

Date: 23<sup>rd</sup> July, 2021

# **Technical Data Sheet**

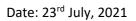
Version:02

Product Name	
Full Product Name	334 2K PU Primer Base (Tintable Primer)
Type of Product	2K high build acrylic Polyurethane primer surfacer
Description	Unicote 334 2K PU Primer Base is a high solid 2K acrylic Polyurethane primer surfacer, characterized by excellent film build per coat, adhesion to properly prepared substrates and rust inhibiting properties. This product is designed specifically to give high filling properties with ease of sanding. This base is used with the Unicote 300 system making it tintable with Concentrate tinters by using colour program to achieve all colours.

Products						
Product Name	Volume Solids %	Weight Solids %		i <b>sity</b> bs/US gal		<b>DC</b> bs/US gal
334 2K PU Primer Base 241 PU Hardener (4:1) Slow 241 PU Hardener (4:1) Normal 241 PU Hardener (4:1) Fast Infra-Red Primer Hardener 831 2K Thinner Slow 831 2K Thinner Normal 831 2K Thinner Fast	52.7 37.3 31.5 33.9 0.0 0.0 0.0 0.0	73.3 45.3 38.9 39.9 0.0 0.0 0.0 0.0	1.565 0.954 0.938 0.986 0.893 0.882 0.872	13.30 7.96 7.83 8.23 7.45 7.36 7.27	417.5 521.9 572.7 593.1 892.7 881.9 871.5	3.58 4.36 4.78 4.95 7.45 7.36 7.27

#### **Properties**

- High film build per coat (high solids)
- Excellent adhesion to properly prepared substrates
- Easy to sand with reduced paper clogging
- Excellent corrosion protection
- Excellent drying and sag resistance



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#### **Substrates**

- Mild Steel surfaces primed with Concept 103 Etch Primer or Concept 110 Metal Etch Grey
- Aluminium surfaces primed with Concept 103 Etch Primer or Concept 110 Metal Etch Grey
- Polyester spray filler
- Glass reinforced polyester (GRP & general types of fibreglass body parts)
- Sound, cured, cleaned and sanded existing surfaces

Substrate Preparation	
All Substrates	All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept 025 Rust Converter.

Prod	uct Preparat	ion			
	Mixing Ratio 4:1 (by volume)		Unicote 334 2K PU Primer Base	241 PU Hardener (4:1)	
			4 parts	1 part	
	Reducer	10-20% (v/v) of Concept 831 2K Thinner, if required.			
AB	Pot life @ 25°C (77°F)	2-3 hours			
S	Spray viscosity @ 25°C (77°F)	BSB 4 Cup Ford 4 Cup	25-27 s 22-23 s		



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Product Preparation cont						
	Spray equipment	Gun type	Fluid tip	Spray pressure	Spray Distance	
		Gravity feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
⋗		Suction feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
HVLP		HVLP	1.5-1.8 mm 0.059-0.071"40-70 kPa 0.4-0.7 bar 6-10 psi15-20 cm 6-8 inch			
		Airless Air Assisted Electrostatic	Consult the man	ufacturer's instru	uctions.	
	Number of coats	2-3 (up to 4) Apply one coat followed by two even full coats. Avoid heavy wet coats.				
	DFT Recommended	50-80 μm (up to 100 μm) 2.0-3.2 mils (up to 4.0 mils)				
$\frac{\langle \uparrow \rangle \uparrow \rangle}{2}$	Flash off time @ 25°C (77°F)	5 min between coats				
	Drying	Air Dry 3-4 hours 50-80 μm (2.0-3.2 mils)   @ 25°C (77°F) 16-24 hours 100 μm (4 mils)				
		Low Bake @ 50°C (122°F)	30-40 min			
		Infra-Red Dry	12-15min short v Use Infra-Red P		medium wave	
e	Sanding	Wet sand with P600-P800 before applying finish coat or Dry sand with P240 followed by P400-P500 using an orbital sander				
with any	ta relates only to th y other material or a ation and we assur	any process. The d	ata is not to be cor	sidered as a warr		



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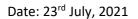
Remarks	
	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
₽°F / °C	Surface temperature must always be a minimum of 3°C (5°F) above dew point.

#### Equipment Cleaning

Use recommended Concept Paints 035 Gunwash

Dry Film Properties	After 7 days drying, when compared to similar technology products.
Hardness	Excellent
Flexibility	Excellent
Corrosion protection	Excellent
Sanding	Excellent

Product Data	
Colour	Unicote 300 colour data base
Theoretical Coverage	Approx. 5 m <sup>2</sup> /L (205 ft <sup>2</sup> /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature away from sunlight.



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Product Packaging		
Product Code	Product Name	Package Size
IN33490003.60 IN241910000X IN241920000X IN241930000X AU2269200001 IN8319100020 IN8319200020 IN8319300020	334 2K PU Primer Base 241 PU Hardener (4:1) Slow 241 PU Hardener (4:1) Normal 241 PU Hardener (4:1) Fast Infra-Red Primer Hardener 831 2K Thinner Slow 831 2K Thinner Normal 831 2K Thinner Fast	3.6L 250mL, 1L 250mL, 1L 250mL, 1L 1L 20L 20L 20L

#### Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

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This Technical Data Sheet supersedes all previous issues.

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