

 	<b>Mixing Ratio</b>  131SR 3642S / 3608S (fast)	<b>Maxi</b>		<b>Primer Surfacer</b>		
		Volume 1 0.5	Weight 100 30	Volume 1 0.8	Weight 100 45	
<b>VOC</b>		620-660g/L				
		<b>Pot life at 20°C</b> Not applicable				
		<b>Spray viscosity at 20°C</b> <b>DIN 4</b> <b>FORD 4</b>		25 – 28 s 28 – 30 s	16 s 18 s	
		<b>Spray equipment</b>  Gravity feed Suction feed HVLP Pressure feed		<b>Fluid Tip</b>  <b>Maxi</b> 1.6-1.8 mm - 1.8 mm 1.4 mm		<b>Distance</b>  1.2-1.4 mm 1.5-1.8 mm 1.4-1.6 mm 1.2 mm  15-20 cm 15-20 cm 15 cm 20-25 cm
		<b>Spray pressure</b>  Gravity feed Suction feed HVLP Pressure feed		<b>Spot repair</b> 2-2.5 bar 2-2.5 bar 0.7 bar at nozzle 3 bar		<b>Panel repair</b> 2.5-3 bar 2.5-3 bar 0.7 bar at nozzle 3 bar
		<b>Number of coats</b>		1 - 3	1 - 2	
		<b>Flash time</b> Between coats till flat				
<b>DFT</b>		35 – 100 µm		25 – 50 µm		
		<b>Dry to sand at 20°C</b>		2 h 30 – 45 min		
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.						

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#### SURFACE PREPARATION

OEM and cured repaired finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with correct preparatory cleaner. Wipe dry using clean Sontara® wipes
3. Wet sand with P600 or dry sand with P280 - P320.
4. Clean with a correct final cleaner using clean Sontara® wipes
5. Before priming, wipe dry using clean Sontara® wipes

Treat bare metal spots with 1 coat 825R (see specific TDS).

#### EQUIPMENT CLEANNING

Use a correct solventborne gunwash.

#### RECOATABILITY

At any time after dry to sand.

#### REMARKS

- Reduced 131SR will settle out over time (1 day). It always has to be mixed thoroughly prior to re-use.
- If temperature is above 25°C, replace maximum 5 % of standard thinner by 3989S.
- Material has to be at room temperature (18-25°C) before use.

#### PRODUCT DATA

Package Viscosity: 2000 – 2500 cp  
Theoretical Coverage: 2 -9 m<sup>2</sup>/L at recommended DFT – ready-to-spray

Directive 2004/42/EC: 2004/42/IIB(e) (840)695: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 695 g/l.

#### SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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### FILL'N'SAND 1K ACRYLIC PRIMER

All other products referred to in the paint system build-up are from Cromax<sup>®</sup>. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax<sup>®</sup>, unless explicitly indicated otherwise.

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