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TECHNICAL DATA SHEET

AT825 2K WET ON WET PU PRIMER SURFACER

EFFECTIVE: AUGUST 2020

Product Description

AT825 2K WET ON WET PU Primer Surfacer is a Refinish Quality, high performance "HIGH solids", 2K Acrylic Polyurethane Primer Surfacer specifically designed for WET ON WET applications when fast spot & panel repairs are needed or over new fully cured electrocoat panels which require priming prior to basecoat or topcoat application. This product gives fast drying, excellent filling properties & appearance under all basecoats & topcoat Systems. It is specifically formulated to meet the high-performance requirements of today's Refinish Quality Solventborne & Waterborne Basecoat & 2K Low baked Enamel Topcoat systems. This product gives high build film build in one coat applications, fast drying, no need to sand prior to topcoat if applied as wet on wet and delivers excellent adhesion & gloss holdout qualities. AT825 is based on the latest acrylic-isocyanate technology.

Products

- AT825: 2K WOW PU Primer Surfacer
- AT825: 2K WOW PU HARDENER
- AT650 AT650 Reducer

Properties

- High solids
- Excellent and reliable application properties
- Wet on Wet Application, Fast Drying, can be airdried, low baked or infra-red cured
- Excellent sanding and filling properties
- Excellent appearance
- Good vertical stability (Sag Resistance)
- Excellent topcoat holdout
- Suitable for use under all Solventborne & Waterborne Basecoat & 2K Topcoats



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Products Use

AT825 is recommended for use under Refinish Grade SB & WB Basecoats & 2K Low Baked Enamel Topcoat Systems as well as Acrylic enamel and Iso Free systems. This product can be used for motor vehicle refinishing, commercial vehicles, construction machinery, agricultural equipment, and furniture. This product can be applied over properly prepared & primed steel, galvanised steel, aluminium (hard & soft), primed & unprimed fibreglass (also GRP & SMC), cured OEM coatings, polyester putties, and ABS plastics as well as MDF Chipboard & solid wood. Note: It is always recommended to check performance over plastics before proceeding.

Gloss

Semi-gloss

Colours

Grey

Substrates

- Properly sanded or blasted steel, Cleaned & sand "NEW" panels (OEM E'coat)
- Properly cleaned or sanded aluminium
- Galvanized steel or stainless steel
- 1K & 2K Etch Primers
- 2 Pack Epoxy Primers
- Cured topcoats, polyester putties, wood and some plastics (please refer to your Technical Representative if further data is required)
- MDF/Chip Board & Solid Wood
- Fiberglass (Gelcoat, SMC)
- Thoroughly degreased, unsanded or lightly sanded cured E-coat
- Original or old paintwork (except reversible substrates, Example: Acrylic lacquer)

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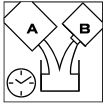
Surface preparation

- Degrease, sand, clean and dry
- For MDF/ Chip board and wood, clean with air pressure only, do not degrease






Mixing ratio

	Products	By weight	By volume
	AT825 PART A	100	4
	AT825 PART B	21.8	1

Pot life

	Temperature (°C)	10	20	40
	Time (h)	3	2	1

Application

Spray Equipment	Application viscosity T-4 at 20°C (S)	Thinner (%)	Spray Nozzle (mm)	Pressure (Bar)	Number of coats
 Gravity feed	18-20	0~10	1.6~1.8	1.5~3.0	1-2
 HVLP	18-20	0~10	1.5~1.9	0.7	1-2
 Electrostatic	According to the advice of the Technical Representative				
 Flash time between coats	10 min				
 Flash time before baking	5~15 min				
Recommended Dry Film Thickness	25~50 microns				



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Drying

Dry Type	Dust Dry	Dry to handle & Apply Topcoats	Hard dry
Air Drying at 25°C	10 min	20 min	4 h
Force Drying at 60°C	30 min		
Infra-Red	5 -10 min depending on wavelength		

Physical Data (Please check)

	PART A	PART B	RTS
Weight Solid	60.7%	50.5%	58.7%
Volume Solids	43.0%	46.7%	43.7%
Density	1.26 Kg/L	1.05 Kg/L	1.22 Kg/L
Flash Point	23°C	3°C	3°C
Theoretical Coverage	6.8 m ² /litre at 80 microns DFT (RTS)		
VOC	540 g/litre (RTS)		

Shelf life

- AT825 PART A: 24 months
- AT825 PART B: 24 months
- AT650 REDUCER: 48 months

The shelf life quoted is based on the shelf life of the product in full and sealed original containers within the normal ambient temperature conditions and other specified requirements.

Safety


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



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Remarks

	Stir the paint thoroughly each time before use, Stir the mixture well after the weigh-out of the components,
	Surface temperature must always be a minimum of above 3°C (5°F) dew point,

Information

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since BC COATINGS cannot anticipate all variations in actual end-use conditions BC COATINGS makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.

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