

Description

HS top-quality acrylic primer-filler can be used as normal, high-build or wet-on-wet filler. Suitable for spot repair or large surfaces. Product is very easy to apply even in higher thickness. The surface appears smooth and is easy to sand.

Features & Benefits

- wet-on-wet or normal application
- fast drying, easy to sand - saves time, effort and sanding paper
- improves topcoat adhesion
- direct to metal application, strong adhesion on zinc-plated and aluminium
- possible to apply on plastic parts (in combination with 7035 4Plastic Adhesion additive)
- improved filling power
- smooth surface: superb topcoat appearance
- VOC compliant
- hardener: 9220, 9230, 9250, 9270 (vol. 5:1)

Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner.

Before application of the primer filler on bare steel/metal, sand the surface. Bare Steel should be lightly abraded and completely rust free before application. The 5900 Primer can be applied directly, but a 2K Epoxy primer or Etch primer is recommended where optimum adhesion and corrosion resistance is required. It is recommended to use appropriate primer (epoxy, etch, etc.) to optimize adhesion and corrosion protection on aluminium and galvanized steel surfaces.

Zn and Alu: Scuffing pad + matting paste

New parts/panels sand with grit P360/dry or P800/wet.

Old coatings sand with grit P280 - P320/dry or P800/wet.

GRP or Fiberglass sand with grit P320/dry.

Polyester Fillers sand with grit P120-P320/dry.

Before applying water based basecoat clean with an appropriate waterbased antisilicone cleaner as also suggested by the producer of water basecoat.

Mixing ratio

	Wet-on-wet application	<u>By volume</u>	<u>By weight</u>
	5900 3-2-1 Surfacer	5	750
	9230/9250/9270 2K Hardener	1	100
	7050/7070 Maxx Thinner	20 – 35* %	175
	* Use 20% thinner for VOC compliancy		
	Standard application (60 – 180 µm)	<u>By volume</u>	<u>By weight</u>
	5900 3-2-1 Surfacer	5	750
	9220/9230/9250/9270 2K Hardener	1	100
	7030/7050/7070 Maxx Thinner	10 – 20 %	50 – 100
	High-build application (240 – 350 µm)	<u>By volume</u>	<u>By weight</u>
	5900 3-2-1 Surfacer	5	750
	9220/9230/9250/9270 2K Hardener	1	100
	7030/7050/7070 Maxx Thinner	0 – 5 %	0 – 25

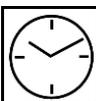
Mixing ratio - Application on plastic parts

	Wet-on-wet application (wet-on-wet)	<u>By volume</u>	<u>By weight</u>
	5900 3-2-1 Surfacer	5	750
	9230/9250/9270 2K Hardener	1	100
	7035 4Plastic Adhesion additive (Plastic primer additive)	10 %	50
	7030/7050/7070 Maxx Thinner	15 – 20 %	75 – 100
	Wet-on-wet application (2-3 layers)	<u>By volume</u>	<u>By weight</u>
	5900 3-2-1 Surfacer	5	750
	9220/9230/9250/9270 2K Hardener	1	100
	7035 4Plastic Adhesion additive (Plastic primer additive)	10 %	50
	7030/7050/7070 Maxx Thinner	5 – 15 %	25 – 75

Application

	Application	<u>Standard application</u>	<u>"high-build" application</u>
	Number of coats	1 – 3 (5 – 20 % thinner)	3 – 5 (0 – 5 % thinner)
	Flash off until matt	5 – 10 min	10 – 20 min
	Total dry film build	60 – 180 microns	240 – 350 microns
	Spray gun set /air inlet	1.4 – 1.8 mm	1.8 – 2.2 mm
	Spray pressure	1.5 – 2.0 bar	1.5 – 2.0 bar
	Wet-on-Wet application		
	Number of coats	1	
	Flash off before overcoating	20 – 30 minutes	
	Total dry film build	20 – 30 microns	
	Spray gun set /air inlet: Gravity feed 1,3 mm; 1.5 – 2.0 bar		

Drying

	Dry film thickness	<u>60 – 180 microns</u>	<u>250 – 350 microns</u>
	at 60 °C/140 °F	25 – 35 min	min. 40
	IR (short waves)	25 – 30 min	min. 30
	at 20 °C/68 °F	6 – 8 h	> 12 h
	Potlife at 20 °C/68 °F	30 – 50 min	30 – 50 min

Testing of the material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) has to be done at least 15 days after the application.

Processing instructions

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60°C. Degrease the surface with Silco antisilicone degreaser. Sand/matt with matting pad. Clean again with Silco antisilicone degreaser. Allow parts to dry completely. ATTENTION: Sanded material must be removed completely! After this preparation we recommend to do a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts.

Complementary products

- 9220 (extra fast), 9230 (fast), 9250 (medium), 9270 (slow) 2K Hardener
- 7030 Maxx Thinner Fast; 7050 Maxx Thinner Standard; 7070 Maxx Thinner Slow
- 7035 4Plastic Adhesion additive (Plastic primer additive)

Prod. Nr.	Description	Volume	Packaging Box
5900-A-3,5	White	3,5 L	2
5900-A-1	White	1 L	6
5900-B-3,5	Dark Grey	3,5 L	2
5900-B-1	Dark Grey	1 L	6
5900-C-3,5	Grey	3,5 L	2
5900-C-1	Grey	1 L	6

Physical properties

Specific weight (5900): 1,49 – 1,52 kg/L

Solid content (5900) 1085 g/L

Theoretical coverage: 2,3 m²/100 microns; 4,6 m²/200 microns

VOC

2004/42/IIB(c) (540) <540

Shelf life

Min. 24 months from the production date under normal storage conditions and unopened can.

Additional Information

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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Table 1.1 – Mixing ratio by weight (9220/30/50/70 Hardeners)
5:1 + 20% Thinner

Volume of RFU paint required (ml)	Primer	Primer + Hardener	Primer + Hardener + Thinner
100	111	125	138
250	277	312	344
330	365	412	454
500	554	624	689
750	830	936	1033
1000	1107	1249	1377

Table 1.2 – Mixing ratio by weight (9220/30/50/70 Hardeners)
5:1 + 10% Plastic additive + 10% Thinner ¹

Volume of RFU paint required (ml)	Primer	Primer + Hardener	Primer + Hardener + 7035 Plastic additive	Primer + Hardener + 7035 Plastic additive + Thinner
100	111	125	131	138
250	277	312	321	344
330	365	412	423	454
500	554	624	641	689
750	830	936	962	1033
1000	1107	1249	1282	1377

¹ Add thinner as needed to adjust viscosity.

5900 Greyshade System chart

	F1	F3		F5		F6		F7
5900-A	100 %	95 %	75 %	-	80 %	-	35 %	-
5900-B	-	5 %	-	-	20 %	50 %	65 %	100 %
5900-C	-	-	25 %	100 %	-	50 %	-	-

* values are in weight %