







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TECHNICAL DATA SHEET

CHAMÄLEON ACRYLIC PRIMER HS 5+1 OPTIMAL

Article number:	488 (grey), (black), (red), (white)
Intended use:	Car refinishing Product/2K High solid, acrylic surfacer low voc
General characteristics:	Chamäleon 5 +1 HS Optimal is a fast-sand able 2K Compact filler with high corrosion resistance, high filling capacity and good adhesion for automotive refinishing. Also, the filling of patches (spot repair) is possible without sagging and edges margins. Coverage: 5-6 m ² / l
Substrate pre-treatment:	
	
	sand;
Application:	
Mixing ratio:	5:1 by volume with Chamaeleon Acrylic Hardener
Pot life:	1-5 hours
Application:	conventional gravity-feed
	
Thinners:	15 - 20 % , wet on wet method 30 - 40 %
Application viscosity:	30 – 55 seconds DIN4/20°C
	
Spray nozzle:	1,4-1,9 mm



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Spraying pressure: 2,5– 4,5 bar
Number of coats: 1 – 3



Flash off between the coats: 15 min



Drying:

Air drying at 20°C:			
		120 – 180 micron	6 – 8 hours at 20°C
Baking:			
	flash off time		10 – 15 minutes
	drying	120 – 180 micron	30-40 minutes at 60°C

Sanding:

grind (with sandpaper P 400 for dry or P 600 for wet sanding for one-coat finishes, for two-coat finishes use P 500 for dry and P 800 is recommended for wet sanding)

Remarks: Process conditions: from + 10° C and up to 75% air relative humidity.

Storage: at least 3 years if stored in tightly closed original containers.



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For the additional information that is not included to the Technical Data Sheet apply to the supplier:

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See information on safety in Safety Data Sheet.