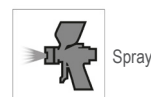
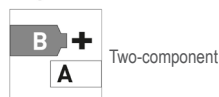


3304 SPRUZZO EVOLUTION

UNIVERSAL SPRAY POLYESTER PRIMER



Description and Use

Two-component primer for spray application based on unsaturated polyester resins to be cured with a liquid organic peroxide.

Easy to sand, it is suitable for bodywork and industrial applications as a replacement for normal spatula fillers, especially when complex and large surfaces need to be treated.

In the case of substrates with layers of different types of materials (old paints/primers/sheet metal), the application of an epoxy primer is always recommended.

Product also suitable for nautical use.

Substrate preparation

Surface must be dry, clean, free from dust or grease and made rough by sanding.

Suitable substrates:

Steel, cast iron, aluminum, light alloys, galvanized sheet metal, old hardened paints and fiberglass without release agents. For further information apply to our TECHNICAL SERVICE.

Not suitable substrates:

Wash primers, epoxy primers with phenolic hardeners, thermoplastic varnishes, solvent-sensitive primers and rust inhibitors. Copper and its alloys must be pretreated with a non-phenolic or acidic adhesion primer.

Application

Application method:

- air mix spray gun with nozzle Ø 2.2.2.5 mm and pressure of 2-4 bar.

Application

Product preparation:

Stir thoroughly the part "A" before using, then add the hardener in the following ratio:

Do not cure quantities more than 1 kg on purpose to avoid the "mass effect" which reduces notably the life time of the mixture. Clean equipment immediately after use with CELLULOSE thinner.

	By weight	By volume
PRODUCT 3304 SPRUZZO EVOLUTION	150	100
HARDENER 4401 CATALIZZATORE	5	5

Dilution:

Not required, if necessary 5% maximum with DILUENTE PER POLIESTERE (thinner for polyester) code 1626.

Infrared rays lamps:

Using medium or short waves IR lamps, waiting time before sanding can be reduced, getting at the same time a drier surface.

After application allow some minutes before radiating the filler.

It is important that the filler temperature never exceeds 60°C (140°F).

Refer to the lighting system manufacturer to get correct user information (e.g. times and distances).

Sanding:

after 3 hours at 20°C, after 30 minutes in the oven at 60°C (140°F) or IR radiation.

Sand with P120 or finer paper (e.g. P180).

Recoating:

After sanding. For best result, spray a coat of insulating primer EQUALIX HS code 1513 or STAR PRIME HT code 1543 before applying the finishing paint.

Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 12 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with the current legislation.

Technical features

Colour	grey
Specific gravity comp. A	1.57 kg/l (± 0.03)
Viscosity part "A"	5000 ÷ 6500 mPa·s Brookfield rpm 20 s 4
Gel time	25 minutes (± 3)
Recommended thicknesses	400 µm dry film
Practical cover rate *	2 m²/l (2 layers)
Complete polymerisation	after 24 hours
EU limit value of VOC content (Directive 2004/42/EC)	Category B/b, SB: VOC max 250 g/l product VOC < 250g/l
* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.	
The data are measured at a temperature of 20°C and 65% R.H.	

Warnings

- For professional use only.
- Always read the safety datasheet before use.
- Solvents or thinners used for cleaning tools, as well as any product residues, must not be released into the environment or poured down domestic drains. The recipient/product/thinner or cleaning solvent must be disposed of in accordance with national regulations.
- Clean equipment immediately after use with cellulose thinner.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market can lead to slight deviations in the declared values. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

Avoid to apply when temperature is below + 10°C (50°F)

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at assistenza.technica@impa.it.