



## 4463 - 2K Rapid Primer Black

### Description:

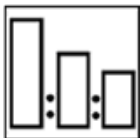
A VOC compliant, high build, two component sanding primer surfacer with good vertical stability, fast air drying and force drying, good filling properties in combination with excellent application and sanding properties. Direct to plastic with addition of plastic additive 8230.

### Suitable Substrates:

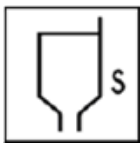
- Existing Finishes except TPA
- OEM Primer or EDP, sanded
- “General” Polyester Putties
- Bare metal substrates must be pre-primed with wash primer 9700.
- Available colors (Beige 4460, Grey 4462, Black 4463, White 4464, Red 4465, Dark Grey 4466)



STIR 4463 well before mixing



Mix 100:25% : 5-25%  
- H500 Fast  
- H600 Normal  
5-25% General Thinners  
Potlife 45 to 60 min / 20 °C (68 °F)



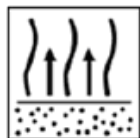
22-24 sec / DIN 4 mm / 20 °C (68 °F) @ 5% reducer  
18-19 sec / DIN 4 mm / 20 °C (68 °F) @ 25% reducer



Compliant 1.6 – 1.8 mm  
2.0 – 2.5 bar inlet pressure  
HVLP 1.7-2.0 mm ; maximum 0.7 bar at the air-cap



2-3 coats  
50-60 microns per coat



5-6 minutes at 20 °C (68 °F) between coats



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2-3 hours at 20 °C (68 °F)  
20 mn. at 60 °C (140 °F)



10 – 15 mn. Short Wave  
The object should be maintained at greater than 60cm from source



Initial Sanding with P500 - P600 grit  
Final Sanding with P800 - P1000 grit



Initial Sanding with P320 grit  
Final Sanding with P400 - P500 grit



Clean Surface to remove contamination prior to application of top coat



GenRock Top Coat  
GenRock, Gen<sub>2</sub>O Basecoats



Wear suitable protection

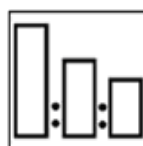
### Tinting the Primer for Limited Opacity Colors

#### NB:

Poor opacity solid colors: When the GenMix Pro system informs you that the solid color has poor opacity, we recommend the following: Add the relevant 2K color formula into the appropriate primer which will assist you in achieving a background that will enhance the color and save on unnecessary coats of the selected color thus allowing you to keep costs to a minimum. Use Beige primer for Yellow colors, use Grey primer for Orange and Red colors

#### Process:

Using the appropriate primer from our range mix:



2:1:1:0.5  
Appropriate Primer 2 Parts.  
Selected 600 Series Color Formula 1 Part.  
Hardener 1 Part.

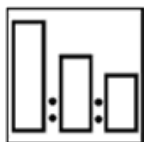
**All other processes remain the same as per the 4463 TDS sheet on application, drying and sanding.**



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### 4463 Primer Direct on Plastics:

With the addition of 8230, 4463 can be applied direct to plastics without the need for a 1k plastic adhesion promotor (plastic primer)



Mix 4:1

- H600 H500 Hardeners.
- 10 – 25% Reducer “General”
- Add 15% plastic additive 8230
- Potlife 45-60 mins / 20 °C (68 °F)

### 4463 Primer Plasticized:

#### Soft Plastic Application

| Product   | Parts     | Weight(g)         |
|-----------|-----------|-------------------|
| 4463      | 100.0     | 1465.0            |
| 810       | 50.0      | 502.2             |
| H500/H600 | 50.0      | 485.9/490.9       |
| Reducer   | 5.0- 25.0 | 64.0-320. approx. |

#### Hard Plastic Application

| Product   | Parts     | Weight(g)           |
|-----------|-----------|---------------------|
| 4463      | 100.0     | 1465.0              |
| 810       | 15.0      | 150.6               |
| H500/H600 | 37.5      | 364.5/ 368.2        |
| Reducer   | 5.0- 25.0 | 46.0- 231.0 approx. |

