

**TECHNICAL DATA SHEET***Revision date: 20.03.2024***2K EXPRESS PRIMER 4:1**

Article number:	14991, 14992, 14993, 14994, 14995, 14996
Colour:	grey, black, white
Intended use:	Car refinishing product/ Filler
General characteristics:	<p>2K Express primer 4:1 is a high-quality filling primer for fast and economic car refinishing (express technology). After drying for 10-15 min at 60 °C or 5-10 min by IR, the coated parts can be sanded after they've cooled down. At room temperature the surface can be sanded after 60 min.</p> <p>Excellent adhesion to bare metals. Perfectly suitable for spot-repair. Mixing white, black and grey primer allows to produce any shade of grey.</p>

PAINTING PREPARATION PROCESS**Hardener:** Chamäleon 299 Hardener for 499 Express primer**Mixing ratio (by volume):** 4:1**Mixing ratio (by weight):**

Primer, g	Hardener, g	Thinner, g	Mixture quantity, ml
157	24	9	100
314	49	18	200
472	73	26	300
629	97	35	400
786	122	44	500
943	146	53	600
1100	170	62	700
1258	195	71	800
1415	219	79	900
1572	244	88	1000

Dilution: without thinner; if necessary dilute with up to 10% Chamäleon UNI Thinner 322

- **Spraying viscosity 4 mm DIN (20°C): 20 - 30 s**
Pot life at 20 °C: 45 min

Substrate pre-treatment:

The substrate must be clean, dry, free from rust and grease. Remove old coatings or primers that have not cured or are not sound.

Old paint coating	In case of one layer topcoat use P400 for dry sanding or P600 for wet sanding. In case of a two-layer topcoat use P500/600 for dry sanding and P800/1000 for wet sanding.
Polyester putties	Dry sand, use P240-320 for final sanding, blow off, degrease
Epoxy primer	Dry sand, use P240-320 for final sanding, blow off, degrease
Wash primer	Apply after drying
Plastics	Degrease, mat with an abrasive finishing pad, degrease again.
Steel, bare metal	Dry sand, use P240-320 for final sanding, blow off, degrease. Prime bare metal surfaces beforehand with an adhesion promoter. Small iron and steel surfaces which are not larger than a hand, can be recoated directly.

ATTENTION: Do not apply on thermoplastic substrates

APPLICATION PROCESS

Processing conditions:

Please only use in an adequate ventilated environment with an ample supply of fresh air. Processing temperature should be at least +12 °C and max. air humidity should not exceed 80%.

Application method	Pressure	Nozzle
Gravity spray gun	1.6 - 2.0 bar	1.3 - 1.8 mm
HVLP	1.6 - 2.0 bar	1.3 - 1.8 mm

Spraying operations	DFT	Consumption
1 - 2	50 - 100 µm	6 - 8 m ² /l

Flash-off time	Between the coatings	Before the oven drying
	2 - 5 min	10 - 15 min

Drying	Dust free	Set to touch	Sandable
Object temperature 20 °C	5 - 10 min	25 - 30 min	1 h
Object temperature 60 °C			10 - 15 min
IR-Drying shortwave*			5 min
IR-Drying mediumwave*			10 - 15 min

*The temperature of the object should not be more than 60 - 70 °C.

Sanding:

Sand with P400 for dry- or P600 for wet sanding for one-coat finishes. For two-coat finishes use P500/600 for dry- and P800/1000 is recommended for wet sanding.

Related Chamäleon products:

Hardener	299 Hardener for 499 Express primer
Thinner	322 UNI Thinner
Elastifier	360 Elastifier
Anti silicone additive	361 Anti silicone additive

Mixing ratios by volume of product

	SV1	SV2	SV3	SV4	SV5	SV6
499 WHITE	100	50		75		
499 GREY		50	100		50	
499 BLACK				25	50	100

VOC regulation:

EU limit value: Category B/c 540 g/l
This product contains max. 540 g/l VOC

Shelf life:

24 months, if stored in tightly closed original containers.

This release replaces all eventually earlier issued versions.

For additional information, not contained in this Technical Data Sheet, please contact the supplier under:
info@chamaeleon-produktion.de

For safety information, please refer to the corresponding Safety Data Sheet.