

### Description

Universal high build HS acrylic primer filler with its fast drying and easy sanding is suitable for all kind of repairs and different substrates.

### Features & Benefits

- improved filling power
- improved drying time
- easy to sand - saves time, effort, and sanding paper
- direct to metal application, adhesion on Zinc-plated and Aluminium substrates
- possible to apply on plastic parts (in combination with 7035 4Plastic additive)
- VOC compliant
- hardener (vol. 4:1): 9082, 9085

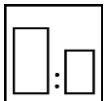
### Substrate preparation

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 7080 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.

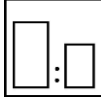
- New parts/panels sand with grit P360/dry or P800/wet.
- Old coatings sand with grit P280 - P320/dry or P800/wet.
- GRP or Fiberglass sand with grit P320/dry.
- Polyester Fillers sand with grit P120-P320/dry.
- Zn and Alu: Scuffing pad + matting paste

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




### MIXING RATIO /See table 1.1

	Mixing ratio	By volume	By weight
	7080 M8 Acryfill	4	1000
9082/9085 2K Hardener	1	150	
7030/7050 Maxx Thinner	10 %		0 – 60

### APPLICATION ON PLASTIC PARTS /See table 1.2

	<b>Mixing ratio</b>	<u>By volume</u>	<u>By weight</u>
	7080 M8 Acryfill	4	1000
	9082/9085 2K Hardener	1	150
	7035 4Plastic	10 %	60
	7030/7050 Maxx Thinner	0 – 5 % *	0 – 30 *
* Add thinner if needed to reduce viscosity.			

### Application and drying time

	<b>Spray gun set /air inlet</b>		
	Gravity feed 1.4 – 1.8 mm	1.5 – 2.0 bar	
	Suction feed	Verify manufacturer's info	
	<b>Application</b>	<u>Standard application</u>	<u>“high-build” application</u>
	Number of coats	1 – 2	3 – 5
	Flash off	5 – 10 min	5 – 10 min
	Total dry film build	60 – 180 microns	240 – 350 microns
	<b>Drying</b>	<u>Standard application</u>	<u>“high-build” application</u>
	Sanding dry 60°C/140°F	10 – 15 min	20 – 25 min
	Infrared shortwave	5 – 7 min	25 – 40 min
	Sanding dry (20°C/68°F)	2,5 – 3 h	3 – 4 h
	Potlife at (20°C/68°F)	20 – 40 min	20 – 40 min

### Complementary products

- 9082 (extra fast)/9085 (standard) 2K Hardener
- 7030 Maxx Thinner Fast, 7050 Maxx Thinner Standard
- 7035 4Plastic Adhesion additive (Plastic primer additive)

Prod. Nr.	Description	Volume	Packaging Box
7080-A-1	White	1 L	6
7080-A-3	White	3 L	2
7080-C-1	Light Grey	1 L	6
7080-C-3	Light Grey	3 L	2
7080-B-3	Dark Grey	3 L	2

### Processing instructions

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60 °C/140 °F. Degrease the surface with Silco antisilicone degreaser. Sand/matt with matting paste. Clean again with Silco antisilicone degreaser. Allow parts to dry completely. ATTENTION: Sanded material must be removed completely! After this preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Additionally, use of Antistatic Degreasing Wipe (art.no. 2215) is recommended. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts (application and adhesion).

### 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.

### Additional information

Theoretical coverage:

8,5 m<sup>2</sup>/L (50 µm layer thickness)

6 m<sup>2</sup>/L (75 µm layer thickness)

4,5 m<sup>2</sup>/L (100 µm layer thickness)

3 m<sup>2</sup>/L (150 µm layer thickness)

Specific weight: 1,65 kg/L

### 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**

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
100	122	141	148
250	306	352	370
330	403	464	489
500	611	704	741
750	917	1056	1111
1000	1222	1407	1481

**Table 1.2 – Mixing ratio by weight (Application on plastic)**

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + 5Plastic	Weight Primer + Hardener + 5Plastic + Thinner
100	122	141	148	152
250	306	352	370	380
330	403	464	489	501
500	611	704	741	759
750	917	1056	1111	1139
1000	1222	1407	1481	1519

### 7080 Greyscale System chart

	F1	F3		F5		F6		F7
7080-A	100 %	95 %	75 %	-	80 %	-	35 %	-
7080-B	-	5 %	-	-	20 %	50 %	65 %	100 %
7080-C	-	-	25 %	100 %	-	50 %	-	-

\* values are in weight %