



HYDRAX

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WATERBASED 1K PRIMER

DEFINITION

HYDRAX is a waterbased 1k primer for car refinishing. It has high building power, fast drying and it is easy to sand on both dry and humid applications.

It is suitable for applications made on spot as well as on large repairs and it ensures an excellent adhesion power on all kind of sanded surfaces of different substrates used in car refinishing, such as steel, aluminium, galvanized, stainless and plastics, as well as in OEM finishing, polyester putties or wash primers.

It can be repainted with waterbased basecoat systems.

As it is a waterbased product, it contains a very low concentration of organic solvents, which makes it respectful with the environment and with the worker's health.

It contains anticorrosion additives to protect the steel against oxidation.

PHYSICAL CHARACTERISTICS

Nature:	Acrylic dispersion	
Colour:	Grey	
Specific weight:	1,3 kg/l at 20°C	
Dry film thickness:	35-45 microns	per coat
VOC:	164 g/l	Mixing application
Solid content:	56 %	Mixing application
Yield:	8-10 m ² /l	40 microns






SURFACE PREPARATION

	<i>Primer surfacer</i>	<i>Non sanding</i>
	P240 - P320	P400
	✓	✓

MIXING RATIO






		<i>Primer surfacer</i>		<i>Non sanding</i>	
		<i>Vol</i>	<i>Weight</i>	<i>Vol</i>	<i>Weight</i>
	Hydrax	100	100	100	100
	Solvent (desmineralized water)	0 - 5	0 - 4	15	11
	F/4 at 20°C	60"		20"	

APPLICATION METHOD

		Primer surfacer	Non sanding
	HVLP	1,6 - 1,8	1,2 - 1,4
	HVLP	2 - 2,5	2 - 2,5
 cm	HVLP	10	10
	Coats	2 - 3	1
	20°C	5' - 10' *	-



* Apply next coat alter the first has dried.

DRYING TIMES

		Primer surfacer	Non sanding
 20°C		-	Min 30' * Max 60'
 20°C		3 - 4 h	-
 60°C		25' - 30'	-
 IR Medium wave 60cm	FLASH OFF	5'	-
	FULL BAKE	10'	-
 IR Short wave 80cm	FLASH OFF	3'	-
	FULL BAKE	5'	-

* Venturi can be used to fasten this process, alter 5' of the flash off time.

SANDING

		Primer surfacer	Non sanding
 ORBITE 3 - 5	INITIAL	P400	-
	FINAL	P500	SANDING PAD MICROFINE
	INITIAL	P600	-
	FINAL	P800	P1000

REMARKS

Longer drying times should be considered when the product is applied with a relative humidity higher than 70% or at temperatures lower than 10°C.
It is important to wait on the recommended flash off times.

EQUIPMENT CLEANING

Use a special cleaning thinner for solvent-based basecoat systems.

SAFETY

Follow instructions of product label. For more information check the Safety Data Sheet. Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

STORAGE

Store the product in a ventilated place far from direct exposure to sunlight. Keep between +5°C and +30°C. Store free from frost.

GUARANTEE

In unopened original packaging, one year from manufacturing date.

SUGGESTION:

If the product is used at low temperatures, heat the support previously to improve the drying. An IR lamp can be used.

For any technical information contact with our Customer Attention Service or our Technical Department. ROBERLO SA declines any responsibility due to an incorrect use of the product.