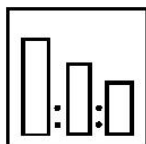


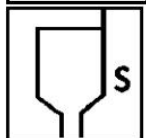


## PRIMER PU 4100

### Quick Reference



8:1 + 20 – 30%  
Primer PU 4100  
Hardener 3093  
Thinner PU 407.04001



25 – 45 sec



Wanda Ruler 8:1



1.5-1.8 mm  
3-4 bar



5 - 10 min.



04h – 25°C  
30min – 60°C



Sand paper 400 / 600



Sand paper 400 / 600

**Description:**

Polyurethane Primer indicated to promote filling and adhesion on metallic surfaces. It has good filling power, fast drying and good sand properties.

**Products and additives:**

Primer PU 4100  
Endurecedor para PU 3093  
Thinner 4030

**Basic raw materials:**

Primer PU 4100 – acrylic resin, organic and inorganic pigments, solvents and additives.  
Endurecedor para PU 3093 – Poly isocyanate and solvents  
Thinner 407.04030 – solvents

**Suitable Substrates:**

Bare metals  
Washprimers  
Existing finishes

**Surface Preparation:**

Sand with P220 or P320 grit. Degrease with Desengraxante Wanda

**Mixing Ratio:**

Reduction A – Primer Filler	Reduction B - Primer surfacer
8 parts of Primer	8 parts of Primer
1 part of hardener	1 part of hardener
20% of thinner PU	30% of thinner PU

**Spray Viscosity:**

25 - 45 seconds FC4 / 25°C

**Pot life:**

3 hours at 25°C

**Spray gun fluid tip and working pressure:**

Spray Gun:	Fluid tip:	Pressure :
Suction Feed:	1.8 mm	3-4 bar (40-50 lb/pol <sup>2</sup> )
Gravity Feed:	1.5 – 1.8 mm	3-4 bar (40-50 lb/pol <sup>2</sup> )
HVLP:	1.7 – 2.0 mm	3-4 bar (40-50 lb/pol <sup>2</sup> )

**Observations:**

These products are intended for professional use only. Please, refer to can, Technical Data Sheet and Safety Data Sheet form more specific information. These products are thoroughly controlled and their quality will be kept as long as they are used according to the manufacturer recommendations. The final result depending upon factors of use which are outside our control.



**Process:** Apply 2-3 single coats, allowing for 3 to 5 minutes flash off time between coats.

**Film Thickness:** 25-50 microns per coat, depending on the added thinner amount.

**Theoretical cover rate :** 13 m<sup>2</sup>/ liter per coat  
**Note:** The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application

**Cleaning of equipment:** Use Thinner Wanda 1100 – 407.04000

Drying times:	25°C	60°C
	Dust	5 min
	Touch	20 min
	Handle	1,5 h
	Total	3 h

**Sanding:** Dry or wet: sand paper 400, ending with 600

**Shelf life:** 2 years at temperatures between 15°C and 35°C, no humidity.

**Health and Safety data:** Please refer to MSDS

**Notes:**

- If necessary, correct the primer with fast putty and respray it.
- Always use the indicated thinner to the product.
- Use the indicated sand paper for dry and wet sanding.
- Before sanding, allowing the specified flash of time in order to avoid mapping defect.

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