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PRODUCT INFORMATION SHEET

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1K PRIMER

Description:

HiChem 1K Primer is a chromate free corrosion protection primer that has outstanding adhesion properties. Specifically designed for panel shop use as a 2 Pack compatible primer surfacer. Can be used as a primer for new parts (over black OEM primer). When applied correctly, can be used as a non sanding primer for parts in good condition.

Uses:

May be used as a primer surfacer of normal film build or as a medium build primer surfacer. High adhesion etch primer for application to steel, galvanised steel, aluminium. May be coated with most solvent based paint systems eg. 2 Pack Colour, Basecoat / Clear coat systems, 2 Pack Iso-Free Acrylic, Acrylic Lacquers, Quick Dry Enamel, QD601 Super Enamel, Auto Enamel, Polyurethane, Epoxy Enamels, 2 Pack Primers.

Properties :

- Rapid drying.
- Easy to sand
- Exceptional adhesion to all common metals.
- Excellent corrosion resistance. Chromate free.
- May be left without topcoat for up to 3 months.
- Colour Beige

Suitable Substrates:

Steel, aluminium, galvanised steel, polyester fillers including *2 Pack Finishing Putty*, and original current vehicle refinishing systems.

Surface Preparation:

Steel: Remove rust, solder and other loose material with grinder, wire brush and mechanical sander. Treat residual rust with *Deoxidiser and Rust Remover*.

Clean the surface with *Prepwash* wax and grease remover.

Galvanised Steel:

Clean and degrease with *Prepwash* while abrading the surface with a coarse abrasive hand pad. Abrade until all shine is removed. Abrade to remove all surface corrosion, tough grime and short term protective coatings. Clean with *Prepwash*.

Aluminium: Thoroughly clean and degrease with *Prepwash*. Abrade with coarse abrasive hand pad. Clean with *Prepwash* again. Aluminium quickly forms a greasy oxide on exposure to air. To maximise adhesion, apply *1K Primer* within 2 hours of cleaning.

Existing Painted Surfaces For new panels with Black OEM finish abrade with fine to medium abrasive pads. For existing paint in sound condition sand with 600-800 grit W&D paper.

Note : Some surfaces may require specific treatments. eg There are different grades of galvanised steel with varying surface treatments. Some have short term protection imparted by a light oil film, others by a polymer film which will not take an etch primer direct. Metal producers issue specifications that may include painting guides for different grades of metal. It is important to consult these guides before issuing painting specifications, especially for larger projects.

Thinning:

For best results use *2 Pack Thinner Normal*. *HiChem Superglow* or *Aclac 20* may be used.

- For use as an etch primer, thin at approximately 70% by volume.
- For use as a medium build primer surfacer, thin at approximately 50% by volume.

Application:

Stir thoroughly before and during use.

Gun sizes: use 1.5-1.7mm when applying as etch primer and 1.7-1.8mm when applying as a medium build primer surfacer.

When used as a medium build primer surfacer, spray 2-3 coats with a 5 minute flash off time between coats. Allow to dry for 30-60 minutes depending on film thickness. Abrade with fine grey abrasive hand pad or 600-800 WD sandpaper. Apply colour coat.

When used as an primer surfacer, spray one light mist coat. Allow 5 minute flash. Then apply a second light coat. Allow to dry for 15-20 minutes.

Caution: *1K Primer* is designed for excellent adhesion to bare metals. It may adversely affect some paint films when it is applied over them eg. some enamels.

Take care when doing touch ups, spot repairs or repaints. Suitable over automotive acrylics, 2 pack epoxy, 2 Pack automotive acrylic-urethanes. Not suitable over Quick Dry Enamels or Auto Enamel. Do not use under Polyester putties. If in doubt test on a small, inconspicuous area.

Recommended Film Thickness: - Approximately 20-25 microns dry film as a medium build primer surfacer.
- Approx. 10-15 micron as primer surfacer.

Drying Time : at approx. 20^o.

Touch Dry-	5 minutes
Dry to handle -	20 minutes
Recoat -	30-60 minutes

Coverage: Approximately 5m²/litre.

Standard Packages :

Product Codes	1 litre	1KP1
	4 litre	1KP4

The information contained in this bulletin is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.