

TECHNICAL DATA SHEET

Revision date: 20.03.2024

2K ALL IN ONE PRIMER 4:1

Article number:	14664
Colour:	grey
Intended use:	Car refinishing product/ Filler
General characteristics:	<p>2K All-in-one primer is a fast drying, multi-purpose sanding and wet-on-wet filler in one. Universal adhesion: applicable directly on steel, iron, aluminum and zincd substrates (DTM) as well as on commonly used plastics in the automotive industry. Furthermore, it is possible to overcoat intact, sound cataphoretic coatings without any pre-sanding. It can be overcoated without intermediate sanding within 5 days.</p> <p>This product combines characteristics of sanding filler, wet-on-wet filler and filler for plastics what leads to a simplification of routines in paint shops.</p> <p>Re-coatable with 1K and 2K lacquers.</p>

PAINTING PREPARATION PROCESS

Hardener: Chamäleon 266 Hardener for 466 All-in-one primer

Mixing ratio (by volume): 4:1

Mixing ratio (by weight):

Primer, g	Hardener, g	Thinner, g		
		Filler (EU), 5%	Filler (non EU), 20%	Wet-on-wet/plastic filler (non EU), 40%
159	24	4	18	35
319	49	9	35	71
478	73	13	53	106
637	97	18	71	141
797	122	22	88	177
956	146	26	106	212

1115	170	31	124	247
1274	195	35	141	283
1434	219	40	159	318
1593	244	44	177	353

Dilution: Chamäleon UNI Thinner 322/323, addition 0 - 5% (EU VOC)/15 - 20 % (non-EU) as sanding filler; 10 - 15% (EU VOC)/30 - 40 % (non-EU) as wet-on-wet filler/plastic filler

Spraying viscosity 4 mm DIN (20°C): 20 - 30 s as sanding filler; 15 - 20 s as wet-on-wet/plastic filler

Pot life at 20 °C: 1 h

Substrate pre-treatment:

The substrate must be clean, dry, free from rust and grease. Remove old coatings or primers that have not cured or are not sound

Old paint coating	In case of one-layer topcoat use P400 for dry sanding or P600 for wet sanding. In case of a two-layer topcoat use P500/600 for dry sanding and P800/1000 for wet sanding.
Polyester putties	Dry sand, use P240-320 for final sanding, blow off, degrease
Epoxy primer	Dry sand, use P240-320 for final sanding, blow off, degrease
Cataphoretic coating	Degrease, mat with an abrasive finishing pad, degrease again
Plastics (PP-EPDM, ABS, PC, ABS-PC, PMMA, PUR, PVC, GRP)	Before application, reheat the object to be painted for 60 min at 60°C. Degrease the surface thoroughly with antistatic degreaser. Sand with a super fine soft-pad. Clean again with antistatic degreaser. Allow parts to dry completely. Due to various kinds of plastics and mixtures available on the market, we recommend testing beforehand on plastic similar the original plastic substrate.
Steel	Dry sand, use P120 for final sanding, blow off, degrease
Aluminium	Dry sand, use P220 for final sanding, blow off, degrease
Zinc	Pre-treat with the ammoniac wetting agent

ATTENTION: Separating substances must be removed completely! After the aforesaid preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment.

APPLICATION PROCESS

Processing conditions:

Please only use in an adequate ventilated environment with an ample supply of fresh air. Processing temperature should be at least +12 °C and max. air humidity should not exceed 80%.

Application method	Pressure	Nozzle
Gravity spray gun	1.6 - 2.0 bar	1.2 - 1.8 mm
HVLP	1.6 - 2.0 bar	1.2 - 1.8 mm

Spraying operations	DFT	Consumption
1 - 3	60 - 180 µm (sanding filler)	5 - 6 m ² /l
	40 - 60 µm (wet-on-wet filler)	
	20 - 30 µm (plastic filler)	

Flash-off time	Between the coatings	Before the oven drying
	5 - 8 min	10 - 15 min

Drying	Sandable	Re-coatable
Object temperature 20 °C	4 - 5 h	15 - 20 min
Object temperature 60 °C	30 - 40 min	
IR-Drying shortwave*	8 min	
IR-Drying mediumwave*	10 - 15 min	

*The temperature of the object should not be more than 60 - 70 °C.

Sanding:

Sand (with sandpaper P400 for dry or P600 for wet sanding for one-coat finishes, for two-coat finishes use P500 for dry and P800 is recommended for wet sanding)

Related Chamäleon products:

Hardener	266 Hardener for 466 All-in-one primer
Thinner	322 UNI Thinner/323 UNI Thinner slow
Elastifier	360 Elastifier
Anti silicone additive	361 Anti silicone additive

VOC regulation:

EU limit value: Category B/c 540 g/l

This product contains max. 540 g/l VOC

Shelf life:

36 months, if stored in tightly closed original containers.

This release replaces all eventually earlier issued versions.

For additional information, not contained in this Technical Data Sheet, please contact the supplier via:
info@chamaeleon-produktion.de

For safety information, please refer to the corresponding Safety Data Sheet.