



4463 - 2K Rapid Primer Black

Product Description

This is a sanding 2K VOC high build primer. 446X series is a fast dry 2K primer with excellent sand ability and gloss holdout. It can be applied directly to plastic parts when combined with plastic additive 8230 and 810 plasticizer.

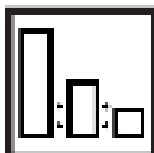
Suitable Substrates:

- Existing Finishes except thermoplastic acrylic
- "General" Polyester Putties/body fillers
- Bare metal substrates must be pre-primed with Etch primer 9700.
- Available colors (Beige 4460, Grey 4462, Black 4463, White 4464, Red 4465, Dark Grey 4466).

Extra Comments

Stir well before mixing.

Product Application



100%	25%	5-25%
4463	H500 - Fast	S711
	H600 - Normal	



35 sec / DIN 4 mm / 20°C (68°F) @ 5% reducer
18-19 sec / DIN 4 mm / 20°C (68°F) @ 25% reducer
Potlife 45 to 60 min / 20 °C (68 °F)



HVLP 1.6 – 1.8 mm
2.0 – 2.5 bar inlet pressure

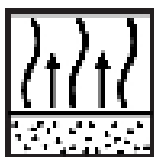


2-3 coats
50-60 microns/coat

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



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



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



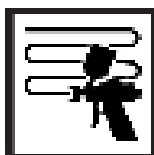
10 – 15 mn. Medium - long Wave
The object should be maintained at greater than 80 cm from source



Initial Sanding with P400 grit
Final Sanding with P500 grit



Clean Surface using Genclean 8241 degreaser to remove contamination prior to application of top coat.



GenRock Top Coat
Gen₂O Basecoats



Wear suitable protection

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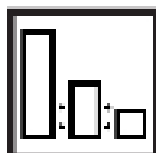
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Tinting the Primer for Limited Opacity Colors

Nb: please refer to genmix comments to select the needed color of the primer that matches with the top coat color.

Process

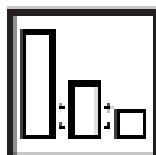
Using the appropriate primer from our range mix:



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

4463 Primer Direct to Plastics

With the addition of 8230, 4460 can be applied direct to plastics without the need for a 1k plastic adhesion promotor (plastic primer)



4:1
- H600 H500 Hardeners.
- 10 – 25% Reducer "General"
- Add 15% plastic additive 8230
- Pot life 45-60 mins / 20 °C (68 °F)

4463 Primer Plasticized:

Soft Plastic Application			Hard Plastic Application		
Product	Parts	Weight(g)	Product	Parts	Weight(g)
4463	100	1633	4463	100	1633
810	50	501.3	810	15	150.39
H500/H600	50	513.4/490	H500/H600	32.5	333.76/ 318.5
S719/ S711	5.0- 25.0	64.0-348.	S719/ S711	5.0- 25.0	49.0- 266.5

	15-20°C				20-25°C				25-30°C				+30°C			
	Thinner 711				Thinner 721				Thinner 721				Thinner S2040			
	Hardener	Time to Sanding			Hardener	Time to Sanding			Hardener	Time to Sanding			Hardener	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	2.5 HRS	20 MINS	15 MINS	H500	2.5 HRS	20 MINS	15 MINS	H600	2.5 HRS	20 MINS	15 MINS	H700	2.5 HRS	20 MINS	15 MINS
Vertical Areas	H500	2.5 HRS	20 MINS	15 MINS	H500	2.5 HRS	20 MINS	15 MINS	H500 H600	2.5 HRS	20 MINS	15 MINS	H700	2.5 HRS	20 MINS	15 MINS
Fast Repair	H200 H500	2.5 HRS	20 MINS	15 MINS	H200 H500	2.5 HRS	20 MINS	15 MINS	H500	2.5 HRS	20 MINS	15 MINS	H700	2.5 HRS	20 MINS	15 MINS
soft plastics 30%-810 Plasticizer	H500	3.5 HRS	30 MINS	N/A	H200 H500	3.5 HRS	30 MINS	N/A	H500 H600	3.5 HRS	30 MINS	N/A	H700	3.5 HRS	30 MINS	N/A
Hard plastics	H500	3 HRS	25 MINS	N/A	H200	3 HRS	25 MINS	N/A	H500	3 HRS	25 MINS	N/A	H700	3 HRS	25 MINS	N/A

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15%-810 Plasticizer					H500					H600							
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Wet on wet

Ratio :

100%	100%	75%	30%
Primer : 4463	Clear :6100 or 6000SR	Hardener : H600	Thinner : S711

Application: 1 light coat followed by 1 full. No flash off in between.

Flash off: 30 minutes before application of topcoating

Spray gun: 1.3—1.4 mm needle size

Product Characteristics

VOC(2004/42/EC):	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.		
Specific Gravity:	4460 = 1633 g/L (13.63 lbs/gal)	4464 =1630 g/L (13.6 lbs/gal)	
	4462 = 1633 g/L (13.63 lbs/gal)	4465= 1633 g/L (13.63 lbs/gal)	
	4463 = 1465 g/L (12.22 lbs/gal)	4466 = 1487 g/L (12.41 lbs/gal)	
Flash Point:	20-25°C (77°F)		
Solid Content:	67.8 % by weight – ready to spray		
Coverage:	5.7-5.8 m2/l at 80-micron film thickness (theoretical)		
SDS:	Refer to the Safety Data Sheet		

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REV-1 – 12/23