

Technical Information

20-94



20-94 high build application

Process for primerfiller, high build application

- High solids containing primer filler, fast drying and easy sandability
- Repairs with larger bare metal areas should prior be treated with 27-10 2K Wash primer

Can be mixed with 20-24 and 20-34 to get different grey shades, according to the grey shade poster.

VOC ready for use	540 g/l	4.5 lb/gal
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Application

	Mixing Ratio 4:1:1	100 % by volume	20-94
		25 % by volume	50-15, -20
		25 % by volume	60-10, -20, -30, -40
	Spray viscosity at 68°F / 20°C	DIN 4: 20-24 s	
	Potlife at 68°F / 20°C	1 h	
	HVLP spray gun		
	Nozzle size	1.6-1.8	
	Application pressure	29 psi	
	Nozzle pressure	10.2 psi	
	Compliant gravity-feed spray gun		
	Nozzle Size	1.6-1.8	
	Application Pressure	29 psi	
	Number of spraycoats	3 -4	
	Film thickness	4-8 mils	

Safety advice:

The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & 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 & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & 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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Drying

	Drying at 68°F / 20°C	16 h
	Drying at 140°F / 60°C	40 min
	Infrared (short wave)	8 min
	Infrared (medium wave)	10-15 min

Sanding

	Sanding manual, wet	P800
	Orbital sanding, dry	P400 / P500

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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