CARMASTER

TECHNICAL DATA SHEET

CP-6120 CARMASTER 2 PACK HI BUILD PRIMER-FILLER

PRODUCT DESCRIPTION

Carmaster 2 Pack Hi Build Primer-Filler is a two pack acrylic urethane high build primer designed for use as a general smash quick drying high build primer-filler that is easy to sand.

It can also be thinned out and used as a primer surfacer and offers excellent film build, sanding and gloss holdout. Another benefit is that it can be tinted with Paraglaze Gloss (PT-G) tinters.

While Carmaster products have been tried and tested to be suitable for use in the harsh Australian conditions, they do not benefit from inclusion in the PROTEC® Autoguard Warranty program. If you require the assurance of a warranted product system, products from the Paraglaze range should be selected.

PRODUCTS

Carmaster 2 Pack Hi Build Primer-Filler	CP-6120
Carmaster Fast Hardener	CH-5100
Carmaster Normal Hardener	CH-5200
Carmaster GP 2 Pack Reducer	CS-3800
Protec Flex Additive	AA-5656
Protec Heavy Duty Wax & Grease Remover	AA-6822

SUBSTRATES & PREPARATION

Carmaster 2 Pack Hi Build Primer-Filler can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE	PREPARATION
Sound OEM finishes and sound, fully cured 2 pack refinish finishes	P240 - P320 (dry)
Small areas of bare steel	P240 - P320 (dry)
New electrocoated panels	P240 - P320 (dry)
GRP & Fibreglass	P240 - P320 (dry)
Plastics	*Protec* Plas Stik Primer - where recommended in the AP-4880 / AP-4990 Technical Data Sheet

Large areas of bare steel and areas where polyester body filler will be applied should be coated first with AP-4110 Protec Epoxy Primer (faster option) or PP-3450 Paraglaze CT 2K HP Epoxy Primer - Grey or AP-4441 Protec Etch Primer.

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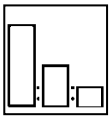
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

CLEANING

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover.

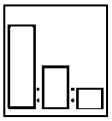
MIXING RATIO BY VOLUME



PRODUCT	PARTS
CP-6120	4
Carmaster Hardener	1
CS-3800	10 - 30%

If tinting: add up to 10% of Paraglaze Gloss (PT-G) tinter before adding hardener.

FLEXIBILISATION



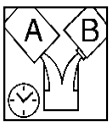
AA-5656 *Protec* Flex Additive must be used at the following ratios when applying CP-6120 over plastics or when the product is used at high film thickness, to ensure proper flexibility of the primer film:

PLASTIC TYPE	HARD PLASTICS	FLEXIBLE PLASTICS	HIGHLY FLEXIBLE PLASTICS
PRODUCT	**PARTS**		
Uncatalysed CP-6120	Not Required	5	2
AA-5656		1	1

Always add AA-5656 to CP-6120 first and thoroughly mix → Then add hardener and reducer as per the normal recommendation above.

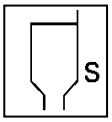
Note: Higher levels or AA-5656 will slow the drying time of CP-6120.

POTLIFE



Catalysed material is useable for up to 1 hour at 25°C.

SPRAY VISCOSITY



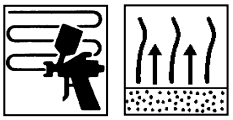
19 - 24 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS *(GRAVITY)*

SETUP 1.6 - 1.8 mm

SPRAY PRESSURE
- HVLP / RP: 1.6 - 2.0 bar
- CONVENTIONAL: 2.0 - 3.0 bar

APPLICATION & FLASH OFF *(at 25°C)*



• COATS: Apply one even medium coat followed by one or two even wet coats, as required. Do not exceed 4 coats.

• FLASH OFF BETWEEN COATS: 5 minutes

DRYING TIME & TEMPERATURE

AIR DRY: Overnight at 25°C

BAKE: 40 minutes at 60°C

Note: Temperature shown is metal temperature

I.R.: 12 - 16 minutes (short wave)

Will vary depending upon equipment. Refer to equipment supplier

TOTAL DRY FILM BUILD

140 - 180 µm

OVERCOAT / RECOAT

TIME: Within 72 hours

The vehicle must be kept dry and free of moisture and contaminants during this period.

PREPARATION: P500 (dry) OR P800 (wet)

Carmaster 2 Pack Hi Build Primer-Filler may be topcoated with the following:

- Refinish basecoats
- Refinish two pack polyurethane topcoats (i.e. direct gloss topcoats)

Refer to the relevant topcoat Technical Data Sheet for further details.

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

Protec hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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