

**TECHNICAL DATA SHEET**

## Acrylic primer SET 4+1 HS

Filling primer based on acrylic resins with increased content of solids. Ready to use immediately after adding the hardener. The product is characterized by good adhesion to various substrates and short drying time. Easy to process, has excellent sandability and good filling properties - it is an ideal ground that guarantees perfect appearance of coated surfaces.

**FOR PROFESSIONAL USE!**

### GROUND TYPES:

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- ◆ Old paint coats including thermoplastic paints;
- ◆ Polyester putties;
- ◆ Steel;
- ◆ Stainless steel;
- ◆ Galvanized steel;
- ◆ Plastics;
- ◆ Polyester laminates;
- ◆ Epoxy primers;
- ◆ Wash primers.

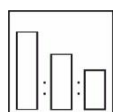
### SURFACE PREPARATION:

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- ◆ old paint coats should be degreased and dry sanded with P220 - P360 paper, dusted off and degreased,
- ◆ polyester putties for final evening should be dry sanded with P240 - P320 paper, dusted off and degreased,
- ◆ steel surfaces should be degreased and dry sanded with P120 - P240 paper, dusted off and degreased,
- ◆ aluminum surfaces should be degreased, matted with abrasive needle cloth and degreased again,
- ◆ galvanized surfaces should be degreased and matted with very fine abrasive needle cloth and then degreased again.
- ◆ stainless steel should be degreased,
- ◆ plastic surfaces should be washed with Silicone remover RANAL and matted with abrasive needle cloth. Degrease again and use Adhesion increasing agent and Elasticity increasing agent RANAL
- ◆ polyester laminates should be degreased and dry sanded with P280 paper, dusted off and degreased.

**TECHNICAL DATA SHEET**

**MIXING RATIO:**



Primer  
Hardener

By volume  
4  
1

By weight  
100  
16

Thinner

0% - 10%

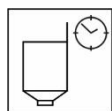
0-6

**ATTENTION!** Add the correct amount of thinner per primer. We recommend the use of Thinner for acrylic products RANAL.

**INSTRUCTION FOR USE:**

Mix carefully the components before use. Apply 2-3 wet coats, each coat 50-60 µm thick, with 5-10 minutes pause for evaporation after each coat. Evaporation time depends on temperature and thickness of the coat. 10 min. after the application of the last coat, it can be hardened in higher temperature.

**SPRAYING VISCOSITY:**



**Filling system:**

0% of the Thinner for acrylic products RANAL  
DIN 4/20°C app. 42 s, Ø 1,6-1,8 mm, 2-4 bar

**Priming system:**

5% of the Thinner for acrylic products RANAL  
DIN 4/20°C app. 30 s, Ø 1,6-1,8 mm, 2-4 bar

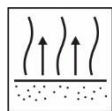
**SPRAYING NOZZLE, WORKING PRESSURE:**

Ø 1,6-1,8 mm, 2-4 bar



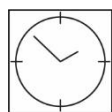
**ATTENTION!** Layer thickness about 50 – 60 µm each coat.

**EVAPORATION TIME:**



5 – 10 min.

**DRYING TIME:**



At the temperature of 20°C: 2,5 h

At the temperature of 60°C: 30 min., for the thickness of 150-180 µm

**TECHNICAL DATA SHEET****SANDING:**

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



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

**CONTENT OF VOLATILE ORGANIC COMPOUNDS:**

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VOC II/B/c = 540 g/L, VOC = 510 g/L

**AVAILABLE COLOURS:**

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According to specification.

**THEORETICAL EFFICIENCY:**

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1 litre of the primer allows to obtain about 5,5 m<sup>2</sup> of the dry coat 120 µm thick.

**TOOLS CLEANING:**

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NITRO or Thinner for acrylic products RANAL

**STORAGE CONDITIONS:**

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Store in a dark and dry place away from the sources of fire and heat. Shelf life of the product in original package at 20°C is 24 months from the date of production for the primer, and 12 months for the hardener.

**HEALTH AND SAFETY RECOMMENDATIONS:**

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According to Safety Data Sheet of Dangerous Substance for particular product.

This information 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.