

TWO PACK PRIMER HI-FILL SURFACER



Technical Data Sheet:

04.2024



Product Details:

Product Name:	2K Primer Hi Fill Surfacers – NO REDUCER
Product Description:	<p>PG4648 2K Primer Hi-Fill Surfacers is an <u>extra high build</u> two pack primer surfacer with strong filling power and fine adhesion between coats. Has excellent flexibility and impact resistance that will increase gloss and build up the topcoat.</p> <p>Can be tinted using a maximum 10% 2k Colour from Germatech Colour Wall. Tinted 2k primer can be used to assist as ground coat coverage for transparent colours.</p>

Substrates:



Sanded existing finishes, putty/body filler, fibreglass or primed surfaces including epoxy, 1k or 2k primer.

Direct to sanded galvanised steel or metal - whilst Germa-Tech 2k Primer will adhere directly to metal, in particular on painted repaired surfaces where sections have been rubbed back to bare, adhesion can only be ensured if surface has been first coated with Germa-Tech Epoxy Primer.

Not stainless steel - stainless steel first requires Epoxy Primer.

Surface Preparation:



Remove Wax, Silicon and other contaminants with Germa-Tech Prepsol



Directions For Use:

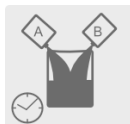
Mixing Ratio:



Mixing Ratio	Primer Surfacer +	Hardener +	Thinner
(Weight)	5	1	NO REDUCER
(Volume)	4	1	NO REDUCER
	GP4648 Grey GP4648B Black GP4648W White	GP4641 (temp <24°C) GP4642 (temp 25°-35°C)	

DO NOT ADD REDUCER, DO NOT EXCEED 3 COATS & 80UM

Pot Life:



Pot-Life at 20 °C

30 Minutes with GP4641 Hardener

Shelf Life:

2 Years in the original sealed can in a cool and dry place at 20°C

Spray Gun Set Up:



Gravity Feed: 1.4-1.8mm HVLP: 2.0-2.5 bar

Suction Feed: 1.7-2.0mm

Conventional: 3-4 bar RP: 2.0-2.5 bar

Coats And Thickness:




Coats & Thickness	2-3 Coats, total 50 - 80um (3 coat maximum) First coat – ½ coat as a dust/tack coat to assist with adhesion Then 1-2 full wet coats
Flash-Off Time	At 23 °C 3-6 minutes between coats (adjust flash off longer or shorter based on climate conditions)
Air-Drying Time	Allow 15-20 minutes air drying time before force drying (must allow full dry time before bake and allow additional time in cold climates)

Drying Time:



Temperature	Time
15 °C	3 Hours
23 °C	2 Hours
60 °C	30 minutes

Sanding Grit: 	Dry Sanding with P400 - P600 Wet Sanding with P600 - P800
Re-Coat:	After drying and sanding, re-coat with all kinds of topcoats.

Additional Information

Package:	4kgs*4 Cans per box.
Notes:	<ol style="list-style-type: none">1. Clean equipment immediately after application.2. Paint mist will dry faster when applied on panels above >25°C.

The information contained in this file 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.