

2K Primer Filler / 2K Primer / 2K Wet – on – Wet - Filler

Product Category: **C 2.3**

Fields of use

As Primer Filler

2-component primer filler with special anti-corrosive properties for direct use on metal substrates (steel, aluminum, galvanized steel as per quality standard of the automotive industry).

As Primer:

Two-component primer to be used as corrosion protection under R-M primer filler or sealer.

As Wet – on – Wet - Filler:

2-component Wet – on - Wet – Filler with special anti-corrosive properties for an efficient application. Direct to use on metal substrates (steel, aluminum, galvanized steel as per quality standard of the automotive industry).

Additional Information

No need to sand new e-coated parts.

No combination with additives to accelerate the drying (e.g. SPEEDFLASH) possible.

The filler hardeners D 70 / D 80 cannot be used in this product.

Use on plastic substrates in combination with FLEXPLO additive is possible (see A 1.6.5).

Technical characteristics

Solids content 73 % ± 2	Density 1.638 g/cm ³
Storage temperature min. 5°C to max. 45°C	Shelf life 24 months

Application

As Primer Filler

Stir well before use. For efficient application, apply the product with ½ + 1 spray coats. For higher build, you can also apply it with 2-3 spray coats reaching an overall film thickness of up to 120 µm.

Air drying requires a minimum temperature of +15°C.

As Primer:

There is only a thin covering spray coat required.

As Wet – on – Wet - Filler:

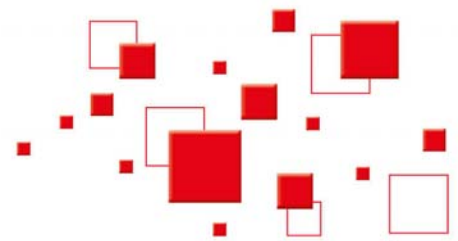
For an efficient application, apply the product with ½ + 1 spray coat. At first, the putty area is covered with ½ spray coat.

Then the complete repair area is covered with 1 spray coat.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.mpaint.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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Substrate / Pre-treatment / Cleaning

Metal substrates (steel, aluminum, galvanized steel as per quality standard of the automotive industry)

Clean with PK 700 or PK 900.

Sanding (steel with P80, aluminum with P150-P180, galvanized steel and solvent-resistant old paintwork with P240).

Clean with PK 1000.







Plastic substrates

Clean with PK 1000



Sanding (replacement body panel with abrasive pad, damaged panels with P400)

Clean with PK 1000

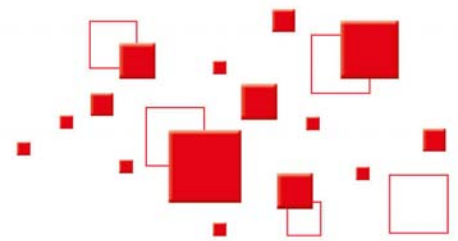
2K Primer Filler

	DIRECTFILLER GREY D 701 FR 500 / R 2100 / R 2200 / R 2300	100% by vol. 20% by vol. 20% by vol.	100 g 13 g 11 g
	Viscosity at 20°C: ISO 4 cup: DIN 4 cup:	40 to 50 seconds 18 to 20 seconds	
	Potlife: 90 min. at 20°C		
	HVLP gravity-feed spraygun Compliant gravity-feed spraygun	1.7 – 1.9 1.6 – 1.8	0.7 bar at the nozzle 2.0 – 2.5 bar
	Spraycoats: Film thickness:	½ + 1 50 – 70 µm	½ + 2 80 – 120 µm
	Drying at 20°C: Drying at 60°C:	12 hours 35 min.	12 hours 45 min.
	(short wave)	10 min.	15 min.

Finishing

	dry P400 – P500
	wet P800

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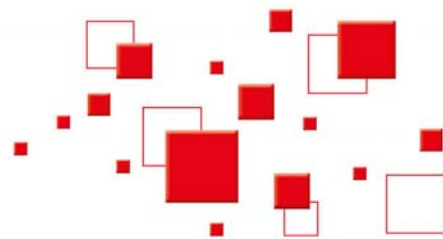
2K Primer

	DIRECTFILLER GREY D 701 FR 500 / R 2100 / R 2200 / R 2300	100% by vol. 20% by vol. 20% by vol.	100 g 13 g 11 g
	Viscosity at 20°C: ISO 4 cup: DIN 4 cup:	40 to 50 seconds 18 to 20 seconds	
	Potlife: 90 min. at 20°C		
	HVLP gravity-feed spraygun Compliant gravity-feed spraygun	1.3 – 1.7 1.3 – 1.7	0.7 bar at the nozzle 2.0 – 2.5 bar
	Spraycoats: Film thickness:	1 thin coat (covering) 10 – 20 µm	
	Flash-off time at 20°C	10 – 15 min.	

Finishing

After flash-off time, apply R-M primer filler or sealer. When the flash-off time exceeds 24 hours at 20°C, denib the surface before primer filler or sealer will be applied.

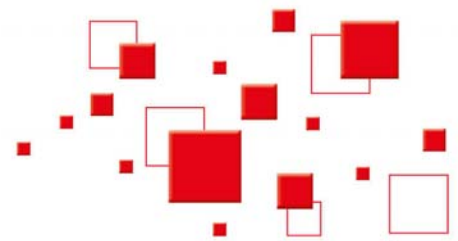
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2K Wet – on – Wet - Filler

	DIRECTFILLER GREY D 701 FR 500 / R 2100 / R 2200 / R 2300	100% by vol. 25% by vol. 25% by vol.	100 g 16 g 14 g
	Viscosity at 20°C: ISO 4 cup: DIN 4 cup:	25 to 50 seconds 15 to 20 seconds	
	Potlife: 90 min. at 20°C		
	HVLP gravity-feed spraygun Compliant gravity-feed spraygun	1.3 1.3 – 1.4	0.7 bar at the nozzle 2.0 bar
	Spraycoats: Film thickness:	$\frac{1}{2} + 1 = \frac{1}{2} \times \text{putty area} / 1 \times \text{whole repair area}$ 30 – 40 µm	
	Flash-off time at 20°C	25 – 30 min.	

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2K Wet – on – Wet – Filler for plastics

	DIRECTFILLER GREY D 701 FLEXPRO	100% by vol. 25% by vol. 25% by vol.	100 g 16 g 14 g
	Viscosity at 20°C: ISO 4 cup: DIN 4 cup:	25 to 50 seconds 15 to 20 seconds	
	Potlife: 90 min. at 20°C		
	HVLP gravity-feed spraygun Compliant gravity-feed spraygun	1.3 1.3 – 1.4	0.7 bar at the nozzle 2.0 bar
	Spraycoats: Film thickness:	$\frac{1}{2} + 1 = \frac{1}{2} \times$ putty area / 1 x whole repair area 30 – 40 µm	
	Flash-off time at 20°C	25 – 30 min.	

Safety instructions

2004/42/II(B)(cl)(540)539: The EU limit value for this product (product category: IIB.cl) in ready-for-use form is max 540 grams of VOC per liter. The VOC content of this product is 539 g/l.

It cannot be ruled out that this product contains particles < 0.1 µm.

The products are suitable for professional use only.

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.