

Technical Data Sheet

MS 2K PRIMER FILLER P2300, P2400, P2550

Description: P2300, P2400, P2550 are high build 2K urethane primer filler with a simple 4:1 mixing ratio. They are exceptionally fast-dry with excellent sandability. High film build around 70 microns per 1 ready-to-spray application provides an excellent surface filling property. Supplied in three color shades.

P2300 (white)

P2400 (gray)

P2550 (dark gray)

Relevant Products: H4400 (MS Hardener for P2300, P2400 and P2550)
D585 (2K Thinner)
D500 (2K Thinner for spot or panel repair)
D500s (2K Thinner for overall repair)
Master Colour (Concentrated Tinter)





Recommended Substrates: OEM finishes / Cured repaired finishes / 2K Polyester Putty RE 160 / 2K Polyester Putty RE-702, RE-749, RE-769 / Epoxy Primer P3615 / Plastic Primer AE 1860




Topcoats: Master Colour

Physical Properties

Appearance	Vicious Liquid
Color P2300 P2400 P2550	White Gray Dark Gray
Odor	Characteristic
Viscosity	< 60 sec (Ford #4)
Density (g/lit)	1600
% non- volatile	<65.5 %
ph	n/a
% soluble in water	< 1.00 %

Product Preparation

	Mixing Ratio	MS 2K Primer Filler P4400 2k Thinner	4 Part 1 Part 2.0-2.5 Part	1600 gram 250 gram 400-600 gram
	580-590 g/l			
	Pot life @ 20° C	1 hours		
	Spray viscosity @ 20° C	IWATA # 2	12 ± 0.10 sec	
	Spray equipment	Gravity feed Suction feed	Nozzle size	Distance
			1.6 – 1.8 mm 1.6 – 1.8 mm	15 – 20 cm 15 – 20 cm

	Spray pressure	Gravity feed Suction feed	35-40 pounds 35-40 pounds
	Number of coats	2-3	
	Flash time	5-10 minutes	
	Theoretical coverage	8-10 m ² /lit at recommended DFT 0.9-1.0 mm -ready-to-spray	

Substrate Preparation

RE-160, RE-702, RE-749, RE-769

1. Sand with sandpaper P240-P320
2. Wash with water and soap
3. Wipe dry with clean cloth

4. Degrease with E-100 or E 100QUICK

AE 1860, OEM Finishes, Cured repaired finishes

1. Sand with sandpaper P320-P400
2. Wash with water and soap
3. Wipe dry with clean cloth
4. Degrease with E-100 or E 100QUICK

P3615: Allow P3615 to dry for 20 before coating. DO NOT Degrease properly with E-100 or E100QUICK. DO NOT leave P3615 over 1 hour after priming.

Remark: Avoid the use of excessively coarse grit sandpaper.

Recoatibility or Topcoating

Sanding the primer with sandpaper P600-P800 if the primer has been allowed sitting for more than 16 hours

Film Property

Drying Time (@ 20°C)	
- Dust-free	7-10 minutes
- Dry sand	1 hour
- Hard Dry	2 hours
IR drying (@ 80°C)	
- Flash time	5-10 minutes
- Distance	80 cm
- Time to dry	30 minutes
Film Thickness	120-140 μ
Gloss (60°)	n/a
Hardness	H
Adhesion	25/25
Resistance NaOH (5%)	Excellent
Resistance to general thinner	Excellent

Repair Systems

Overall repair

Pay attention to the application method. Spray procedure has to ensure proper overspray meltin which is achieved within 2 min. of the clear application. In case of working in high temperature condition, to avoid overspray, E500S is recommended to use. Lower spray pressure and slower spray stoke are required to achieve DFT recommended.

Products	Packages (lit)	Storability @ 20° C (month)	Density @ 20° C (g/lit)
P2300, P2400, P2550	1-3.000	24	1450-1550
H4400	0.250-0.790	20	950-970
2K thinner	3.785-13.000	24	950-980

Safety Information

- Consult the chemical safety data sheet prior to use.
- Read the precautionary notice displayed on the container.
- Suggested protection suit and accessories must be used while working
- MSDS is available at distributors or the manufacture
- INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.

VOC Regulated Areas

These directions refer to the use of products, which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

Disclaimer: To the best of our knowledge, the information contained herein is accurate. However, neither the above named supplier nor any of its subsidiaries assumes any liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of suitability of any material is the sole responsibility of the user.

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