

GENERAL INFORMATION

2K Easy Sand HiFill Surfacer (A-400 /A-402 /A-404) is a two-component polyurethane high build primer surfacer for general automotive refinishing. Designed for application to various substrates, it provides excellent application, filling and sanding properties.

MIXING RATIO



4 : 1 2K Surfacer Activator + 35 - 45% Thinner

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,8	2/29
HE	1,6-1,8	2/29

APPLICATION



2 - 3 coats 40 - 60µm per coat

FLASH-OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 35°C / 95°F	FORCED DRY 60°C / 140°F
Flash off	10 - 15 minutes	-	10 minutes
Dust free	-	-	-
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	5 hours	1 hour	30 minutes
Dry to polish	-	-	-



DRY TIMES AND DISTANCE IR



	Distance	Flash time	Half-bake	Full-bake
Maximum 3 coats	80 cm	5 minutes	5 minutes	15 - 20 minutes

Follow the IR equipment recommendations for optimal distance between object and IR-lamps

POT LIFE



4 hours (at 30°C)

COMPONENTS



A-414 2K Surfacer Activator
ICR-1293 2K Medium Thinner
ICR-1294 2K Slow Thinner
ICR-1295 2K Extra Slow Thinner

SUBSTRATES



OEM primer, GRP / fibreglass, polyester body fillers, existing finishes in good condition and etch primer. Prospray 1K Plastic Primer.

ADDITIVES



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SURFACE PREPARATION



Cleaning: Clean by using wipe on/wipe off method.

Sanding: Sand surface thoroughly with P180 dry discs.

For preparation and OEM finishes sand with P280 - P320 dry discs or scuffing pad.

Cleaning: After preparation of substrate repeat cleaning procedure.



NEXT LAYER



Prospray Intermix Single Stage System

Prospray Intermix Basecoat System

Prospray Engine Bay Binder System

PHYSICAL DATA



PHYSICAL DATA		
Chemical Base	Composition based on acrylic copolymer	
Physical Properties	Viscosity (RTS)	18 - 21 sec. DIN Cup4 / 30°C
	Specific Gravity (kg/l)	1,2
	Flash Point Closed Cup	24°C / 75,2°F
	Volume % Solids	41%
	Economy	6,6m²/L/60 µm
	Gloss	Matt
	Colour	Grey/Black/White

PROTECTION



Use suitable respiratory protection (**we recommend the use of a fresh air supply respirator**).

For more detailed information please visit the following link for the Safety Data Sheet:

sds.prospray.eu

CLEANUP



Clean equipment after use with a cleaning solvent.

Dispose of solvent according to local regulations.

STORAGE / SHELF LIFE



Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

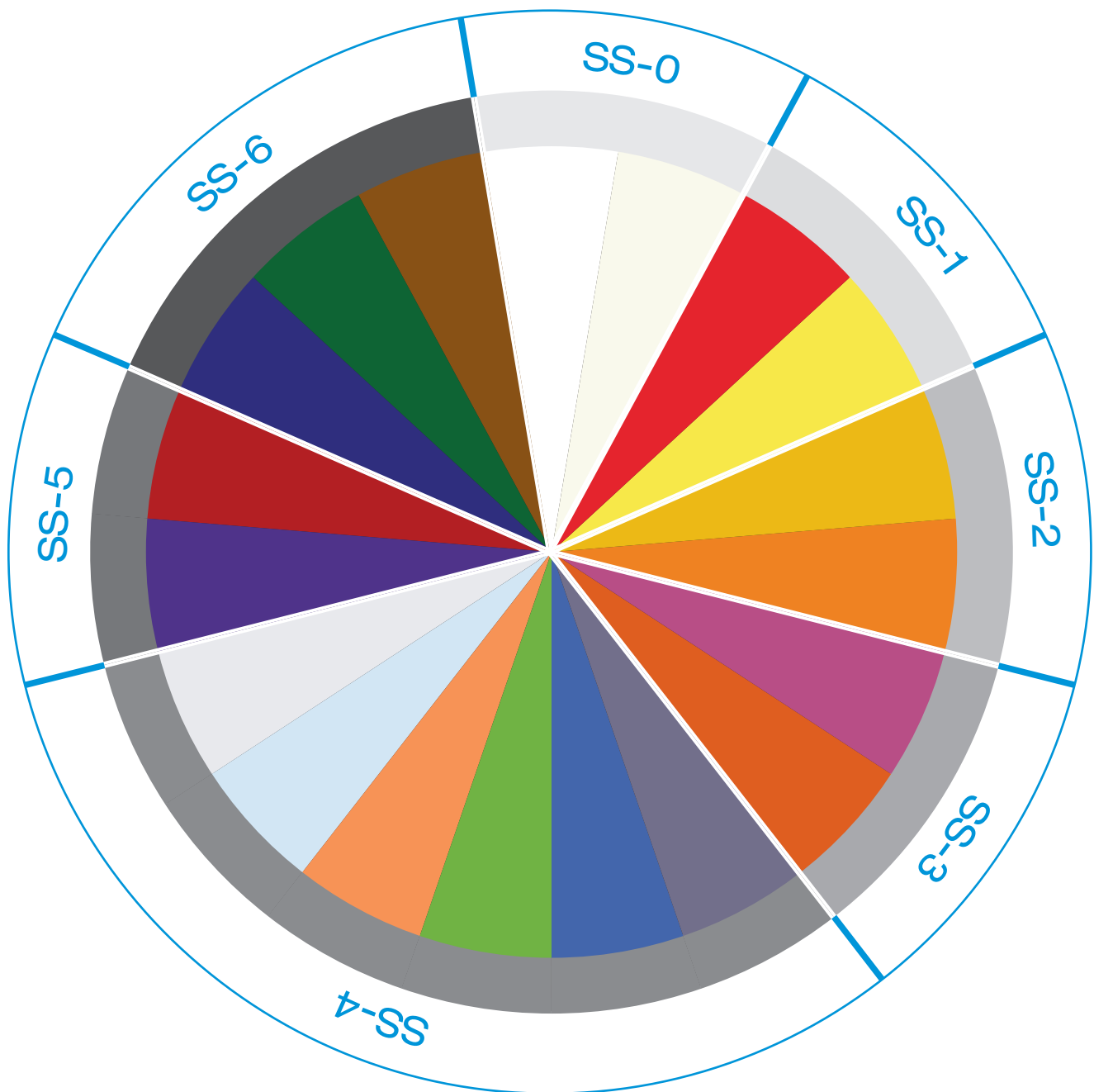
NOTES



All reported product properties on the TDS are determined at a temperature of 30°C unless specified otherwise.

Selecting the shade of grey that has the closest lightness/darkness to the topcoat colour will result in:

- REACHING OPACITY IN FEWER COATS
- INCREASING PRODUCTIVITY
- REDUCING ALL COLOUR CONSUMPTION
- BETTER COLOUR MATCHING WITH POOR HIDING PROBLEM COLOURS.



A-400/A-402/A-404

2K Easy Sand HiFill Surfacer, Grey, White and Black