

SPRUZZO

3300.

Spray polyester primer

09/05/13 LRD/nz

Description and use

Two-pack primer for spray application based on unsaturated polyester resins to be cured with a liquid organic peroxide. It may be sanded both dry or wet conditions. It is suitable for applications in industry and car body shop instead of regular filler paste, especially in case of large or complex surfaces.

Technical data

Colour	: grey
Specific gravity**	: part "A": 1.54 kg/l (± 0.03)
Viscosity**	: part "A": 35 seconds (± 5) ISO-DIN Cup # 8
Hardener	: liquid code 4401
Gel time**	: 25 minutes (± 3)
Complete polymerisation**	: after 24 hours
Sandability	: after 3 hours @ 20°C, after 30 minutes @ 60°C(140°F.) or IR radiation.
Flexibility	: good
Water resistance	: very good
Solvent resistance	: good
Practical coverage*	: 2 m ² /l
Storage life**	: 12 months in original sealed container, away from light.

*The practical coverage is calculated on the suggested thickness and applied on plane and regular surfaces.

**Data recorded @ 20°C (68°F.) and 65% R.H.

The product is compliant with Directive **2004/42/CE-IIB(b)** maximum VOC limit value: 250 g/l

Application note

Suitable surfaces	: Steel, cast iron, aged car paints and fiberglass free of detaching agents. For any further information apply to our TECHNICAL SERVICE.
Not suitable surfaces	: Aluminium, zinc plated steel and light alloys, wash primer, epoxy primers with phenolic hardeners, thermoplastic varnishes, solvent sensitive primers.
Surface preparation	: Surface must be dry, clean, free from dust or grease, and made rough by sanding.
Product preparation	: Stir thoroughly the part "A" before using, than add the hardener in the following ratio:

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	BY WEIGHT / IN PESO	BY VOLUME / IN VOLUME
PRODUCT / PRODOTTO 3300 SPRUZZO	150	100
HARDENER / INDURITORE 4401 CATALIZZATORE LIQUIDO	5	5

Do not cure quantities more than 1 kg on purpose to avoid the "mass effect" which reduces notably the life time of the mixture. Clean equipment immediately after use with CELLULOSE thinner.

- Reduction : Not required, if necessary 5% maximum with DILUENTE PER POLIESTERE (thinner for polyester) code 1626.
- Application method : - air mix spry gun with nozzle \varnothing 2.2 ÷ 2.5 mm and pressure of 2 ÷ 4 bar.
- Suggested thickness : 400 μ m dry film
- Overcoatable : After dry sanding using P240 grit or more fine, using P120 or more fine if wet sanded.
For best result, spray a coat of insulating primer EQUALIX HS code 1513 or STAR PRIME HT code 1543 before applying the finishing paint.

NOTE: Avoid to apply when temperature is below + 10°C (50°F.)

Information provided in this technical data sheet is based upon our best experience and technical knowledge; it does not absolve the users from carrying out tests and preventive checks in order to verify the suitability for use. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE.

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