

**TECHNICAL DATA SHEET****HS HIGH BUILD  
filling primer**

Two-component acrylic primer with very good filling properties. A product of increased hardness, perfectly adhering to steel, well sandable and easy to process. It has very good filling properties. The ideal substrate to guarantee the perfect appearance of topcoats.

**FOR PROFESSIONAL USE!**

**SUBSTRATE:**

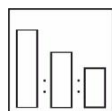
- ◆ old paint coats including z thermoplastic paints,
- ◆ polyester fillers,
- ◆ steel,
- ◆ galvanized steel,
- ◆ aluminium,
- ◆ plastics,
- ◆ polyester laminates,
- ◆ epoxy primers,
- ◆ reactive primers (wash primers).

**GROUND PREPARATION:**

- ◆ old paint coats should be degreased and dry sanded with P220 - P360 paper, dusted off and degreased,
- ◆ polyester fillers should be dry sanded with P240 – P320 paper for final smoothing, dusted off and degreased
- ◆ steel surfaces should be degreased and dry sanded with P120 - P240 paper, dusted off and degreased
- ◆ aluminium surfaces should be degreased and matted with an abrasive cloth, and degreased again,
- ◆ galvanized surfaces should be degreased and matted with a very fine abrasive cloth, dusted off and degreased again,
- ◆ stainless steel should be degreased,
- ◆ plastic surfaces should be wiped with Silicone Remover RANAL and with an abrasive cloth. Degrease again and apply 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:



	By volume	By weight
Primer	4	100
Hardener	1	15
Thinner	15% - 20%	6 - 11

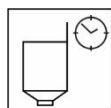
### ATTENTION!

- ◆ Acrylic thinner RANAL is recommended.
- ◆ Pot life of the mixture of primer and hardener is 1h.

### INSTRUCTION FOR USE:

Mix the components carefully before application. Apply 2 - 3 wet layers, each 50-60µm thick, with evaporation time of 5-10 min. after each layer. Evaporation time depends on the temperature and layer thickness. 10 minutes after the application of the last layer the coat can be cured at higher temperature.

### SPRAYING VISCOSITY:



#### Filling system:

15% Acrylic thinner RANAL  
DIN 4/20°C app. 35-40s, Ø 1.6-1,8mm, 3-4 bar

#### Priming system:

20% Thinner for primers and bases RANAL  
DIN 4/20°C app. 23-26, Ø1,6-1.8mm, 3-4 bar

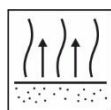
### SPRAY GUN NOZZLE, WORKING PRESSURE:

Ø1.6-1.8mm, 3-4 bar



**ATTENTION! Layer thickness app. 50 – 60 µm of each one.**

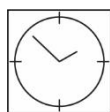
### EVAPORATION TIME:



5 – 10 min.

**TECHNICAL DATA SHEET****DRYING TIME:**

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At the temperature of 20°C: 3 hours

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

**SANDING:**

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Dry mechanical sanding: P360 – P500

Dry manual sanding : P400 – P500



Wet mechanical sanding: P600 – P1000

Wet manual sanding: P800 – P1000

**CONTENT OF VOLATILE ORGANIC COMPOUNDS:**

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

**AVAILABLE COLOURS:**

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Grey, Black, White

**THEORETICAL PERFORMANCE:**

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1 litre of the primer allows obtaining app. 6 m<sup>2</sup> of a dry film 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. The shelf life 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.

**PACKAGING**

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Item No	Capacity	Package, pieces	Package weight, kg
10503 (grey)	0,8 l		
10519 (white)	0,8 l		
10520 (black)	0,8 l		

**TECHNICAL DATA SHEET**

10507 (hardener)	0,2l
10503-0 (compl. primer. grey +hard.)	0,8+0,2 l
10519-1 (compl. primer. white +hard.)	0,8+0,2 l
10520-1 (compl. primer. black +hard.)	0,8+0,2 l

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.