

Data sheet

794.AIR77

AIRFILLER

PRIMER HS 5:1 DARK GRAY FAST AIR DRYING



1000 +
200 +
100 - 200



20" - 22" FORD 4
at 20 °C



Ø 1.5 - 1.7 mm
2 - 3 Atm
N° of coats 2/3



Drying 20 °C: 15' - 20'
at A.T. (20 °C) : 120' - 150'
At 60 °C: 15' - 20'

NATURE AND PRODUCT FEATURES:

The 5:1 **794.AIR77** two-component acrylic primer is a high-fill insulating primer characterized by exceptionally fast curing at room temperature. Distinguished by its ease and versatility of use, offers excellent spreading and casting resistance, and is very easy to sand. Absence of sagging and/or marks; can be used for both touch-ups and total renovations. Applicable to properly prepared polyester putties, fiberglass, old two-component paints (still adhering and intact).

FIELD OF APPLICATION:

Can be used as an insulating primer and filler depending on the requirements and application diagram used. There are two different types of hardeners to complete the product: Standard and Fast to be used depending on the working temperature and/or size of the workpiece to be painted. Overpaintable with any type of enamel.

PREPARATION OF THE SUBSTRATE:

AIR FILLER HS acrylic primer has excellent adhesion on degreased and sanded sheet metal, primers, old, well-cured and properly prepared paints.

PREPARATION OF THE PRODUCT:

Thoroughly mix component A until the color and consistency are uniform. Then mix with component B in the ratio shown below:

| Component | Blend by volume | Blend by weight |
|-------------------------------------|-----------------|-----------------|
| Primer 794.AIR77 | 5 | 100 |
| Hardener CZ.711 (*) Standard | 1 | 13 |
| Hardener CZ.720 (*) Fast | 1 | 13 |
| Diluent D.737 (*) Standard | 1 - 1.3 | 15 - 20 |

(*) Hardener and thinner should be chosen according to environmental conditions and the size of the piece.

Dilute the perfectly blended mixture with 10-20% of our polyacrylic thinners until obtaining the best viscosity for the desired effect.

Application diagrams

(Referred to temperature conditions of 20 °C)

| Application data | Insulator | Filler |
|------------------------|--------------------------|--------------------------|
| Dilution (by weight) | 15 - 20 | 13 - 15 |
| Gravity Feed nozzle | 1.5 - 1.7 | 1.5 - 1.7 |
| Number of coats | 2 - 3 | 2 - 3 |
| Interval between coats | 5 minutes | 5 minutes |
| Recommended thickness | 90 - 110 µm | 125 - 150 µm |
| Pot-life | 40 minutes | 40 minutes |
| Curing at A.T. | 2 hours | 2 hours and 30 minutes |
| Curing in furnace | 10 - 15 minutes at 60 °C | 15 - 20 minutes at 60 °C |

PRODUCT SPECIFICATIONS:

TYPE OF PRODUCT : Two-component;

APPEARANCE OF THE FILM : Semi-matte

COLORS : Dark gray

SPECIFIC WEIGHT : 1,61 Kg/l (± 0,05)

SUPPLY VISCOSITY : Thixotropic Product

DRY RESIDUE (A) : 78% (± 1%)

DRYING : - *Dry dust-free* : 5' at 20 °C
 - *Drying at A. T.* : 2 - 2.5 hours
 - *Forced Drying* : 15' - 20' at 60 °C

RECOMMENDED LAYERS : Two coats

RECOMMENDED THICKNES : 100 - 120 µm

SAFETY REGULATIONS:

Strictly follow the instructions on the labeling and in the safety data sheet.

STORAGE CONDITIONS:

Store in unopened and sealed packages kept at a temperature of +5 to +30 °C.

The data and information contained in this sheet are the result of our experience and accurate laboratory tests. However, since the painting process represents a set of operations that are beyond our control, they do not therefore guarantee, in any way, the final performance of the cycle.

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