

## S2025 – 4:1 HS PRIMER FILLER

<p><b>FEATURES</b></p>	<p>Is a high solids 2007 VOC compliant two component acrylic coating, which can be used as multi-role coating:</p> <ol style="list-style-type: none"> <li>1. High Build Primer Filler for spot repairs. (use at 4:1)</li> <li>2. Primer Surfacer for large areas. (use at 4:1+10% thinner)</li> <li>3. A Non Sand (wet on wet) sealer. (use at 4:1+20% thinner)</li> <li>4. Tintable with up to 10% with acrylic mixing base.</li> </ol>
<p><b>BENEFITS</b></p>	<p><b>S2025</b> Offers excellent opacity and hiding power.</p> <p><b>S2025</b> Has excellent film build and surface levelling properties.</p> <p><b>S2025</b> Can be air dried, low baked or I.R. cured.</p> <p><b>S2025</b> Is easy to sand and gives perfect gloss holdout.</p>
<p><b>SURFACE PREPARATION</b></p>	<p><b>Step 1:</b> Degrease with Precleaner or panel prep and allow to dry. E.g. S2000, S2001 or S2002</p> <p><b>Step 2: Abrade the surface</b></p> <p><b>Original paint:</b> Wet flat P320 or Dry flat P280.  <b>Bare metal:</b> Abrade with P180. <b>(Aluminium and zinc coated steel):</b> Must first be coated with 1-2 light coats of ACID #8 1K etch primer and allowed to dry for 20 minutes.  <b>GRP, SMC, Glass fibre, Polyester Filler:</b> Dry flat P240.  <b>E-coat:</b> <b>S2025</b> Is suitable for direct application to unabraded E-coated panels.</p> <p><b>Step 3:</b> Degrease with System 20 Degreaser.</p> <p><b>Step 4:</b> When dry flat down primer, wet flat P800 or Dry flat P320, repeat <b>Step:1</b>. Apply base coat and clear coat e.g. S2083</p>
<p><b>V.O.C. information</b></p>	<p>The EU limit for this product (product category: IIB.c) in ready to use form is 540g/litre.</p> <p>The VOC content of this product in ready to use form is 540g/litre.</p> <p>Solids of primer base is 1275g/l.</p>

# U-POL™

## TECHNICAL INFORMATION

Colour	Grey		
	High Build Primer Filler	Primer Surfacer	Wet on Wet Surface
Mixing Ratio 2025:2030/31/32/33: 2040/41/42/44/46	4:1	4:1:10%	4:1:20%
RFU VOC g/l	453	495	535
Viscosity DIN 4/sec.	50 - 65	40 - 45	25 - 30
Spray Gun	U-POL HVLP Gravity Gun		
Air Pressure	2 bar at the gun		
Gun Tip size/mm	2.0	1.7	1.3 - 1.7
Coats	1 - 2	2 - 3	1 - 2
Build / microns.	180	100 - 120	30 - 60
Flash Off/min.	15	10	10
Dry to Sand Air/hours	3 - 4	3 - 4	2 - 3
Dry to Sand 60°C/min.	20 - 30	20 - 30	20 - 30
Dry to Sand I.R/min.	15	15	15
Pot-Life/hours	1 - 2	1 - 2	2 - 3
Wet Sanding/abrasive	600 - 800	600 - 800	600 - 800
Dry Sanding/abrasive	320 - 400	320 - 400	320 - 400

## TEMPERATURE RANGE FOR USE OF SYSTEM 2030 HARDENERS

Temp °C	-5	0	5	10	15	20	25	30	35	40	+45
Hardener											
S2031											
S2030											
S2032											
S2033											

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