








TDS 20-1-1








Cardea® 4+1 Acrylic Primer

Description	Cardea® 4+1 Acrylic Primer is a two component acrylic primer designed for auto refinish purposes. It has very good sandability properties and short drying time. By changing mixing ratio, it can be also used in wet-on-wet systems.				
Related Products	Cardea® 4+1 Acrylic Primers Cardea® 4+1 Primer Hardener TDS no: 40-1-1 Cardea® Universal Thinners TDS no: 50-2-1				
Substrate	Sanded CED or old painted surfaces, PE putties, steel surfaces, washprimers, epoxy primers.				
Surface Preparation		Degrease with Cardea® U-Clean 300 by clean cloth.			
Surface Preparation		Genuine parts : fiber cloth or dry sanding - P320 sanding paper Steel : dry sanding - P120 → P220 sanding papers Polyester putty : dry sanding - P180 → P280 sanding papers Old paint : dry sanding - P220 → P320 sanding papers			
Surface Preparation		Clean with Cardea® U-Clean 300 by clean cloth.			
Mixing		Sanding System		Wet-on-wet System	
		By Volume	By Weight	By Volume	By Weight
		Cardea® 4+1 Acrylic Primers	100	100	100
		Cardea® 4+1 Primer Hardener	25	15	40
		Cardea® Universal Thinners	10 - 35	5 - 15	50 - 70
			30 - 40		
Viscosity		Sanding system : 16 - 18 s/20°C (DIN 4)		Wet-on-wet system : 11 - 12 s/20°C (DIN 4)	
Pot Life		Sanding system : 40 min (at 20°C)		Wet-on-wet system : 3-4 hr (at 20°C)	



TDS 20-1-1

Cardea® 4+1 Acrylic Primer

Spray Gun Parameters		<p>Gun Type</p> <p>Suction feed spray gun</p> <p>Gravity feed spray gun</p> <p>HVLP Suction feed spray gun</p> <p>HVLP Gravity feed spray gun (wet-on-wet)</p> <p>Suction feed spray gun</p> <p>Gravity feed spray gun</p>	<p>Nozzle size</p> <p>1,8-2,0 mm</p> <p>1,6-1,8 mm</p> <p>1,8-2,0 mm</p> <p>1,7-1,9 mm</p> <p>1,4-1,6 mm</p> <p>1,3-1,5 mm</p>	<p>Air pressure</p> <p>2 - 4 bars</p> <p>2 - 4 bars</p> <p>2 - 2,2 bars</p> <p>2 - 2,2 bars</p> <p>2 - 4 bars</p> <p>2 - 4 bars</p>
Application		<p>Sanding system : 2 - 3 coats</p> <p>Wet-on-wet system : 2 coats</p> <p>In wet-on-wet application, dust can be removed by P1200 sand paper after 1,5 hr. at 20°C or 30 min. at 60°C (before next coat).</p>		
Flash-off Time		<p>Approximately 10 minutes (at 20 °C) until touch-dry.</p> <p>Note: In wet-on-wet application wait between 5 - 30 min (at 20 °C) before next coat.</p> <p>Note: The flash-off time between two coats depends on the application temperature, film thickness and air circulation.</p>		
Drying		<p>60°C / 30 min</p> <p>20°C / 2 hr</p>		
Dry Film Thickness		<p>Sanding system : 50 µm / coat</p> <p>Wet-on-wet system : 25 - 30 µm</p>		
Theoretical Coverage		<p>Sanding system : 12 - 12,5 m²/l at 50 µm</p> <p>Wet-on-wet system : 26,5 - 27 m²/l at 25 µm</p>		
Next Coat		<p>Dry sanding</p> <p>First sanding : P320</p> <p>Finish sanding : P400/P500</p> <p>Wet sanding</p> <p>First sanding : P500/P600</p> <p>Finish sanding : P800/P1000</p> <p>Note: If wet sanding will be done, let the surface dry before next coat application.</p>		
		<p>Clean with Cardea® U-Clean 300 by clean cloth.</p> <p>Wipe the surface with a tack cloth and blow air.</p>		
		<p>Cardea® 2K Topcoats and Basecoats. See TDS No: 30-3-1, 30-1-1</p>		



TDS 20-1-1

Cardea® 4+1 Acrylic Primer

Equipment Cleaning

Use acrylic or cellulosic thinners.

Package

Cardea® 4+1 Acrylic Primers : 1 L; 3 L
Cardea® 4+1 Primer Hardener : 0,25 L; 0,75 L

Color

Light grey, grey, dark grey

Safety

Professional use only. See Material Safety Data Sheet.