# TECHNICAL INFORMATION KLASS AQ PRIMER





## **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	
Dilluent	1 part		
Mix ratio	(6:1-1)	_	

Application Viscosity 18 - 22 seconds, Pot Life: 45 – 60 minutes DIN Cup #4

#### **APLICATION 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.

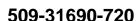








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Conventional Suction Feed	1.7 - 1.8 mm	40 - 45
Standard Gravity Feed	1.7 -1.8 mm	40 - 45
Gravity Feed HVLP	1.7 -1.9 mm	30 – 35 output

#### PRODUCT APPLICATION

**Drying** 



Number of coats Time Between Coats Dry Film Thickness

3 - 4 10 minutes (blower forced) 4 - 5 mils



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

# **Drying Times**



Data measured at 20°C (68°F).

Dust dry 5 minutes
Touch Dry 30 minutes
Dry-to-sand 18 hours

TIME

Before the next product After sanding
Dry to retouch After sanding

Forced drying TIME

Oven @ 60°C: 30 minutes

Medium wave infrared 20 – 25 minutes

Short wave infrared 2 minutes @

50% and 5
minutes @
100%.
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.



This 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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