

2K NOBLE EASY SANDING ACRYLIC PRIMER

PRODUCT DESCRIPTION	2K Noble easy sanding acrylic primer Developed for easy to sand and delivers Fast drying combined with good application Leveling and sanding properties as well good Color hold out for all type of car refinishes. High quality appearance that offers excellent Distinctiveness of image in top coat.
FEATURES	01. It delivers fast drying 02. Excellent Sanding properties. 03. Superior adhesion and grip for topcoat. 04. Easy to apply & smooth flow 05. Outstanding sanding results. 06. Can be used for spot, panel, & overall repairs.





SUITABLE SUBSTRATES

Noble 2K easy sanding acrylic primer is suitable to apply over Polyester putties, Epoxy Primers, Steel Surfaces, and Old. Paint surfaces, Thermoplastic paints, Wash Primers. Highly recommended to use this primer coat for protection of steel in severely corrosive environment and where gloss and color Retention is required.

SURFACE PREPARATION

When painting plastic, it is necessary to use Noble plastic primer. Please refer to the TDS "Noble Plastic primer"
 Removal of existing finish and initial sanding of polyester body filler/putty P120. Feather edge before polyester/putty and finish, sanding for complete panel priming P220. Feather edge and final step before spraying primer/surfacer for spot repairs P320. OEM electro (ED) coated parts P320. Prior to any surface preparation, Noble Cleaner the repair area using Noble cleaner. Use clean quality rags or degreaser cloth, one for wetting and one for drying the surface. Apply sufficient Noble cleaner to keep the surface wet. Wipe Noble cleaner off before it can evaporate.

TECHNICAL TIPS

	It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.
	Use Noble Cleaner to remove grease, oil and other contaminants. Use clean quality tack rags or wiping towels, one for wetting and one for drying with wipe on wipe off.
	Stirred the material properly before use.
	Product Mixing: The choice of Hardener and Thinner should be made according to application temperature and size of repair. For Mixing use Noble scale.



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TECHNICAL TIPS



Always Use filter paper to avoid the risk of dust particles.





Clean the gun properly after usage. (with Noble lacquer thinner)

TECHNICAL DATA

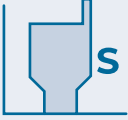
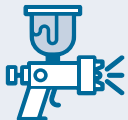
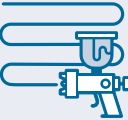
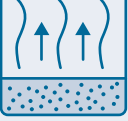




COLORS	Grey Black and White
FINISH	Flat
VISCOSITY (25°C)	20 - 25 Poise
SPECIFIC GRAVITY	1.60 ± 0.02 (of mix)
SOLID BY WEIGHT %	70 - 75 %
THEORETICAL SPREADING RATE	6 - 8 m ² /Liter
FLASH POINT	25 °C when mixed
IMPACT RESISTANCE (25 CM)	50 cm forward / 50 cm backward
SCRATCH RESISTANCE	Pass
BENDING TEST (15 MM)	7.5 - 10 mm.
WATER RESISTANCE (24 HRS) SPOT	Pass
VOLATILE ORGANIC COMPOUND (VOC)	432 g/L

PRODUCT PREPARATION

	MIXING RATIO	Noble 2K Primer Primer Hardener Noble Thinner	Mix By Volume
			4 1 20 - 30%
	Pot life at 25°C	2 Hrs	



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PRODUCT PREPARATION					
	Spray viscosity at 25°C	DIN 4 FORD 4 AFNOR 4	32 - 36s 32 - 36s 34 - 38s		
	SPRAY EQUIPMENT	Type of Gun	Nozzle Size	Distance	Pressure
		Gravity Feed Suction feed HVLP	1.6 - 2.0 1.6 - 2.0 1.6 - 1.8	15 - 20 15 - 20 15 - 20	2 - 3 bar 2 - 3 bar 1 - 2 bar
	NUMBER OF COATS	2,3 Depends on the job			
	FLASH TIME	Till flat between coats			
	DFT	45 - 50 microns ≈ 1.4 mils. Depends No. of coats			
	DRYING TIME 25°C	Dry Dust free	Dry to Handel	Dry to Polish	Recoating Interval
		3 - 5 min.	10- 15 min.	30 - 45 min	1 hrs
	IR Drying	Distance	Half Power	Full Power	*Guideline form short / Medium wave IR equipment
		80 cm.	5 min	15- 20 min	
	DARING SANDING	P- P400, P500 (we recommend to use black dry guide coat better results and uniformly sanding)			
	WET SANDING	Wet P600 – P800 Remove all traces of sanding dust.			
	NOTE	Respect 100 grit maximum jumps in dry sanding steps and 200 grit maximum jumps in wet sanding steps. Use guide coat to control sanding.			



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ADDITIONAL DATA

The surface should be clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. If wet sanding, allow water to evaporate. Apply heat to ensure water has evaporated to prevent humidity blistering overtime

MISCELLANEOUS DATA

STORAGE

The product must be stored according to Noble Regulations. The product should be kept in cool and well ventilated place, protected from heat and direct sunlight at temp 5 - 35°C. Containers must be kept tightly closed.

SAFETY / HEALTH

Ensure good ventilation during application and drying. Avoid contact with skin and eyes. While painting it is advisable to wear eye protector. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice. To remove splashes from skin; use soap and water or a recognized skin cleaner. Keep out of reach of children.

NOTE : We warranty the quality of our product and this data sheet represents test results and practical experience obtained under controlled conditions. We reserve the right to change data without prior notice.

