

Products Application Process

Products	Mixing Ratio	Hardener Reducer	Pot Life	Nozzle	Application	Flash off between coats	Flash off before baking	Dry	Sanding
A8402 Wash Primer	1:1	A8117	3 – 4 hours	Ø 1.1 - 1.3	1 - 2	/	5 -10 min	5 – 10 min	P180-P220 P320-P400
A832, A834 A835, A836 Plastic Primer	Ready for use		4 hours	Ø 1.3 - 1.5	1 - 2	3-5 minutes	10 – 15 min before next process		P400-P500 P600-P800
A846 Wet-on-Wet Primer	3:1:1 100:25:15-20	Hardener A801/802/803 Reducer A810/811/812	40 min	Ø 1.3 - 1.5	1 - 1.5	/	10 – 15 min before next process		P320-P400 P600-P800
TDM39 HS High Build Primer	5:1:0.25-0.5 100:12.5:3-7	Hardener A801/802/803 Reducer A810/811/812	4 hours	Ø 1.5 - 1.7	2 - 3	3-5 minutes	10 – 15 minutes	60 °C 60-80 min 23°C 4-5 hours	P320-P400-P500 P600-P800
Tintable Primer Surfacer A8830 <input type="checkbox"/> A8831 <input type="checkbox"/> A8832 <input type="checkbox"/>	Wet-on-Wet 3:1:2 100:20:40	Hardener A8809 A801/802/803 Reducer A810/811/812	1 hour	Ø 1.3 - 1.5	1-2 layers	3 – 5 min	10 – 15 min before next process		P320-P400 P600-P800
	Sanding 3:1:1 100:20:20			Ø 1.5 - 1.7	2-3 layers		5 - 8 min	60 °C-30 min 23°C - 1 hours	P320-P400-P500 P600-P800
Primer Surfacer	3:1:1 100:20:20	Hardener A801/802/803 Reducer A810/811/812	1 hour	Ø 1.5 - 1.7	2-3 layers	3 – 5 min	5 - 8 min	60°C-30 min 23°C-60-90 min	P320-P400-P500 P600-P800
A831 4:1 Primer Surfacer	3:1:1 100:25:25	Hardener A801/802/803 Reducer A810/811/812	1 hour	Ø 1.5 - 1.7	1-2 layers	3 – 5 min	5 - 8 min	60°C -40 min 23°C 3-4 hours	P320-P400-P500 P600-P800
A844 5:1 Epoxy Primer	1:0.4:0.55 100:60-80	Hardener A891 Reducer A892 A810/811/812	2 hours	Ø 1.3 - 1.6	1-2 layers	2 – 3 min	3 - 5 min	60°C -30 min 23°C - 4 hours	P80-P120-P180 -P240-P320 P400-P600
A138 2K Production Clear Coat	2:1:0.1-0.4 100:50:5-20	Hardener A139F/139/19S Reducer A810/811/812	2 hours	Ø 1.3 - 1.5	2 - 3 layers	5 - 8 min	8 - 10 min	60 °C 45 min 23°C 4-5 hours	P1000-P1500 Trizact P1500-P3000
A850 Weather-resi- stant clear 2:1	2:1:0.1-0.4 100:50:5-20	Hardener A801/802/803 Reducer A810/811/812	2 hours	Ø 1.3 - 1.5	2 - 3 layers	5 - 8 min	8 – 10 min	60 °C 35 min 23°C 4-5 hours	P1000-P1500 Trizact P1500-P3000
A852 MS Clear 2:1	2:1:0.3-0.5 100:50:15-25	Hardener A801/802/803 Reducer A810/811/812	2 hours	Ø 1.3 - 1.5	2-3 layers	5 - 8 min	8 - 10 min	60 °C 40 min 23°C 3 - 4 h	P1000-P1500 Trizact P1500-P3000
A853 Anti-solvent popping MS clear 2:1	2:1:0.3-0.5 100:50:15-25	Hardener A801/802/803 Reducer A810/811/812	2 hours	Ø 1.3 - 1.5	2 - 3 layers	5 - 8 min	8 - 10 min	60 °C 40 min 23°C 3-4 hours	P1000-P1500 Trizact P1500-P3000
A855 Hi-weather-re- sistance clear 2:1	2:1:0.2-0.4 100:50:10-20	Hardener A801/802/803 Reducer A810/811/812	2 hours	Ø 1.3 - 1.5	2 - 3 layers	5 - 8 min	8 - 10 min	60 °C 40 min 23°C 3-4 hours	P1000-P1500 Trizact P1500-P3000
A857 Low VOC HS Clear 2:1	2:1:0.4-0.6 100:50:20-30	Hardener A804 Reducer A810/811/812	2 hours	Ø 1.3 - 1.5	1 - 2 layers	5 - 8 min	8 - 10 min	60°C 25 min 23°C 1.5 - 2 h	P1000-P1500 Trizact P1500-P3000
A867 Matt Clear Coat	3:1:0.6-0.8 100:50:20-25	Hardener A801/802/803 Reducer A810/811/812	2 hours	Ø 1.3 - 1.5	2 - 3 layers	8 - 10 min	15 - 20 min (Until matte)	60°C 35 min 23°C 3 - 4 h	P800-P1000 -P1500
A770 Super Curing Clear Coat 4:1	4:1:0-0.4 100:25:0-25	Hardener A707/A707S Reducer A810/811/812	30 min	Ø 1.3 - 1.5	2 - 3 layers	3 - 5 min	3 - 5 min	60°C 5 min 23°C 25-35 min	P1000-P1500 Trizact P1500-P3000

Application table of hardeners and reducers

Product	Fast		Standart		Slow	
	5 ~15 , 40 ~60		15 ~25 ,60 ~80		25 ~35 , 80 ~95	
	Hardener	Reducer	Hardener	Reducer	Hardener	Reducer
A832, A834/A835/A836 Plastic Primer	/	/	/	/	/	/
A8402 Wash Primer	A8117	/	A8117	/	A8117	/
A844 5:1 Epoxy Primer	A891	A892/A810	A891	A892/A810	A891	A892/A812
A846 Wet on Wet Primer	A801	A810	A802	A811	A803	A812
A8830/8831/8832 Tintable Prime Surfacer	A801	A810	A802	A811	A803	A812
A8833 Primer surfacer	A801	A810	A802	A811	A803	A812
A831 4:1 primer surfacer	A801	A810	A802	A811	A803	A812
A839 HS High Build Primer	A801	A810	A802	A811	A803	A812
138 2K Production Clear Coat	A139F	A810	A139	A811	A139S	A812
A850 Weather-resistant clear 2:1 A852 MS Clear 2:1 A853 Anti-solvent popping MS clear 2:1 A855 Hi-weather-resistance clear 2:1	A801	A810	A802	A811	A803	A812
A857 Low VOC HS Clear 2:1	A804	A810	A804	A811	A804	A812
A770 Super Curing Clear Coat 4:1	A770	A810	A770	A811	A770	A812
A867 Matt Clear Coat	A801	A810	A802	A811	A803	A812

