

Technical Datasheet

Highprime 310 HS Express 4:1

PRODUCT INFO

Product Description:

Highprime 310 HS Express 4:1 is a high build, fast drying direct to metal 2K PU Primer. It is suitable for both wet on wet and sanding application. It is Chromate and Lead free, ready for use, with excellent corrosion protection. Suitable for both for air-dry and force-dry applications.

Substrates:

Iron, steel, stainless steel, galvanized steel, solvent resistant surfaces, aluminium, GRP and sanded original and old paintwork.

Preparation:

Sand-blasting according to EN ISO 12944, Sa 2,5 is recommended. For galvanized steel sweep-blasting is recommended. Alternatively flat thoroughly using P80 – P240 dry eccentric sanding. The durability of the coating system largely depends on the thoroughness of the preparation of the surface.

Cleaning:

Surface must be dry and free from any contamination, e.g. oil, grease, release agents. Degrease with metal cleaner, solvent-thinner, silicon remover or industrial cleaners. Thorough cleaning is indicated by water-break free surfaces after rinsing.

Recoating:

May be recoated with Valspar R-Cure / Valthane topcoats.

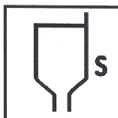
Physical properties:

Chemical base	Polyurethane
Specific Gravity	1.45 (Base only)
Mixed Volume Solids (%)	46%
Pot life (23°C)	approx. 2 – 3 hours
Coverage (m ² / litre)	approx.5 – 6 m ² / litre (@ 80µm DFT)
Gloss	Matt
Colour	Light grey
Processing temperature	+8°C till max. +40°C, max. Humidity 85%

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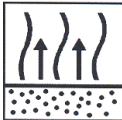
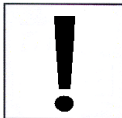
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APPLICATION DATA

	<u>Cleaning</u> With appropriate cleaners	Surface must be dry and free from any contamination, e.g. oil, grease, release agents	
	<u>Preparing</u> Substrates must be sandblasted or other kind of blasting systems or alternatively sanded.	Sa 2,5 according to EN ISO 12944, part 4 Sanded systems P80 – P240	
	<u>Before use</u> The product must be mixed thoroughly before and directly after the hardener has been added. Please note this primer forms a partial gel structure when unmixed, but will readily flow out once mixed.		
	<u>Mixing ratio with Activator and Reducer</u> (by volume)	LPK1285 Highprime 310 HS Express 4:1 LXC7287 Highprime 310 Hardener LRC9153 PU Fast Reducer or LRC9154 PU Medium Reducer or LRC9155 PU Slow Reducer	4 parts 1 part 0 – 10%
	<u>Faster drying in low ambient temperatures:</u>	LAC9235 Accelerator (after Activator) *Will reduce pot life	*1 – 2%
	<u>Viscosity</u> 20 – 23 sec. Ford 4 @ 25°C (wet on wet version) 22 – 30 sec. Ford 4 @25°C (sanding version)		
	<u>Gravity or Suction Feed</u> Nozzle set Spray gun Pressure HVLP (Air cap pressure) Airless / Airmix	1.5 – 1.8 mm 3.0 – 4.5 bar 0.7 bar See manufacturer info	
	<u>Application</u> <u>DFT</u>	<u>Wet-on-wet version</u> 1 Full Wet Coat 45 – 60µm	<u>Sanding version</u> 2 Full Coats 80 – 150µm

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	<u>Between coats: 25°C</u>	N/A	5 – 10 minutes
	<u>Before baking: 25°C</u>		10 minutes before force-dry
	<u>Air-dry: 23°C</u> (depending on total DFT)	Dust free: 10 - 15 minutes Dry to sand: *3 hours (@ 80µm DFT) *Can be reduced by addition of LAC9235 Accelerator	
	<u>Force-dry: 60 – 70°C</u>	30 – 40 minutes (ensure part temp reaches 60°C)	
	<u>Recoatable:</u> By wet/wet after 15 minutes at 25°C until 5 days for topcoat application, or 21 days for another coat of primer (provided the primer surface remains clean and chalk free). After 5 days, the primer needs to be sanded before topcoat application.	<u>Compatible Topcoats</u> Multi Plus / Valthane 520 / Valthane 730 / R-Cure range	
	Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).		
	<u>Precautions:</u> During application all health and safety measures referring to the use and handling of coating materials are to be observed, e. g. existing regulations issued by the trade associations in the Chemical Industry. For Health and Safety information please refer the Material Safety Datasheet (MSDS).		
	<u>Note:</u> The products listed are intended only for the professional user and for professional use. All recommendations in words and writing given on the use of our products to customers or users are not binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from autonomously checking whether our products are suitable for the intend purpose. The durability of the coating system largely depends on the thorough preparation of the surface. Furthermore our universal terms of delivery and payment are applicable.		
	With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.		