

TECHNICAL INFORMATION

KLASS AQ PRIMER



509-31690-720

DESCRIPTION



water-based primer is made with epoxy resins, developed for good filling, forced drying, and excellent sandability. This primer is to apply on steel surfaces, on the original finish or even on plastic parts if they have been previously primed with Klass Plastic Primer 31450-721



Containers

¼ gallon, 1 gallon

Available Colors

Neutral grey

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

N/A



OEM Finish

330 - 900

220-320-P220-
P400

330 - 900

N/A

Replacement Part

330 - 900

Grey Sponge

330 - 900

N/A

Paintable Plastic

N/A

Grey Sponge

N/A

Klass Plastic Primer

COMPONENTS AND MIXING RATIOS



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



MIXING RATIO

HARDENER

DILUENT

Product

6 Parts

Tap Water



Hardener

1 Part

00772-900

Diluent

1 part

Mix ratio

(6:1-1)

Application Viscosity

18 - 22 seconds,
DIN Cup #4

Pot Life: 45 – 60 minutes

APPLICATION EQUIPMENT



For better results, use recommended nozzle size and pressure.



Air Spray

Nozzle

Pressure (PSI)

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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Conventional Suction Feed	1.7 - 1.8 mm	40 - 45
Standard Gravity Feed	1.7 - 1.8 mm	40 - 45
Gravity Feed HVLP	1.7 - 1.9 mm	30 – 35 output

PRODUCT APPLICATION



Number of coats

3 - 4

Time Between Coats

10 minutes (blower forced)

Dry Film Thickness

4 - 5 mils



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

Drying Times



Data measured at 20°C (68°F).



Drying

TIME

Forced drying

TIME

Dust dry

5 minutes

Oven @ 60°C:

30 minutes

Touch Dry

30 minutes

Medium wave infrared

20 – 25 minutes

Dry-to-sand

18 hours

Short wave infrared

2 minutes @
50% and 5
minutes @
100%.

Before the next product

After sanding

Dry to retouch

After sanding

Wait 3 – 5
minutes before
using infrared
lamp

SANDING



SANDING METHOD

GRIT

FEPA GRIT

Wet sand by hand

400 – 600

P400 - P600 – P1200



Dry sand by hand

400-600-800

P400 - P600 – P1200

Power sanding, dry

400-600-800

P400 - P600 – P1200

NOTICE

Do not use compressed air to force dry between coats.

Use the indicated air spray nozzle.

After applying this product, you have a maximum of 5 days to sand and apply the finish, otherwise you must sand and apply one more layer of product following all the recommendations on this sheet.

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STORAGE, HEALTH AND SAFETY



Keep this product stored in its original container and with the proper label, 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>

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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