



Technical Data Sheet

Primer Filler




Product: Automotive Art Warp Speed HS Primer, 45-85

Features:	Automotive Art Warp Speed HS Primer is a fast drying, high build LOW VOC Primer that is the ideal solution for spot or full panel repairs on all types of surfaces.
Benefits:	<ul style="list-style-type: none"> Fast Drying High Build Easy to Sand Grey Color Simple 4:1:1 mix ratio Same Universal hardeners as with 2:1 clears Low VOC
Recommended Use:	Fast drying HS Primer Filler that can be sanded in under 1 hour at room temperature. Can be used on many types of surfaces, including: directly on steel, galvanized steel, aluminium or fiberglass steel or on old paintwork.
Materials for the job:	<ul style="list-style-type: none"> Automotive Art Express Primer Filler 45-85 Automotive Art Hardener (2.1 voc) 30-76, 30-86 National Rule 30-72, 30-82 Automotive Art Reducer (2.1 voc) 35-55, 35-60, 35-65 National Rule 35-10, 35-20, 35-30 Mixing stick, mixing container and spray gun
Physical properties:	<p>Specific gravity (kg/l): 1.59</p> <p>Flash point: Closed cup: 16°C (60.8°F)</p> <p>Vol.% solids RTS: 52%</p> <p>Coverage: Ca. 8 m²/L/40 µm.</p> <p>Viscosity RTS DINCUP 4mm/20°C: 12 Sec DIN Cup 4</p> <p>Gloss: Matt</p> <p>Color: Grey</p> <p>V.O.C. (RTS): 249 g/l</p>
Pretreatment:	<p>Clean with Automotive Art Wax & Grease Remover 20-95</p> <p>Sand surface to promote adhesion and clean one more time with Universal Cleaner</p>
Cleaning the equipment:	Lacquer Thinner 60-4
Shelf Life:	Under normal storage conditions minimum two years (unopened tins).
Mixing ratio: Hardener	<p>4 : 1 : 1</p> <p>100% by vol. Automotive Art Primer Filler 45-85</p> <p>25% by vol. Automotive Art Hardener (2.1 voc) 30-76, 30-86 National Rule 30-72, 30-82</p> <p>25% by vol. Automotive Art Reducer (2.1 voc) 35-55, 35-60, 35-65 National Rule 35-10, 35-20, 35-30</p>



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Nozzle size:	Gravity gun: HVLP: 1.6 -1.8 mm Suction gun: HVLP: 1.7 -1.9 mm	High Pressure suction: 1.8 - 2.0 mm
Spraying Pressure:	HVLP/RP: 2.0-3.0 bar (30-45 p.s.i.) See manufacturer info	High Pressure: 3-4 bar (45-65 p.s.i.)
Application: 	Apply with spray gun using normal spraying motion. Apply two spray coats with a <i>flash off</i> time of 0 - 5 minutes.	
Drying time: At 20° C At 60° C IR short wave 	1 hour 30 minutes 5 minutes Can be sanded in 1hr at 20 Deg C	
Guide Color:	Refer to Guide Color Application.	
Sanding: 	P 600-800 Wet by hand	P 400-500 Orbital sander
Pot life at 20° C:	30 min – 1 hour	
Warnings:	Can be sanded in 1hr at 20 Deg C	