

### Description

Universal high build HS acrylic primer filler suitable for spot repair or larger surfaces. Possibility to choose among two different hardener types to achieve fast on normal drying speeds.

### Features & Benefits

- improved filling power
- fast drying, easy to sand - saves time, effort, and sanding paper
- smooth surface: superb topcoat appearance
- direct to metal application, adhesion on Zinc-platted and Aluminium substrates
- possible to apply on plastic parts (in combination with 7015 Adhesion Promoter)
- VOC compliant
- hardener (vol. 5:1; standard overnight drying): 9220, 9230, 9250 or 9270
- hardener (vol. 3:1; 60-minute drying at 20°C/68 °F): 3950

### 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 9900 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.

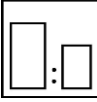
Polyester Fillers sand with grit P120-P320/dry.

Zn and Alu: Scuffing pad + matting paste

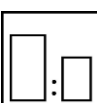
Before applying water based basecoat clean with an appropriate waterbased antisilicone cleaner as also suggested by the producer of water basecoat.


### FAST FILLER (sandable in 1h from application)


#### NORMAL APPLICATION


	<b>Mixing ratio</b>	<u>By volume</u>	<u>By weight</u>
	9900 M9 Surfacer	3	1000
	3950 2K hardener	1	220
	7030/7050 Maxx Thinner	10 – 20 %	60 – 120

#### APPLICATION ON PLASTIC PARTS

	<b>Mixing ratio</b>	<u>By volume</u>	<u>By weight</u>
	9900 M9 Surfacer	3	1000
	3950 2K Hardener	1	220
	7035 4Plastic Adhesion additive (Plastic primer additive)	10 %	60
	7030/7050 Thinner Standard	10 % *	60
* Add thinner if needed to reduce viscosity.			


	<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>
	Number of coats:	1 – 2 coats
	Flash off (until matt):	5 – 10 min
	Total dry film build:	60 – 120 microns





	<b>Drying</b>	<b>Thickness 60 – 120 µm</b>	<b>Thickness 120 – 180 µm</b>
	Dry to sand (20°C/68°F)	60 min	90 min
	Dry to sand (60°C/140°F)	5 – 7 min	In case of high-build application (>180 µm), drying times are prolonged and overnight drying is recommended.
	Infrared shortwave	3 – 5 min	
	Potlife (20°C/68°F)	20 – 40 min	

### SANDABLE NEXT DAY FROM APPLICATION

#### NORMAL APPLICATION

	<b>For small and medium size surfaces/high build</b>	<u>By volume</u>	<u>By weight</u>
	9900 M9 Surfacer	5	1000
	9220/9230/9250/9270 2K Hardener	1	130
	7030/7050/7070 Maxx Thinner	10 – 20 %	60 – 120
	<b>For large surfaces/for high temperatures</b>	<u>By volume</u>	<u>By weight</u>
	9900 M9 Surfacer	5	1000
9270 2K Hardener Slow	1	130	
7070 Maxx Thinner Slow	20 – 25 % *	120 – 150	

#### APPLICATION ON PLASTIC PARTS

	<b>Mixing ratio</b>	<u>By volume</u>	<u>By weight</u>
	9900 M9 Surfacer	5	1000
	9220/9230/9250/9270 2K Hardener	1	133
	7035 4Plastic Adhesion additive (Plastic primer additive)	10 %	65
	7030/7050/7070 Maxx Thinner	10 % *	65
* Add thinner if needed to reduce viscosity.			
	<b>Spray gun set /air inlet</b>	<u>Normal application</u>	<u>“high-build” application</u>
	Gravity feed	1.4 – 1.8 mm	1,8 – 2,2
	Pressure:	1.5 – 2.0 bar	1.5 – 2.0 bar
	Suction feed	Verify manufacturer's info	
	<b>Application</b>	<u>Normal 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>Normal application</u>	<u>“high-build” application</u>
	Dry to sand (60°C/140°F)	25 – 30 min	40 min
	Infrared shortwave	20 – 25 min	30 min
	Dry to sand (20°C/68°F)	6 – 8 h	> 12 h
	Potlife at 20°C/68°F	30 – 50 min	30 – 50 min

### Complementary products

- 9220 (ultra fast), 9230 (fast), 9250 (medium), 9270 (slow) 2K Hardener
- 3950 2K Hardener (3:1; 60-minute drying) (Shelf life 12 months)
- 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
9900-A-3,5	White	3,5 L	2
9900-C-1	Grey	1 L	6
9900-C-3,5	Grey	3,5 L	2
9900-B-3,5	Dark Grey	3,5 L	2

### 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/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).

### 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)**

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
100	109	123	136
250	271	307	339
330	358	405	447
500	543	614	678
750	814	920	1017
1000	1086	1227	1356

**Table 1.2 – Mixing ratio by weight (with 3950 hardener)**

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
100	91	111	122
250	228	278	305
330	301	366	402
500	456	555	609
750	684	833	914
1000	912	1110	1218

### 9900 Greyscale System chart

	F1	F3		F5		F6		F7
<b>9900-A</b>	100 %	95 %	75 %	-	80 %	-	35 %	-
<b>9900-B</b>	-	5 %	-	-	20 %	50 %	65 %	100 %
<b>9900-C</b>	-	-	25 %	100 %	-	50 %	-	-

\* values are in weight %