### Process Notes:

*To optimize the sanding properties, the plasticized primers should be dried 45 min. @ 60-65 °C panel temperatures. All other processes remain the same as per the 4463 TDS sheet on application, drying and sanding.*

|                        | 15 - 20° C.  |                 |            |            | 20 - 25° C.  |                 |            |            | 25 - 30° C.  |                 |            |            | + 30° C.      |                 |            |            |
|------------------------|--------------|-----------------|------------|------------|--------------|-----------------|------------|------------|--------------|-----------------|------------|------------|---------------|-----------------|------------|------------|
|                        | Thinner 711  |                 |            |            | Thinner 721  |                 |            |            | Thinner 721  |                 |            |            | Thinner S2040 |                 |            |            |
|                        | Hardenener   | Time to sanding |            |            | Hardenener   | Time to sanding |            |            | Hardenener   | Time to sanding |            |            | Hardenener    | Time to sanding |            |            |
|                        |              | 20° C.          | 60° C.     | IR         |              | 20° C.          | 60° C.     | IR         |              | 20° C.          | 60° C.     | IR         |               | 20° C.          | 60° C.     | IR         |
| Full paint             | H500         | 2.5HRS          | 20 MINUTES | 15 MINUTES | H500         | 2.5HRS          | 20 MINUTES | 15 MINUTES | H600         | 2.5HRS          | 20 MINUTES | 15 MINUTES | H700          | 2.5HRS          | 20 MINUTES | 15 MINUTES |
| Vertical areas         | H500         | 2.5HRS          | 20 MINUTES | 15 MINUTES | H500         | 2.5HRS          | 20 MINUTES | 15 MINUTES | H500<br>H600 | 2.5HRS          | 20 MINUTES | 15 MINUTES | H700          | 2.5HRS          | 20 MINUTES | 15 MINUTES |
| Fast Repair            | H200<br>H500 | 2.5HRS          | 20 MINUTES | 15 MINUTES | H200<br>H500 | 2.5HRS          | 20 MINUTES | 15 MINUTES | H500         | 2.5HRS          | 20 MINUTES | 15 MINUTES | H600          | 2.5HRS          | 20 MINUTES | 15 MINUTES |
| Soft plastics          |              |                 |            |            |              |                 |            |            |              |                 |            |            |               |                 |            |            |
| 30 % - 810 Plasticizer | H500         | 3.5 HRS         | 30 MINUTES | NA         | H200<br>H500 | 3.5 HRS         | 30 MINUTES | NA         | H500<br>H600 | 3.5 HRS         | 30 MINUTES | NA         | H700          | 3.5 HRS         | 30 MINUTES | NA         |
| Hard plastics          |              |                 |            |            |              |                 |            |            |              |                 |            |            |               |                 |            |            |
| 15 % - 810 Plasticizer | H500         | 3 HRS           | 25 MINUTES | NA         | H200<br>H500 | 3 HRS           | 25 MINUTES | NA         | H500<br>H600 | 3 HRS           | 25 MINUTES | NA         | H700          | 3 HRS           | 25 MINUTES | NA         |



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|                              |                                                                                                                                                                                                     |
|------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>VOC<br/>(2004/42/EC):</b> | 2004/42/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. |
| <b>Flash Point:</b>          | 20-25°C (77 °F)                                                                                                                                                                                     |
| <b>Specific Gravity:</b>     | 1465 g/L (12.22 lbs/gal)                                                                                                                                                                            |
| <b>Solids Content:</b>       | 67.8 % by weight – ready to spray                                                                                                                                                                   |
| <b>Coverage:</b>             | 5.7-5.8 m <sup>2</sup> /l at 80 micron film thickness (theoretical)                                                                                                                                 |
| <b>SDS:</b>                  | Refer to the safety data sheet                                                                                                                                                                      |

Product Data Sheet