

**TECHNICAL DATA SHEET**

*Revision date: 24.02.2020*

**ALL IN ONE PRIMER**

**Article number:** 14664

**Colour:** Dark grey

**Intended use:** Car refinishing Product/ Filler

**Product description:**

ALL IN ONE PRIMER is a fast drying, multi- purpose sanding and wet-on-wet filler in one. Universal adhesion: applicable directly on steel, iron, aluminium and zincd substrates as well as on commonly used plastics in the automotive industry (.e.g. PP-EPDM, ABS, PC, ABS-PC, PMMA, PUR, PVC and GRP). Furthermore, it is possible to overcoat intact, sound cataphoretic coatings without any pre- sanding. It can be overcoated without intermediate sanding within 5 days. Universal application: it can be used as sanding filler as well as wet-on-wet filler. This product combines the characteristics of sanding filler, wet-on-wet filler and filler for plastics. A lot of different fillers and their additives are replaced by one product and this leads to a simplification of routines in paint shops. Recoatable with 1K and 2K lacquers.

**Painting preparation process :**

**Hardener** Hardener 266

**Mixing ratio** Paint + hardener 4:1 by volume

**Dilution:** Chamäleon thinner, addition 0 - 5 % as sanding filler, 10 - 15 % as wet-on-wet filler / plastic filler

**Spraying viscosity 4 mm DIN:**

Gravity spray gun 25 - 35 s as sanding filler

Gravity spray gun 15 - 20 s as wet-on-wet / plastic filler

**Pot life at 20 °C:** 1 hour

**Application process:**

| Application method               | Pressure      | Nozzle       |
|----------------------------------|---------------|--------------|
| Gravity spray gun                | 1.6 - 2.0 bar | 1.2 - 1.8 mm |
| HVLP                             | 1.6 - 2.0 bar | 1.2 - 1.8 mm |
| 0.7 bar internal nozzle pressure |               |              |

### Processing conditions:

Please only use in an adequately ventilated environment with an ample supply of fresh air. Processing temperature should be at least + 10 C° and max. air humidity should not exceed 80%.

| Spraying operations | DFT         | Consumption                         |
|---------------------|-------------|-------------------------------------|
| 1 - 3               | 20 - 180 µm | 5 - 7 m <sup>2</sup> /l at 45µm DFT |

| Flash-off time | Between the coatings | Before the oven drying |
|----------------|----------------------|------------------------|
|                | 5 - 8 minutes        | 10 - 15 minutes        |

| Drying                   | dust dry | set to touch | sandable     | recoatable   |
|--------------------------|----------|--------------|--------------|--------------|
| Object temperature 20 °C |          |              | 4 - 5 hours  | 15 - 20 min. |
| Object temperature 60 °C |          |              | 30 - 40 min. |              |

### VOC regulation:

EU limit value: Category B/c 540 g/l

This product contains max. 533 g/l.

### Processing tips

The substrate must be clean, dry and free from grease.

In case of one-layer topcoat use sanding paper P 400 for dry sanding or P 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper P 500/ 600 for dry sanding and P 800/ 1000 for wet sanding.

**Substrate preparation:** All substrates must be cleaned beforehand. It is recommended to wash zinc substrates with an ammoniac wetting agent. Pre-treatment: Sand aluminium with P 220, steel with P 120. After sanding clean again thoroughly.

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60°C. Degrease the surface thoroughly with antistatic degreaser. Sand with a super fine softpad. Clean again with antistatic degreaser. Allow parts to dry completely. **ATTENTION:** Separating substances must be removed completely! After the aforesaid preparation we recommend to do a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts.

This release replaces all eventually earlier issued versions.

For additional information, not contained in this Technical Data Sheet, please contact the supplier via: [info@chamaeleon-produktion.de](mailto:info@chamaeleon-produktion.de)

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