



CL420

2K HIGH PRODUCTIVE HS PRIMER

Description

2-component high solids primer.

Colour: medium grey.

Composition based on functional acrylic copolymer.

Products

CL420 2K High Productive HS Primer

CL650 HS Hardener Medium

CL640 Hardener Fast

CL680 Hardener Slow

CL705 Reducer Fast

CL710 Reducer Medium

Properties

- Easy to apply, smooth flow.
- Very high productive primer: easy wet and dry sandability after 1 hr air dry, very short flash time between coats.
- Very easy to sand, many days after application.
- Superb filling.
- Can be coated with CHALLENGER[®] topcoat.

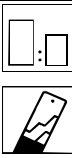




Substrates

- OEM finishes.
- Cured repair finishes.
- Sanded putties.

CL420

2K HIGH PRODUCTIVE HS PRIMER



PRODUCT PREPARATION

	Mixing ratio		Standard (CL660)		Standard (CL650)		Very fast (CL640)		
			Volume	Weight	Volume	Weight	Volume	Weight	
		CL420	4	100	4	100	4	100	
		CL640	1	18	-	-	-	-	
		CL650	-	-	1	18	-	-	
		CL680	-	-	-	-	1	18	
	CL705/710	0.25-0.5	4-8	0.25-0.5	4-8	0.25-0.5	4-8		
	VOC (2004/42/EC)	576 g/l							
	Potlife at 20°C	With CL650/660	1 hr			-			
		With CL640	-			30 min			
	Spray viscosity at 20°C	DIN 4	17 s						
		FORD 4	17 s						
		AFNOR 4	20 s						
	Spray equipment		Fluid tip		Distance		Pressure		
		Conventional guns							
		Gravity feed	1.4-1.8 mm		20-25 cm		3-4 bar		
		Suction feed	1.6-1.8 mm		20-25 cm		3-4 bar		
		Pressure feed	1.0-1.2 mm		20-25 cm		3-4 bar		
		Compliant guns (HVLV/HTE)							
		Gravity feed	1.4-1.7 mm		15-20 cm		According to supplier's specifications		
		Suction feed	1.6-1.8 mm		15-20 cm				
		Pressure feed	1.0-1.2 mm		15-20 cm				
	Number of coats	1-3					1-3		
		Flash time	Between coats till flat. 10 min before bake.					Between coats till flat. 10 min before bake.	
DFT			50-100 µ					50-100 µ	

CL420

2K HIGH PRODUCTIVE HS PRIMER

PRODUCT PREPARATION (con'd)

	Dry to sand	at 15°C	2 hr	1-2 hr
		at 20°C	1 hr	1 hr
		at 40°C	30 min	30 min
		at 60°C	25 min	25 min
	IR-drying*	Distance	80 cm	* Guideline for short / medium wave IR equipment
		Half power	5 min	
		Full power	15-20 min	

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

RECOMMENDED USE

Surface preparation

Before applying CL420, clean the surface, sand and degrease properly.

Remarks

- Do not use activated CL420 beyond the pot life nor reduce it further to get viscosity down again.
- If CL420 is applied over thermoplastic acrylic finishes, complete panel or overall car has to be treated. Spot repairing or sand throughs of the primer can result in spot marking or lifting when applying a basecoat.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.



CL420

2K HIGH PRODUCTIVE HS PRIMER

RECOMMENDED USE (con'd)

Remarks (con'd)

- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

Product data

Package viscosity: 2500-3000 cp (at 5 rpm)
900-1200 cp (at 20 rpm)
Theoretical coverage: 7 m²/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
CL420	1	2	1.330
CL640	1	2	0.986
CL650	0.25 - 0.5 - 1	2	0.959
CL680	0.5	2	0.972
CL705	1	2	0.874
CL710	1	2	0.901

Safety

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.