Automotive Refinish
Technical Data Sheet

MEGA PRIMER SURFACER 4:1

Rev.01/26

Product Description

Mega Primer Surfacer 4:1 is excellent adhesion on steel, galvanized steel, other light metals.
It is a high solids product. It has excellent adhesion with base coat and easy sanding.

Substrate preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Mixing Ratio

- Two Component System

	Weight	Volume
Mega Primer Surfacer 4:1 Part A	100	100
Mega Primer Surfacer 4:1 Part B	16	25
Thinner	20-30	20-30

Mix Part A and Part B, strictly follow mix ratio recommendations before and stir for 2-3 minutes until the mixture is homogeneous before application.
- Pot life 1 hour after mixing @30^{0}C

Thinner

Mega Standard Thinner No.20

Viscosity For Spray

Viscosity Cup	Viscosity (sec) @ 30 ^{o}C
Ford Cup No.4	16 - 18

Spray gun
Gravity Feed

Set-up
Full pattern, Flow - 2.5 turns from fully closed set-up

Nozzle size
1.4 - 1.8 mm. (Please refer to spray gun manufacturer)

Spray pressure
1.5 - 2.0 Bar

Number of spray coats
Recommended apply 2 coats
- Light to medium first coat
- Full wet second coat
- Dry film thickness 50 to 60 Microns

Flash-off time
Between coat : 2 - 5 mins

Drying time

Drying time	Air dry (30 ^{o}C)
Surface dry	5 - 8 mins
Sanding time	45 - 60 mins
Full cure	7 days

Handling and Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Shelf life

48 months at <40 ^{0}C

Safety and Disposal

- Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.
- For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.