

TECHNICAL INFORMATION

KLASS PRIMER FILLER 3+1



509-31654-721

DESCRIPTION



Base primer with good filling properties, fast drying, smooth sanding and does not clog sandpaper, either dry or wet. Its neutral gray color allows for an easier hiding with the top coating.



Containers

¼ Gallon, 1 gallon

Available Colors

Neutral gray

SURFACE PREPARATION



Before application, surface must be free of dust, grease, oil, waxes, or any other contaminants that can affect product adherence



SUBSTRATE

FIRST CLEANING

SANDING

AFTER CLEANING

ADHERENCE ENHANCER

Iron

330 - 900

180-220/P180-P220

330 - 900

Klass Etching Primer



Aluminum

330 - 900

220-320/P220-P400

330 - 900

Klass Etching Primer

Galvanized Steel

330 - 900

Gray Fiber

330 - 900

Klass Etching Primer

OEM Finish

330 - 900

220-320/P220-P400

330 - 900

N/A

Replacement Part

330 - 900

Gray Sponge

325 - 900

N/A

Paintable Plastic

N/A

Red Fiber

N/A

Klass Etching Primer

COMPONENTS AND MIXING RATIOS



Add only the recommended components. Use KLASS measuring rule for a correct mix.



MIXING RATIO

HARDENER

DILUENT

Product

100 Parts

754-900

476-900



Hardener

33 Parts

Diluent

33 Parts

Mix ratio

(3:1:1)

Application Viscosity

18- 22 seconds,
DIN Cup #4

Pot Life:

46 – 60
minutes @
20°C

APPLICATION EQUIPMENT



For better results, use recommended nozzle size and pressure.


These technical data were calculated under controlled laboratory conditions, but SUR QUIMICA has no control over conditions, tools, applicator skills, selection, preparation, or compatibility of products used; therefore, can only guarantee this product quality, its features and qualities' suitability, but is not responsible for the results obtained in conditions impossible to check once the job has been done. SUR QUIMICA has made reasonable efforts to ensure the accuracy of the information provided here, but assumes no responsibility for any error, omission, or inaccuracy in it. If there is any inconsistency between different language issues of this document, Spanish version will prevail.

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Air Spray	Nozzle	Pressure (PSI)
 Conventional Suction Feed	1.7 – 1.8 mm	45 – 45
Standard Gravity Feed	1.7 – 1.8 mm	40 – 45
Gravity Feed HVLP	1.7 – 1.8 mm	30 - 35 (10 output)

PRODUCT APPLICATION

 Number of coats	Time Between Coats	Dry Film Thickness
3	7 – 10 minutes	2 -3 mils



Comments: Respect curing time between coats and do not exceed recommended thickness.

Drying Times



Data measured at 20°C (68°F). In case of contamination, lightly sand two-layer with #600 grit wet and reapply.



Drying	TIME	Forced drying	TIME
Dust dry	7 min	Oven @ 60°C:	30 minutes
Touch Dry	45 minutes	Medium wave infrared	20 – 25 minutes
Dry-to-sand	3 hours	Short wave infrared	2 minutes @ 50%, 6 minutes @ 100%
Before the next product	After sanding		
Dry to retouch	After sanding		

SANDING



SANDING METHOD	# GRIT	FEPA GRIT
Wet sand by hand	320 - 400 - 600	P400 – P600 – P1200
Dry sand by hand	320 - 400 – 600	P400 – P600 – P1200
Power sanding, dry	320 - 400 - 600	P400 – P600 – P1200



* For wet sanding, submerge sandpaper 20 minutes in water, before use.

OBSERVATIONS

- Do not exceed film thickness recommended in APPLICATION.
- Respect curing time between layers.
- Do not use compressed air to force-dry between layers.
- Use the indicated nozzle size.
- Do not sand this primer with sandpaper grit coarser than 320.

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STORAGE, HEALTH AND SAFETY



Keep this product stored for a short period, in dry environment, between 50°F and 95°F.
Read and understand all safety instructions on label.



Never add other components than those indicated on this sheet. Doing so may affect its performance and voids all warranties.



If you need more information, check our website <https://www.gruposur.com/asistencia/>

This is a professional/industrial product and it should be applied by properly trained personnel, wearing appropriate Personal Protection Equipment (PPE), as described in its Safety data Sheet (MSDS), available at <http://www.gruposur.com>

Do not use this product near sources of ignition, such as sparks or equipment with high temperatures.
Do not smoke during use. Use in a well-ventilated area.

Dispose of waste in accordance with local laws and regulations.

If you need to dispose of empty containers of our products in Costa Rica, contact your SUR Color paint store or our industrial compound in La Uruca, San Jose.

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