



4204 2K VOC Primer White

ACCELERO

Description:

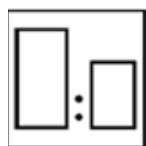
Accelero 4204 is a VOC High Build Air-Dry 2K Primer with excellent filling properties and sandability. It is recommended for high performance bodyshops focusing on efficiency, space utilization and cost reduction with no compromise on premium quality. (Available in Grey - 4202 and Dark grey - 4206)

Accelero 4204 is easy to sand within 1 hour from application. It maintains an excellent gloss holdout when topcoated with any General topcoating material.

It uses the same HS hardener family (H500, H600) as other primers in the GENERAL range, providing a complete and compact offer.

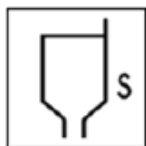
Suitable Substrates:

- Old and Sound thermoset topcoats.
- General polyester fillers.
- Sound OEM



Mix 100 : 25 : 5-25% with H500, H600 General Hardener and Thinner		
100%	25%	5--25%
4204	H500 FAST HS HARDENER	S719 THINNER*
4204	H600 NORMAL HS HARDENER	S711 THINNER

**Recommended*



18-19 s / DIN 4 mm / 20°C
Potlife: 40 minutes at 20°C



HVLP 1.6 – 1.8 mm



3-5 minutes between coats
2-3 coats
45-50 microns/coat
2.0 – 2.2 bar inlet pressure

THINNING RATIO%	VISCOSITY	FILM THICK- NESS/COAT	3 COATS TOTAL FILM BUILD
5%	40"	70 μ	210μ
10%	30"	67 μ	200μ
15%	25"	65 μ	195μ
20%	22"	60 μ	180μ
25%	19"	55 μ	165μ



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Dust free after 10 minutes @ 20 °C (68°F)
Touch free after 15 minutes @ 20 °C (68°F)
Sandable after 60 minutes @ 20 °C (68°F)

Depending on the film thickness

Important note : below 15°C
Do not air-dry
Low bake 5-10 minutes @ 60°C panel temperature



5-7 minutes, depending on color.

Substrate temperature 80°C-100°C (176°F to 212°F)

***Important note:** keep panel at greater than 80cm from IR unit, depending on repair film thickness.



5 Min at 60°C (140 °F)



Wear suitable protection

VOC (2004/42/EC):

VOC (2004/42/EC):2004/42/EC IIB (c) (540)540. The EU limit value for this product (product category IIB. c) in ready to use form is max 540g/ltr. The VOC content of this product in ready for use form is max.540 g/l.

Specific Gravity:

4202 (Grey) = 1.64 kg/cm³
4204 (White)= 1.637 kg/cm³
4206 (Dark Grey)= 1.493 kg/cm³

Flash Point:

25°C (77°F)

Solids Content:

Approx. 62.5% - 67.5% by weight RFU, depending on reduction ratio

Coverage:

5.7-5.8 m²/l at 80 micron film thickness (theoretical)

SDS:

Refer to the safety data sheet

Product Data Sheet