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TECHNICAL DATA SHEET

AT820 2K HS PU PRIMER SURFACER

EFFECTIVE: AUGUST 2020

Product Description

AT820 2K HS PU Primer Surfacer is a Refinish Quality, high performance “HIGH solids”, 2K Acrylic Polyurethane Primer Surfacer specifically designed to give 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 extra film build, fast drying and sanding properties and delivers excellent adhesion & gloss holdout qualities. AT820 is based on the latest acrylic-isocyanate technology.

Products

- AT820: 2K HS PU PRIMER SURFACER
- AT8201 2K PU GTSR FAST PRIMER HARDENER
- AT8202 2K PU MEDIUM PRIMER HARDENER
- AT8203 2K PU SLOW PRIMER HARDENER
- AT650: ALL PURPOSE 2K REDUCER FAST
- AT651 ALL PURPOSE 2K REDUCER MEDIUM

Properties

- High solids
- Excellent and reliable application properties
- Fast Drying, can be airdried, low baked or infra-red cured
- Excellent sanding and filling properties
- Excellent appearance
- Good vertical stability (Sag Resistance)



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- Excellent topcoat holdout
- Suitable for use under all Solventborne & Waterborne Basecoat & 2K Topcoats

Products Use

AT820 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

Matte

Colours

Grey

Substrates

- Properly sanded or blasted steel
- Properly cleaned or sanded aluminium
- Galvanized steel or stainless steel
- 1K & 2K Etch Primers
- 2 Pack Epoxy Primers

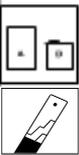
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- Cured topcoats, polyester putties, wood and some plastics (please refer to your Technical Representative if further data is required)
- MDF/Chip Board & Solid Wood
- Fiberglass (Gelcoat, SMC)
- Thoroughly degreased, unsanded or lightly sanded cured E-coat
- Original or old paintwork (except reversible substrates, Example: Acrylic lacquer)

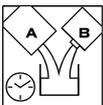
Surface preparation

- 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
	AT820 PART A	100	4
	AT820 PART B	18.6	1

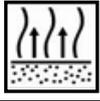
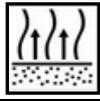
Pot life

	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	20~22	0~10	1.6~1.8	1.5~3.0	2
 HVLP	20~22	0~10	1.5~1.9	0.7	2

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	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		80~200 microns

Drying

Dry Type	Dust Dry	Dry to handle	Hard dry
Air Drying at 25°C	10 min	30 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	71.6%	50.5%	66.0%
Volume Solids	55.3%	46.7%	52.5%
Density	1.48 Kg/L	0.96 Kg/L	1.44 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)		



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Shelf life

- | | |
|-----------------------|-----------|
| • AT820 PART A: | 24 months |
| • AT820 HARDENERS: | 24 months |
| • AT650 REDUCER CODE: | 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

- | |
|---|
| <ul style="list-style-type: none">• Consult the Safety Data Sheet prior to use• Observe ALL the precautionary notices displayed on the container |
|---|

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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