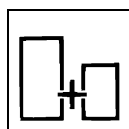
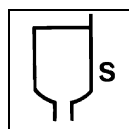
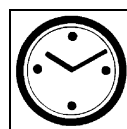




04318 - FIX-O-DUR EC

1000 ml +
1000 mlPot life at 20° C:
24 h15-17" DIN 4
at 20° CØ 1,4 mm
4 Atm
HVLP:
Ø 1,2-1,3 mm
2 Atm
N° of coats: 2Air drying at 20° C:
60'**DESCRIPTION**

Two pack anti-corrosive grey etch primer, free from chromates and lead.

USE

Suitable in car refinishing as a primer on bare patches.

CHARACTERISTICS

- Excellent adhesion on steel sheets, on aluminium and light alloys, zinc-coated sheets and stainless steel
- Good covering power
- Very high anti-corrosion protection
- Fast drying
- Chromate-free and lead free

SUBSTRATE PREPARATION**Steel sheet**

Degrease with 00695 SILICONE REMOVER SLOW, sand if necessary.

Aluminium, light alloys, zinc-coated sheet

Degrease with 00695 SILICONE REMOVER SLOW.

Stainless steel sheet

Sand and degrease with 00695 SILICONE REMOVER SLOW.

Old coatings

Do not apply on solvent-sensitive films (i.e. T.P.A.)

Putties and polyester primers

It may be applied on sanded polyester primers, while putties and polyester primers **must never be applied to 04318 FIX-O-DUR EC.**

Always previously verify the adhesion on aluminium alloys and on zinc-coated steel sheet.

APPLICATION

Spray application.

Mixing ratio:

	volume	weight
04318 FIX-O-DUR EC	1000 ml	1000 g
00328 FIX-O-DUR EC HARDENER	1000 ml	810 g

Prepare the mixture in non-metallic containers (polyethylene or glass).

Pot life at 20° C: 24 hours (if the product is stored in PE or glass containers, it can also be used at a later time, reintegrating with fresh product)

Spray viscosity at 20 °C: 15 - 17" DIN 4

Ø Air cap: conventional gun 1.4 mm; HVLP gun 1.2-1.3 mm

Air pressure: conventional gun 4 Atm; HVLP gun 2 Atm

N° of coats: 2

Recommended film thickness: 10-15 µ

Coverage (theoretic value): 1 l of mixture = 13 m² by 10 µ

1 kg of mixture = 14 m² by 10 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 780 g/l

This product ready for use contains at most 750 g/l VOC

DRYING TIME

Air drying at 20 °C:

Dust-free: 8 – 10 min.

Handling: 20 min.

Through-drying: 60 min.

SANDING

Not necessary. If some hours have passed from the application rub down with Scotch Brite (Ultrafine) before overcoating.

OVERCOAT WITH

- Nitro-combi, polyurethane (D/D and W/W) and polyacrylic primer fillers from the Lechler car refinish range.
- Air drying and low baking synthetic enamels and acryl-polyurethane enamels: allow the primer to dry for 60 min. at 20° C.

TECHNICAL DATA SHEET N° 0326-GB

UPDATED 11/2019

All information contained in this data sheet is the result of carefully controlled tests and is correct to the best of Lechler's knowledge at the time of issue. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated and the manner of use is the sole responsibility of the user. FOR PROFESSIONAL USE ONLY.