

**ACRYLIC PRIMER 4:1
S-5000**

A two-component acrylic primer with very good filling. Product with increased hardness which perfectly adheres to steel, easy to sand and process. It does not tend to turn yellow over time. The ideal substrate to guarantee the perfect appearance of topcoats.

PRODUCT FOR PROFESSIONAL USE!

PRODUCT COLOUR

- ✓ Graphite.
- ✓ Light grey.
- ✓ Dark grey.
- ✓ Black.

RECOMMENDED USE:

- ✓ Universal application in the automotive industry.
- ✓ Car paint repairs.
- ✓ Levelling the substrate.
- ✓ Filling the substrate to achieve smoothness before applying the topcoat.

TECHNICAL PROPERTIES

- | | |
|--|--------------------------------------|
| ✓ Density (app.): | 1.5 kg/dm ³ |
| ✓ Recommended thickness of a single coat: | 60 µm |
| ✓ Recommended thickness of a single layer | 95 µm |
| ✓ Pot life at 20°C | 1 h |
| ✓ Cure time at 20°C | 3 h |
| ✓ Cure time at 60°C | 30 min. |
| ✓ Theoretical coverage at film thickness 60 µm | 0.09 dm ³ /m ² |
| ✓ The content of non-volatile substances | (approx.) 65% vol/mixture |
| ✓ Recommended number of coats | 2- 3 |

SUBSTRATE

- ✓ Old paint coatings including thermoplastic paints.
- ✓ Polyester fillers.
- ✓ Steel.
- ✓ Stainless steel.
- ✓ Galvanized steel.
- ✓ Aluminium.

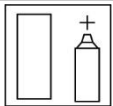
SURFACE PREPARATION

- ✓ The surface should be degreased - free of dirt, oil, grease, dust, old paint coating loosely bound to the substrate, rolling scale, rust and foreign impurities.
- ✓ The coating should be sanded with 120-220 sandpaper, free of grease, dust and corrosion; dry.
- ✓ Steel surface should be dry, free from dirt, degreased, cleaned to a cleanliness degree of at least Sa2 (blasting) for external surfaces. External surfaces can be cleaned to a degree of cleanliness of at least St3 (manual cleaning or cleaning with the use of power tools according to PN-ISO 12944-4).
- ✓ Old paint coats should be degreased and dry sanded with P220-P360 sandpaper.
- ✓ Aluminium surfaces, galvanized should be primed with the RANAL WASH PRIMER (Reactive Primer).

ATTENTION! Use RANAL Silicone remover and RANAL antistatic wipes to degrease the surface. The surface prepared for painting should be dry, free of salt, grease, dust and other impurities.

CONDITIONS DURING PAINTING AND CURING

- ✓ Minimum ground temperature is 5°C and at least 3°C above the dew point.
- ✓ Relative air humidity up to 90%.
- ✓ Efficient ventilation.

MIXING RATIO:

Primer:	4 parts by weight
Hardener:	1 part by weight
Thinner:	15-25%

ATTENTION! We recommend the use of Thinner for primers and bases by RANAL.

WAY OF USE

Mix the components according to the recommended mixing ratio.
When thoroughly mixed and diluted to spray viscosity, apply with a spray gun.

Apply 2-3 wet coats each 60µm thick, with 5-10 min. pause for evaporation after each coat. Evaporation time depends on the temperature and thickness of the layer. 10 min after the application of the last layer, it can be cured at higher temperature.

ATTENTION! Do not use at temperatures below 10°C.

APPLICATION METHOD

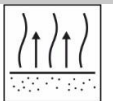
Airless spray, brush, air spray:

Nozzle diameter	1,8 – 2,5 mm
Spraying pressure	2,5 – 3,5 atm

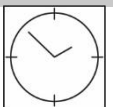
Primer: addition of 15% of solvent – viscosity DIN 4	35 – 40 s
Content of organic volatile compounds (for a ready-to-spray mixture)	VOC = 510 g/l
Filler: addition of 20% of solvent – viscosity DIN 4	22 – 26 s
Content of organic volatile compounds (for a ready-to-spray mixture)	VOC = 540 g/l

POT LIFE WHEN MIXED WITH HARDENER

1 hour at 20°C.

EVAPORATION TIME:

5 – 10 min.

DRYING TIME

3 hours at 20°C.

SANDING:

Mechanical dry sanding: P360– P500
Manual dry sanding: P400– P500



Mechanical wet sanding: P600– P1000
Manual wet sanding: P800– P1000

NEXT COATINGS

Acrylic coats.
Single and multi-layer polyurethane coatings.

CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC II/B/b= 540 g/l
VOC = 510-540 g/l (depending on dilution)

TOOLS CLEANING

Recommendation: NITRO RANAL or Thinner for acrylic products RANAL.

STORAGE CONDITIONS

Shelf life in original container at a temperature of 20°C is:
✓ 24 months for the primer,
✓ 12 months for hardener.
Store in a dark and dry place away from sources of fire and heat.

HEALTH AND SAFETY REGULATIONS

According to the Material Safety Data Sheet for particular product.

PACKAGING

ITEM NO	TYPE	CAPACITY (KG)	PACKAGING (PCS)	PACKAGING (KG)
10365-1	white	1 L + 0,25 L hard	6	11,9
10366-1	black	1 L + 0,25 L hard	6	11,9
10364-1	gray	1 L + 0,25 L hard	6	11,9

The information given is based on careful laboratory research and many years of experience. Strong market position does not absolve us from constant control of the quality of our products. However, we are not responsible for the final results after incorrect use of the product.