

## AB-PR3300 4+1 Primer HS

### Field of application

Passenger cars and commercial vehicles. New or repaired vehicle parts and complete priming of vehicles

### General Information

**AB-PR3300 4+1 Primer HS** is a high solid, two-component, colourable (with Solid Color Top Coat) primer. It is a primer with very good filling power and adhesion, easy-to-apply, also it provides paint properties therefore smooth surfaces can be obtained. It does not absorb the paints applied on it and ensures long life to the top coats.

### Preparation of Substrate – Degreasing/Priming/Sanding



**AB-PR3300 4+1 Primer HS** should only be applied over clean, well sanded/scuffed and degreased surfaces. Before proceeding to the preparation stage for the primer, wash all surfaces to be painted with soap and water. Rinse and allow to dry. Degrease with a appropriate surface cleaner. Make sure all substrates are thoroughly cleaned and dried before and after each preparation step. Immediately wipe the cleaner off the panel surface using a clean, dry cloth.

**Bare Steel (Small Areas):** The surface must be lightly abraded and completely rust-free before application. **AB-PR3300 4+1 Primer HS** can be applied directly but Epoxy Primer is recommended where optimum corrosion resistance is required.

**Other Bare Metals:** Epoxy Primer is recommended where optimum corrosion resistance is required.



**Electropaint** should be sanded with P360 grade paper (dry) or P600 grade (wet).

**Original Paintwork or Primers** should be sanded using P280-P320 grade paper (dry) or P400-P500 grade paper (wet).

**GRP or Fibreglass** should be sanded using P320 grade paper (dry).

**Polyester Fillers** should be dry sanded using a sequence of grade of paper grades suitable for the chosen application of **AB-PR3300 4+1 Primer HS**:

P80-P120 when using as a spray filler.

P80-P120-P240 when using as a primer surfacer or non-sand surfacer.

**Mask entire vehicle to eliminate unwanted overspray.**

## Hardener and Reducer Selection

Temperature	Hardeners	Universal Reducers
Up to 18 °C	AB-PR3400 4+1 Primer HS Hardener Fast	AB-URDC 5001 Uni Urethane Reducer Fast
18-25 °C	AB-PR3400 4+1 Primer HS Hardener Medium	AB-URDC 5001 Uni Urethane Reducer Medium
25-35 °C	AB-PR3400 4+1 Primer HS Hardener Medium	AB-URDC 5001 Uni Urethane Reducer Slow
Over 35 °C	AB-PR3400 4+1 Primer HS Hardener Slow	AB-URDC 5001 Uni Urethane Reducer Extra Slow

## Mixing Ratio

Mixing Ratio with Hardeners **as a Filler (by volume)**

**4:1 AB-PR3300 4+1 Primer HS: AB-PR3400 4+1 Primer HS Hardeners**



Mixing Ratio with Hardeners **as a Surfacer (by volume)**

**4:1 AB-PR3300 4+1 Primer HS: AB-PR3400 4+1 Primer HS Hardeners + AB-URDC 5001 Uni Urethane Reducers**

Mixing Ratio with Hardeners **as a Wet on Wet (by volume)**

**4:1 AB-PR3300 4+1 Primer HS: AB-PR3400 4+1 Primer HS Hardeners + AB-URDC 5001 Uni Urethane Reducers**

## Mix Tables

	as HS FILLING PRIMER			as MS SURFACER			as WET ON WET		
	Mixin g Ratio	Volum e (L)	Weight (gr)	Mixin g Ratio	Volum e (L)	Weight (gr)	Mixin g Ratio	Volum e (L)	Weight (gr)
AB-PR3300 4+1 Primer HS	4	0,625	1.000	4	0,625	1.000	4	0,625	1.000
<b>AB-PR3400 4+1 Primer HS Hardener</b>	1	0,151	148	1	0,151	148	1	0,151	148
AB-URDC 5001 Uni Urethane Reducer	-		-	0,6-0,7	0,102	90	0,8	0,119	105
<b>Total Weight (g)</b>		<b>0,776</b>	<b>1.148</b>		<b>0,878</b>	<b>1.238</b>		<b>0,895</b>	<b>1.253</b>
Application Viscosity DIN4 20 °C	40-45"			22-24"			16-18"		
Pot life at 20 °C	50-90 minutes			60-100 minutes			60-100 minutes		

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## Application



	Filling Primer	MS Surfacers	Wet on Wet
Spray gun nozzle (mm)	1,6-1,8	1,4-1,6	1,3-1,5
Air Pressure (Bar) RP, LVLP	1,7-2,0	1,7-2,0	1,7-2,0
Conventional Guns Air Pressure (Bar)	3,0-3,5	3,0-3,5	3,0-3,5
HVLP (Bar)	0,5-0,7	0,5-0,7	0,5-0,7
Number of Coats	max. 3 coats	2-3 coats	max. 1.5 coats
Flash off at 20 °C	5-10 minutes (till matting)	5-10 minutes (till matting)	min 15 minutes (till matting) max 2 hour - recoat

## Drying Times and Thickness



Air Dry 20 °C	Filling Primer	MS Surfacers	Wet on Wet
Dust free	10-15 minutes	10-15 minutes	min 15 minutes
Dry to handle	2 hours	2 hours	1 hour
Dry to tape	2-3 hours	2-3 hours	1 hour
Dry to sand	8-12 hours	3-4 hours	1 hour
Ready for Top Coat (Wet on Wet)	-	-	Min 15 minutes
Forced Dry 60 °C	Filling Primer	MS Surfacers	Wet on Wet
Dust free	-	-	-
Dry to handle	20 minutes	20 minutes	-
Dry to tape	20 minutes	20 minutes	-
Dry to sand	20-30 minutes	20-30 minutes	-
Spray gun nozzle	1.6 mm	1.6 mm	1.3 mm
Total film build	(2-3) coats 150-225 µm	(2-3) coats 100-150 µm	(1-1.5) coats 25-35 µm
Theoretical Coverage (one coat)	4 - 6 m <sup>2</sup> /L 75 µm	7 - 8 m <sup>2</sup> /L 50 µm	11 - 12 m <sup>2</sup> /L 25 µm

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## Sanding

<b>DRY</b>	: 2K – P400	Basecoat – P500
<b>WET</b>	: 2K – P600	Basecoat – P600+P800

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**Gloss** : Matt

**Colour** : Grey, White and Black

**Storage life** : Under normal storage conditions and unopened tins up to 2 years.

## Next Layer

All Finishes

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## Cleaning of Equipment



After use, clean all equipment with Universal Acrylic Reducers and Cleaning Thinners

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## Protection



Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



For more detailed information please see Safety Data Sheet.