

285-21

2.1 VOC Primer - Flexible (4:1 Pre-Mix)



A brand of BASF –
We create chemistry

- Application:** A low VOC flexible primer with outstanding dry sanding characteristics
- Key Features:** Fast drying at ambient temperatures. Excellent for baking application. Excellent corrosion/weather resistance.
- Remarks:**
- Choose hardeners and reducers according to temperature and size of areas to be painted.
 - Pre-Mix mixing ratios between 4:1 (25% 522-333) and 2:1 (50% 522-333) may be used. For 50%: refer to TDS 285-21 2.1 VOC Primer - Flexible (2:1 Pre-Mix).
 - All bumpers to be considered flexible

VOC ready for use 245 g/l 2 lb/gal



Mixing Ratio Pre-Mix

100 parts by volume 285-21
25 parts by volume 522-333

4:1:1



Mixing Ratio

100 parts by volume Pre-Mix



Hardener

25 parts by volume 929-100, -105, -115, -120, -130



Reducer

25 parts by volume 352-25, -45



Spray viscosity at 68°F / 20°C

DIN 4: 14 s

Potlife at 68°F / 20°C

45 min

Safety advice:



Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Safety Data Sheet (SDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.

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Application:	 Compliant gravity-feed spray gun	 HVLP spray gun
Nozzle pressure		10 psi
Nozzle size		1.5-1.7 mm
Number of spraycoats	2-3 medium wet coats	
Flash-off at 68°F / 20°C	5 min between coats	
Film thickness	2-6 mil	



Drying at 68°F / 20°C 90 min

Drying at 140°F / 60°C 30 min



Infrared (short wave) 5-6 min



Sanding manual, wet 320-360



Sanding manual, dry 320-360



Orbital sanding, dry 320-360

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document

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