

# MULTI Purpos-R Grey



**P 2P63**

Variant for primer filler application for B 2P13 SPRAY Bodyfill-R.

**Application:** Pioneer Series - eSense undercoat solutions.

**Key Features:** eSense DTM, grey

**Storage temperature** 5-45 °C

**Shelf life** 24 months



## Cleaning

Clean the surface with MULTI Clean-R before applying MULTI Purpos-R Grey.

## Handling

### Product is suitable on

- Sheet steel
- OEM parts with e-coat
- Old paintwork



### PK 2P50 PRO Prep-R and P 2P63 MULTI Purpos-R Grey needed on bare

- Galvanised sheet steel
- Aluminium

## Safety advice:

**2004/42/IIIB(c I)(540)539:** The EU limit value for this product (product category: IIB.c I) 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.

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.

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	<b>4:1:1</b>	
	<b>Mixing Ratio</b>	100 % by volume P 2P63 eSense DTM, grey
	<b>Hardener</b>	25 % by volume H 2P60 eSense MULTI Purpos-R hardener
	<b>Thinner</b>	25 % by volume R 2P20 eSense undercoat thinner, medium R 2P15 eSense thinner, fast R 2P25 eSense thinner, medium R 2P35 eSense thinner, slow
	<b>Spray viscosity at 20°C</b>	DIN 4: 15-20 s ISO 4: 25-50 s
	<b>Potlife at 20°C</b>	90 min

	 HVLP spray gun	 Compliant gravity-feed spray gun
<b>Application pressure</b>		2 bar
<b>Nozzle pressure</b>	0.7 bar	
<b>Nozzle size</b>	1.7-1.9	1.6-1.8
<b>Number of spray coats</b>	2	
<b>Flash off at 20°C</b>	Flash off between spray coats until mat, no flash off before drying.	
<b>Film thickness</b>	40-50 µm	

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## Drying



**Drying at 60°C** 60 min



**Infrared (short wave)** 15 min  
(4 min 15°C/min up to max. 60°C and 11 min 20°C/min up to max. 80°C)



**Orbital sanding, dry** P400

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.



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