

## TECHNICAL DATA SHEET

### 2K EXPRESS PRIMER FILLER HS

#### DESCRIPTION

Fast drying, high solids primer filler for automotive and commercial vehicle repair. It stands out for its high thickness and easy sanding. Le'Mix express primer allows applications such as high filling filler or just primer filler, modifying its dilution percentage, helping to optimize productivity ratios.

It has very good adhesion on steel, aluminium, galvanized steel and a wide variety of plastics.

#### SURFACE PREPARATION

Before starting the job, first sand, clean and degrease correctly.

Recoatable with 2K topcoats and two-coat systems, both water and solvent based.

This filler is not recommended for repairs on thermoplastic acrylic enamels.

Increase productiveness by using a MEDIUM or HIGH THICKNESS process depending on the situation of surface to be repaired.

#### MEDIUM THICKNESS 2K PROCESS

Recommended process for standard bodywork repair where the surface does not present excessive unevenness or when the work is on new parts. This process optimizes drying and sanding time.

	STANDARD OR FAST
 Mixing ratio Volume Weight	4:1 V 100:15 P
 Pot-life	30'
 Application viscosity Dilution %	25-30" 15-20%
 Gravity Gun Application pressure	1.4 – 1.8 mm 2-2.5 bar
 Number of coats Total thickness	2 coats 75-100 μm
 Flash time	5-10' between coats until matt 5-10' before accelerating drying
 Drying Time 20°C IR Medium wave 60°C	30' 8-10' 20'
 Sanding 20C IR Medium wave 60C	P400 for Basecoat/ P360 for Topcoat 1.5h After drying After drying

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### MIXING RATIOS


	100 g	250 g	500 g	1000 g
LE'MIX EXPRESS PRIMER	72	180	360	720
HARDENER	11	28	55	110
THINNER	17	42	85	170

### HIGH THICKNESS 2K PROCESS

#### USE

Recommended process for standard bodywork repair where the surface does not present excessive unevenness or when the work is on new parts. This process optimizes drying and sanding time.

Follow the indicated terms and thicknesses in order to prevent delays in the repairing process and chips or losses on the finishes. Obtaining a smooth and uniform surface will help shorten the sanding work and achieve a final finish with excellent extensibility and gloss.

	STANDARD OR FAST
 Mixing ratio Volume Weight	4:1 V 100:15 P
 Pot-life	30'
 Application viscosity Dilution %	45-50" 8-10%
 Gravity Gun Application pressure	1.8 – 2.2 mm 2-2.5 bar
 Number of coats Total thickness	2 – 3 coats 100-150 μm
 Flash time	5-10' between coats until matt 5-10' before accelerating drying
 Drying Time 20°C IR Medium wave 60°C	30' 8-10' 20'
 Sanding 20C IR Medium wave 60C	P400 for Basecoat/ P360 for Topcoat 2 h After drying After drying

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### MIXING RATIOS

	100 g	250 g	500 g	1000 g
LE'MIX EXPRESS PRIMER	80	200	400	800
HARDENER	12	30	60	120
THINNER	8	20	40	80

### SAFETY INSTRUCTIONS

The use of appropriate personal protective equipment is recommended during application, to prevent the irritation of the respiratory tract, skin and eyes. For professional use only.

### STORAGE

Keep in a tightly covered container, in a dry and ventilated place, avoiding direct exposure to sunlight. Temperature above 5°C is recommended, between 15 and 30°C optimal.

### VOC

The VOC content of LE'MIX express primer is a maximum of 540 g/l in compliance with European standard 2004/42/CE IIB(C) (540) <540 g/l.

The information contained in this Technical Specification Sheet is based on the knowledge and experience of the Le'Mix technical department, and with it it's intended to advice and inform, being the responsibility of the user to take the necessary measures to guarantee the intended purpose of the product.

FOR PROFESSIONAL USE ONLY.