

KONDAR

1K PRIMER

A670

PRODUCT DESCRIPTION

Kondar is a grey 1K nitrocellulose primer surfacer. It is fast air-drying, easy to sand and gives good film build in a minimal number of coats. It has unlimited potlife, and is suitable for use under sealers and both 2K and 1K topcoat finishes.

Kondar offers good adhesion to a number of suitably prepared surfaces. These include OE finishes and sound non-synthetic paintwork. Kondar can also be used over bare metal or fibreglass which have been pre-primed with an appropriate PPG etch or epoxy primer.

High build, fast air-drying and easy to sand and repair, Kondar is ideally suited for small repairs in bodyshops where stoving facilities are limited, and where airborne dirt contamination could be a frequent problem.

PREPARATION OF SUBSTRATE

In all cases, select the appropriate PPG cleaner(s) from the guide below, and ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Original paintwork or fully cured 2K finishes should be sanded using P240-360 grit discs (dry) or P360-400 grade paper (wet).

Synthetic and 1K finishes, if sound and aged, should be overcoated with a suitable PPG isolating primer before subsequent application of Kondar. D834/5 DP40 Chromate-Free 2K Epoxy Surfacer or D836 Koba Plus are ideal for this purpose - please refer to the appropriate technical data sheets.

Bare steel, aluminium, GRP or fibreglass should be primed with D831/2 Universel Chromate-Free Wash Primer or D834/5 DP40 Chromate-Free 2K Epoxy Surfacer before application of Kondar.

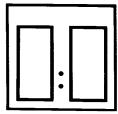
Polyester Bodyfillers should be fully cured then dry-sanded using a sequence of P80 - P120 - P240 grade paper before application of Kondar. Fully cured Spray-Fillers should be sanded with a sequence of P240 - P360 grade paper (dry) or P600 - P800 paper (wet) before application of Kondar.



GUIDE TO SELECTION OF SUBSTRATE CLEANERS

Code	Product	Purpose
D845	DX310 High-Strength Degreaser	For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work, and on any bare metal substrate.
D837	DX330 Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.
D842	DX380 Low-VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimised.

APPLICATION GUIDE



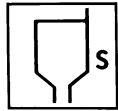
Mixing Ratio :

A670 Kondar : 1 vol
 D866 Deltron 2K Primer Thinner : approx 1 vol

A premium quality PPG cellulose thinner may be used as an alternative to D866

Potlife

unlimited



Spray Viscosity

16-18 secs DIN4 / 20°C



Spraygun Setup :
 Gravity

1.6mm



Suction

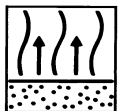
1.6 - 1.8mm

Spray Pressure :

3 - 4 bar

Number of
 coats :

2 - 3 wet



Flash off
 between coats at
 20°C :

10 minutes



Drying times :
 Dust-free at 20°C

10 minutes

Before sanding
 and overcoating
 at 20°C

1-2 hours

Total dry film
 build :
 minimum

50µ

maximum

80µ



<i>Theoretical coverage †:</i>	approx 3m ² /litre
† Theoretical coverage in thinned, ready-to-spray litres, giving a dry film thickness between indicated minimum and maximum values.	
<i>Sanding :</i> <i>grade dry</i>	P240 followed by P360
<i>grade wet</i>	P600 followed by P800
<i>Overcoating :</i>	Most PPG Sealers and Topcoats may be applied over Kondar. Please refer to the appropriate technical data sheet(s) for full details. Please see 'Performance and Limitations' section overleaf.



PERFORMANCE AND LIMITATIONS

Kondar should be stirred thoroughly before thinning and before application if left to stand in the spraygun for any length of time.

Kondar is not suitable for use over plastic or other flexible substrates.

Do not attempt to use Kondar over surfaces where film build exceeds 250µ.

Do not apply more than the recommended number of coats. Excessive film build, insufficient flash-off between coats or use of non-recommended thinner will have adverse effects on Kondar's drying time, sandability and topcoat gloss holdout.

After spot-repairing with Kondar, ensure that the repair surface is carefully sanded around the edges before overcoating with topcoat or sealer.

After use, clean spray equipment thoroughly with cleaning solvent or thinner.

The use of HVLP spray equipment can give an increase in transfer efficiency of around 10% depending upon the make and model of equipment used.

HEALTH AND SAFETY

For comprehensive Health, Safety and Environmental advice, please refer to the relevant Material Safety Data Sheets and Product Can Labels.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.



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