

## AB-URPH6000 2K-4+1 Urethane Primer

### Field of application

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

### General Information

**AB-URPH6000 2K-4+1 Urethane Primer** is a premium quality, two-component, high solid colourable primer. It provides excellent adhesion to all kind surfaces. (galvanized steel, sheet metal, bronzes, aluminium and plastic surfaces, etc.) It provides application and time advantages with its wide application.

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



**AB-URPH6000 2K-4+1 Urethane Primer** 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:** The surface must be lightly abraded and completely rust-free before application. **AB-URPH6000 2K-4+1 Urethane Primer** can be applied directly and provides excellent adhesion, but has limited corrosion resistance. Epoxy Primer is recommended where optimum corrosion resistance is required

**Other Bare Metals:** It can be applied directly on it.



**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).

**Plastic Surfaces:** It can be applied directly to all kinds of plastic surfaces except PE or/and PP-PE blend surfaces. (PE or/and PP-PE blend surfaces must be passivated by heat before application.) Bare Plastic Substrates sanded with P320-280 grade paper (dry) after baking at 60°C for 30 minutes or blow dry. After the surface is thoroughly cleaned, the application can be made. On sensitive plastic surfaces such as thermoplastics, solvent test should be performed on the surface and it should be checked whether it reacts.

**Polyester Fillers** should be dry sanded using a sequence of grade of paper grades suitable for the chosen application of **AB-URPH6000 2K-4+1 Urethane Primer**:  
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	2K Hardeners	Universal Reducers
Up to 18 °C	AB-URPH6100 2K- 4+1 Urethane Hardener Fast	AB-URDC 5001 Uni Urethane Reducer Fast
18-25 °C	AB-URPH6100 2K- 4+1 Urethane Hardener Medium	AB-URDC 5001 Uni Urethane Reducer Medium
25-35 °C	AB-URPH6100 2K- 4+1 Urethane Hardener Medium	AB-URDC 5001 Uni Urethane Reducer Slow
Over 35 °C	AB-URPH6100 2K- 4+1 Urethane Hardener Slow	AB-URDC 5001 Uni Urethane Reducer Extra Slow

## Mixing Ratio

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

**4:1** AB-URPH6000 2K-4+1 Urethane Primer: AB-URPH6100 2K- 4+1 Urethane Hardeners



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

**4:1** AB-URPH6000 2K-4+1 Urethane Primer: AB-URPH6100 2K- 4+1 Urethane Hardeners + AB-URDC 5001 Uni Urethane Reducers

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

**4:1** AB-URPH6000 2K-4+1 Urethane Primer: AB-URPH6100 2K- 4+1 Urethane Hardeners+ AB-URDC 5001 Uni Urethane Reducers

## Mix Tables

	as HS FILLING PRIMER			as MS SURFACER			as WET ON WET		
	Mixing Ratio	Volume (L)	Weight (gr)	Mixing Ratio	Volume (L)	Weight (gr)	Mixing Ratio	Volume (L)	Weight (gr)
AB-URPH6000 2K-4+1 Urethane Primer	4	0,625	1.000	4	0,625	1.000	4	0,625	1.000
<b>AB-URPH6100 2K- 4+1 Urethane Hardeners</b>	1	0,156	148	1	0,156	148	1	0,156	148
AB-URDC 5001 Uni Urethane Reducers	0,3-0,36	0,050	45	0,7-0,8	0,113	100	0,8-0,9	0,136	120
<b>Total Weight (g)</b>		<b>0,831</b>	<b>1.198</b>		<b>0,894</b>	<b>1.253</b>		<b>0,917</b>	<b>1.273</b>
Application Viscosity DIN4 20 °C	35-40"			20-25"			16-18"		
Pot life at 20 °C	45-90 minutes			60-90 minutes			60-90 minutes		

## Application



	Filling Primer	Surfacer	Wet on Wet
Spray gun nozzle (mm)	1,6-1,8	1,4-1,6	1,3-1,5
Air Pressure (Bar) RP, LVLP	1,8-2,2	1,8-2,2	1,8-2,2
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	1-1,5 Coats
Flash off at 20 °C	5-10 minutes (till matting)	5-10 minutes (till matting)	5-10 minutes (till matting)

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## Drying Times and Thickness



Air Dry 20 °C	Filling Primer	MS Surfacer	Wet on Wet
Dust free	10-15 minutes	10-15 minutes	5-10 minutes
Dry to handle	2 hours	2 hours	1 hour
Dry to tape	2-3 hours	2-3 hours	1 hour
Dry to sand	6-8 hours	3-4 hours	1 hour
Ready for Top Coat (Wet on Wet)	-	-	Min 15 minutes
Forced Dry 60 °C	Filling Primer	MS Surfacer	Wet on Wet
Dust free	-	-	-
Dry to handle	20-30 minutes	20-30 minutes	-
Dry to tape	20-30 minutes	20-30 minutes	-
Dry to sand	20-30 minutes	20-30 minutes	-
Spray gun nozzle	1.6 mm	1.6 mm	1.3mm
Total Film Build	(2-3) coats 160 -250 µm	(2-3) coats 90-135 µm	(1-1.5) coats 25-35 µm
Theoretical Coverage (one coat)	4-6 m <sup>2</sup> /L 70 µm	7 - 8 m <sup>2</sup> /L 45 µm	11 - 12 m <sup>2</sup> /L 25 µm

\*\*\*All these drying conditions occur under standard application conditions (20-25 °C and 50-55 % relative humidity.) All conditions may change depending on temperature, relative humidity, and environmental conditions.

## Sanding

**DRY** : 2K – P400 Basecoat – P500  
**WET** : 2K – P600 Basecoat – P600+P800

**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.