



## 4204- Accelero Air dry 2K VOC Primer White

### Product 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 White - 4204 and Dark grey - 4206). Accelero 4202 is easy to sand within 1 hour from application at 20°C room temp. It maintains an excellent gloss holdout when top coated with any General top coating material. It uses the same HS hardener family (H500, H600) as other primers in the GENERAL range, providing a complete and compact offer.

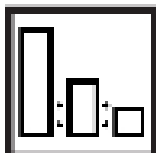
### Suitable Substrates:

- Old and Sound thermoset topcoats.
- General polyester fillers.
- Sound OEM Gen<sub>2</sub>O basecoat

### Notes:

- Adhesion promoter is required to apply to special substrate i.e: plastic, fiber glass, and GRP.
- etch primer (9700) is required to apply to bare metal prior to 420X application

### Product Application



100%	25%	5-25%
4204	H500 FAST HS HARDENER	S719 THINNER*
	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

Disclaimer: Users assume full responsibility for any consequences resulting from the incorrect usage of our products.

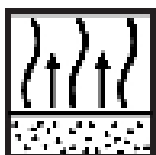


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2-3 coats  
45-50 microns/coat

<i><b>THINNING RATIO%</b></i>	<i><b>VISCOSITY</b></i>	<i><b>FILM THICKNESS/COAT</b></i>	<i><b>3 COATS TOTAL FILM BUILD</b></i>
5%	40"	70 $\mu$	210 $\mu$
10%	30"	67 $\mu$	200 $\mu$
15%	25"	65 $\mu$	195 $\mu$
20%	22"	60 $\mu$	180 $\mu$
25%	19"	55 $\mu$	165 $\mu$



3-5 minutes between coats



Dust free after | 10 minutes @ 20 °C (68°F)

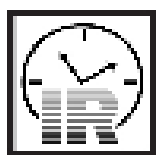
Touch free after | 15 minutes @ 20 °C (68°F)

Sandable after | 60 minutes @ 20 °C (68°F)

Depending on 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 panel temperature (140°F)

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Wear suitable protection

### **Product Characteristics**

<b>VOC(2004/42/EC):</b>	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.
<b>Specific Gravity:</b>	4202 (Grey) = 1.64 kg/cm <sup>3</sup> 4204 (White)= 1.637 kg/cm <sup>3</sup> 4206 (Dark Grey) = 1.493 kg/cm <sup>3</sup>
<b>Flash Point:</b>	25°C (77°F)
<b>Solid Content:</b>	Approx. 62.5% - 67.5% by weight RFU, depending on reduction ratio.
<b>Coverage:</b>	8 - 9 m <sup>2</sup> /l at 5.7-5.8 m <sup>2</sup> /l at 80-micron film thickness (theoretical) micron dry film thickness
<b>SDS:</b>	Refer to the Safety Data Sheet

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