

1543 STAR PRIME HT

TWO-PACK MULTI-PURPOSE ACRYLIC PRIMER



Two-component



Spray

Advantages

- 2 in 1: filling and wet-on-wet primer
- Excellent anticorrosion effect
- Very low absorbin

Description and Use

STAR PRIME HT is a primer for spray application having a high solid content; it features high filling power, very quick drying, excellent anticorrosion effect, easy dry and wet sanding. It can be applied on iron surfaces, polyester putties and existing paints.

The very low absorbing power and the excellent adhesion will give as result a final enamel film smooth, bright and firmly adhering to the surface.

When applied on galvanized steel and light alloys, it is suggested to use EPOKAR PRIMER code 1385 or UNIPRIMER SPRAY code 2001.

The product can be used on "wet-on-wet" cycles by adding a special additive.

Substrate preparation

POLYESTER PUTTIES:

- Sandpaper.

EXISTING PAINTS AND SURFACES TREATED WITH CATAPHORESIS:

- Rough with abrasive paper or Scotch Brite.

IRON SURFACES:

- Sandpaper.

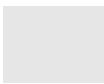
GALVANIZED STEEL AND LIGHT ALLOYS:

- Apply EPOKAR PRIMER code 1385 or UNIPRIMER SPRAY code 2001 on properly prepared supports as indicated in our Technical Data Sheet.

For all types of surface, we recommend to remove dust and degrease with ANTISILICONE code 1618 or QUICK OFF code 0642.

Application

Mixing STAR PRIME HT as indicated in the schedule, you can obtain a full grey scale:

	WHITE	HT grey 1	HT grey 2	HT grey 3	HT grey 4	HT grey 5	HT grey 6	HT grey 7	HT grey 8
									
1015 WHITE	100 g	98 g	95 g	85 g	70 g	60 g	0 g	0 g	0 g
3414 GREY	0 g	2 g	5 g	15 g	30 g	40 g	100 g	50 g	0 g
3450 BLACK	0 g	0 g	0 g	0 g	0 g	0 g	0 g	50 g	100 g

PREPARATION AS FILLING PRIMER:

Stir thoroughly the product and the hardener as indicated in the following schedule, add the thinner and stir well again until having a homogeneous product.

PREPARATION AS WET-ON-WET PRIMER:

Stir thoroughly the product and the additive as indicated in the following schedule, add the hardener and stir well again until having a homogeneous product.

Components	FILLING PRIMER		WET-ON-WET PRIMER	
	By weight	By volume	By weight	By volume
1543 STAR PRIME HT	100	5	100	6
1867 ADDITIVO PER STAR PRIME HT	-	-	30	3
4500 INDURITORE FAST HS or 4300 INDURITORE STANDARD HS	15	1	23 -	2 -
1653 DILUENTE PER ACRILICI or 1648 DILUENTE PER ACRILICI LENTO	10	0.7	-	-
Never use Cellulose thinner.				

	FILLING PRIMER	WET-ON-WET PRIMER
Application method	air mix spray gun: nozzle Ø 1.5-1.9 mm pressure 2.0-2.5 bar.	air mix spray gun: nozzle Ø 1.2-1.4 mm pressure 2.0-2.5 bar.
Pot life (20°C)	60 minutes	45 minutes
Recommended thicknesses	80-120 µm dry film	30-40 m dry film with one coat
Waiting time between two coats	5-10 minutes	5-10 minutes
Practical cover rate *	3-4 m²/l	5-7 m²/l
Air drying (20°C - 65% RH)	30 minutes, dust-free	5 minutes, dust free
	4 hours, touch dry	-
Sanding	after approx. 8 hours at 20°C	-
	or 30 minutes in oven at 60°C (140°F) or with I.R. lamps	-
Overcoatable	just after sanding, with any type of top coat.	after 30 minutes and maximum 2 hours with water- or solvent borne basecoats.
* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.		

Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 24 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with current legislation.

Technical features

Colour	grey, white, black
Binder	acrylic resins/isocyanate
Viscosity	4000-5500 mPas Brookfield rpm 20 s 4
EU limit values for VOC content (Directive 2004/42/EC)	Category B/c, SB: VOC max 540g/l product VOC < 540g/l
AFNOR NF T 36-005 classification	Family I - Category 7b1
The data are measured at a temperature of 20°C.	

Warnings

- For professional use only.
- Always read the safety datasheet before use.
- Solvents or thinners used for cleaning tools, as well as any product residues, must not be released into the environment or poured down domestic drains. The recipient/product/thinner or cleaning solvent must be disposed of in accordance with national regulations.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market can lead to slight deviations in the declared values. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at assistenza.technica@impa.it.