3300 SPRUZZO

SPRAY POLYESTER PRIMER

B + A Two-component

Spray

Description and Use

Two-component primer for spray application based on unsaturated polyester resins to be cured with a liquid organic peroxide.
It may be sanded both dry or wet conditions. It is suitable for applications in industry and car body shop instead of regular filler paste, especially in case of large or complex surfaces.
Product also suitable for nautical use.

Substrate preparation

Surface must be dry, clean, free from dust or grease and made rough by sanding.

Suitable substrates:
Steel, cast iron, aged car paints and fiberglass free of detaching agents. For further information apply to our TECHNICAL SERVICE.

Not suitable substrates:
Aluminium, zinc plated steel and light alloys, wash primer, epoxy primers with phenolic hardeners, thermoplastic varnishes, solvent sensitive primers.

Application

Application method:
- air mix spry gun with nozzle Ø 2.2.2.5 mm and pressure of 2-4 bar.

Product preparation:
Stir thoroughly the part “A” before using, then add the hardener in the following ratio:
Do not cure quantities more than 1 kg on purpose to avoid the “mass effect” which reduces notably the life time of the mixture. Clean equipment immediately after use with CELLULOSE thinner.

	By weight	By volume
PRODUCT 3300 SPRUZZO	150	100
HARDENER 4401 CATALIZZATORE	5	5

Dilution:
Not required, if necessary 5% maximum with DILUENTE PER POLIESTERE (thinner for polyester) code 1626.

IMPA S.p.A Unipersonale Via Crevada, 9/E 31020 San Pietro di Feletto (TV), Italy Tel. +39 0438 4548 Fax +39 0438 454915
Società soggetta ad attività di direzione e coordinamento di Fassa S.r.l. - info@impa.it - www.impa.it

Infrared rays lamps:
Using medium or short waves IR lamps, waiting time before sanding can be reduced, getting at the same time a drier surface.
After application allow some minutes before radiating the filler.
It is important that the filler temperature never exceeds 60°C (140°F).
Refer to the lighting system manufacturer to get correct user information (e.g. times and distances).

Sanding:
after 3 hours at 20°C, after 30 minutes in the oven at 60°C (140°F) or IR radiation.
Dry sanding using P240 grit or finer (e.g. p320), using P120 or finer (e.g. P180) if wet sanded.

Recoating:
After sanding. For best result, spray a coat of insulating primer EQUALIX HS code 1513 or STAR PRIME HT code 1543 before applying the finishing paint.

Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life of 12 months. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with current legislation.

Technical features

Colour	grey
Specific gravity comp. A	1.54 kg/l (± 0,03)
Viscosity part "A"	5000 ÷ 6500 mPa·s Brookfield rpm 20 s 4
Gel time	25 minutes (± 3)
Recommended thicknesses	400 µm dry film
Complete polymerisation	after 24 hours
Flexibility	good
Water resistance	very good
Solvent resistance	good
Practical cover rate *	2 m²/l (2 layers)
EU limit value of VOC content (Directive 2004/42/EC)	Category B/b, SB: VOC max 250 g/l product VOC < 250g/l
* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.	
The data are measured at a temperature of 20°C and 65% R.H.	

IMPA S.p.A Unipersonale Via Crevada, 9/E 31020 San Pietro di Feletto (TV), Italy Tel. +39 0438 4548 Fax +39 0438 454915
Società soggetta ad attività di direzione e coordinamento di Fassa S.r.l. - info@impa.it - www.impa.it

Warnings

- For professional use only.
- Always read the safety datasheet before use.
- Solvents or thinners used for cleaning tools, as well as any product residues, must not be released into the environment or poured down domestic drains. The recipient/product/thinner or cleaning solvent must be disposed of in accordance with national regulations.
- Clean equipment immediately after use with cellulose thinner.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market can lead to slight deviations in the declared values. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

Avoid to apply when temperature is below + 10°C (50°F)

IMPA S.p.A Unipersonale Via Crevada, 9/E 31020 San Pietro di Feletto (TV), Italy Tel. +39 0438 4548 Fax +39 0438 454915
Società soggetta ad attività di direzione e coordinamento di Fassa S.r.l. - info@impa.it - www.impa.it