


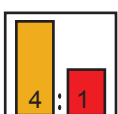



## Technical Data Sheet

# PTK 105: Plascon 2K 4:1 Filler Primer

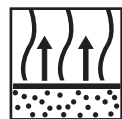
<b>Product Description</b>	<ul style="list-style-type: none"> <li>• An economical high build filler primer.</li> <li>• High filling properties.</li> <li>• Good vertical stability.</li> <li>• Advanced drying properties.</li> <li>• Easy to sand.</li> </ul>
<b>Technical Description</b>	<ul style="list-style-type: none"> <li>• Mix 4:1 with Plascon 2K Hardeners (PTK 202/3).</li> <li>• Air / force drying possible.</li> <li>• Pot life 60 min @ 23°C.</li> </ul>
<b>Working Process</b>	<ul style="list-style-type: none"> <li>• 4:1 as a High Build Filler Primer.</li> </ul>
<b>Substrate</b>	<ul style="list-style-type: none"> <li>• Pre-primed Aluminium and Galvanised zinc substrates with Etch primers (APU 106/7).</li> <li>• Tough-hardened sanded paintwork.</li> <li>• Fibre glass, cleaned and sanded.</li> <li>• Steel, rust free, cleaned, sanded and appropriately primed.</li> <li>• E-coat, sanded.</li> </ul>
<b>Pretreatment / Cleaning</b>	 <ul style="list-style-type: none"> <li>• Ensure that all surfaces are clean, free from dust, oil, grease or other contaminants by using Acryline Pre-cleaner (ATH 310).</li> </ul>
<b>Application</b>	 <ul style="list-style-type: none"> <li>• Use air fed respirator.</li> <li>• Refer to relevant Health and Safety Data sheets.</li> </ul>   <ul style="list-style-type: none"> <li>• 4:1 with Plascon 2K Hardeners (PTK 202/3).</li> <li>• Pot life 60 min @ 23°C.</li> </ul>  <ul style="list-style-type: none"> <li>• Thin with Plascon 2K Thinners (PTK 301/2).</li> <li>• Thin up to 5%.</li> <li>• 22 - 24 sec DIN 4 @ 23°C.</li> </ul>



- 1.6 - 1.8 mm.
- HVLP: 1.8 - 2.0 bar.
- Conventional: 3 - 4 bar.
- 2 - 3 coats: 70 - 110 microns.



- 1.7 - 1.9 mm.
- Conventional: 3 - 4 bar.
- 2 - 3 coats: 80 - 120 microns.



- 5 - 10 min @ 23°C.
- Flash off between coats and final flash off depending upon film build and temperature.



- 30 min @ 60°C.
- Panel temperature.
- Air dry 3 hours @ 23°C depending on film build.



- P400 - P500.
- Orbital sander.



- P600 - P800.
- Wet sanding.

<b>Flashpoint</b>	<ul style="list-style-type: none"> <li>• 23°C.</li> </ul>
<b>Specific Gravity</b>	<ul style="list-style-type: none"> <li>• 1,360 g/cm<sup>3</sup> (approx).</li> </ul>
<b>Solid Content</b>	<ul style="list-style-type: none"> <li>• Approx 62% by weight.</li> <li>• Approx 42% by volume.</li> </ul>
<b>Solid Content (mixed with hardener)</b>	<ul style="list-style-type: none"> <li>• Approx 58% by weight.</li> <li>• Approx 38% by volume.</li> </ul>
<b>Coverage (without reducer)</b>	<ul style="list-style-type: none"> <li>• Approx 4.8m<sup>2</sup> /Lt. at 80 microns dry film thickness.</li> </ul>
<b>Average DFT</b>	<ul style="list-style-type: none"> <li>• 80 microns.</li> </ul>
<b>Raw Material</b>	<ul style="list-style-type: none"> <li>• Acrylic resin and inert fillers.</li> </ul>
<b>Cleaning of Equipment</b>	<ul style="list-style-type: none"> <li>• Clean equipment immediately after use with Lacquer Thinner.</li> </ul>
<b>Shelf Life</b>	<ul style="list-style-type: none"> <li>• 12 Months @ 20 - 25°C in original sealed packaging.</li> </ul>
<b>Important Remarks</b>	<ul style="list-style-type: none"> <li>• For professional use only.</li> <li>• Cannot be used over uncured paint work and thermoplastic finishes.</li> </ul>



- Protect from sunlight.



- Protect from severe cold.



- Working areas should be well ventilated.
- Booth must have good extraction.
- Refer to Safety Data Sheet (SDS), for download from [www.plascon-automotive.co.za](http://www.plascon-automotive.co.za).



- This Product contains flammable materials.
- Keep away from sparks & open flames.
- No smoking permitted in the area.

#### **Warning:**

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitisation if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Contact with skin and eyes should be avoided. Contact with eyes should be referred to a Doctor after washing with water. Gloves and goggles should be worn when handling these products, as well as suitable respiratory equipment. Ensure work area is well ventilated. Inhalation of spray mists must be avoided. Splashes of paint in eyes should be flushed out with water. Contact lenses, if in use, must be removed. Paint in contact with skin must be removed promptly and then washed with soap and water.

#### **Note:**

The information contained here represents the current state of our knowledge and is intended as a guide to our products and their uses. It is not intended as an insurance of certain product properties or of their specific applications. The warnings displayed on the product labels should be followed. Any industrial property rights should be observed. We guarantee perfect product quality under the terms of our general conditions of sale.

All other MasterMix Technical Data Sheets (TDS's) can be downloaded from [www.plascon-automotive.co.za](http://www.plascon-automotive.co.za).

#### **Disclaimer:**

The recommendations contained herein are given in all good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control. Should a recommendation be of a GENERAL NATURE and not refer to any particular project, and should the reader wish to use the general specification for a PARTICULAR project, then he should first confirm with the Technical Service Department that the specification can be used. Not all products referred to in this Data Sheet are stock items. Many are manufactured only on receipt of official customer orders. It is essential, therefore, where time is of the essence, to check availability and manufacturing lead times with us.

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