

# 222S

## ADHESION PROMOTER

### Description

A ready-to-spray adhesion promoter for use over OEM clearcoat finishes.

### Products

222S            Adhesion Promoter

### Properties

- A ready-to-spray transparent adhesion promoter for use over OEM clearcoat finishes used on most clear over base finishes.
- Is designed to be used with acrylic based topcoats.

### Substrates

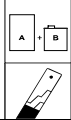








- cleaned and sanded OEM finishes
- cured repaired finishes
- 131S Fill'n'Sand 1K Acrylic Primer
- 1040R, 1141S/1144S/1147S



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### PRODUCT PREPARATION

	<b>Mixing ratio</b>	Ready for use		
	<b>VOC</b>	790 g/li		
	<b>Pot life at 20°C</b>	Not applicable		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	16-18 s 16-18 s 18-20 s	
	<b>Spray equipment</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	<b>Fluid tip</b>	<b>Spray distance</b>
			1.4-1.6 mm 1.6-1.8 mm 1.3-1.5 mm 1.0-1.2 mm	15-20 cm 15-20 cm 10-15 cm 15-20 cm
	<b>Spray pressure</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	2-2.5 bar 2.5-3 bar 0.7 bar at nozzle 3-4 bar	
	<b>Number of coats</b>	1 coat maximum		
	<b>Flash time</b>	15 min. before topcoating		
	<b>DFT</b>	15-20 μ		
	<b>Drying</b>	15 min. to 1 h maximum after 1 h recoat. Detail sanding (after flash time) Wet : P800 - P1000 Dry : P360 - P400		
	<b>IR drying*</b>	Not recommended		
<p>This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.</p>				

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### RECOMMENDED USE

#### Surface preparation

The entire panel has to be carefully prepared (before basecoat application):

1. Clean surface with water and soap.
2. Degrease with 3919S and wipe dry with clean cloth.
3. Repair according to damage.
4. Wet sand with P1200 or treat with 1500S the remaining surface of the panel.
5. Degrease with 3920S and wipe dry with clean cloth.
6. Tack rag.
7. Apply basecoat Centari® 600 or Centari® 6000 and blend out. Finish with DuPont 1K/2K clear.

#### Chemical resistance

When fully cured, 222S is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol

#### Equipment cleaning

Use 3608S.

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### RECOMMENDED USE (con'd)

#### Recoatability

At any time after tape-free time.

Products	Packages (li)	Storability at 20°C (year)
222S	0.946 - 3.785	2

#### Remarks

- Does not require a topcoat clear beyond the blend-out zone, though 222S should not be used as a clearcoat to protect pigment.
- Be sure to apply 222S to areas where colour/clear will be blended.
- To assist in laydown of metallics, apply 222S to panel as an antistatic coat and allow flash.
- Reduces sand scratch swell marks.
- Material has to be at room temperature (18-20°C) before use.

#### Safety

Consult Material Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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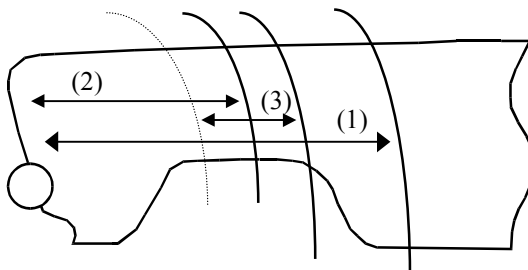
### REPAIR SYSTEMS

#### Spot repair

- When spot repairing with Centari® quality, the method as described below can be used.
  - If blending out the clear in original areas is unavoidable, the melt-in of the clear can be achieved as described below:
    - ① Apply 1 coat of 222S over the substrate, extending into area surrounding the spot.
    - ② Apply colour coats.
    - ③ Blend colour coats in the fade-out area immediately but within 222S area.
- ! Surface should be carefully and correctly prepared before the colour application. See recommended use, paragraph surface preparation.

#### Method 1

- ① Apply 1 coat 222S.
- ② Apply 1<sup>st</sup> coat colour within the previous application.
- ③ Apply 2<sup>nd</sup> coat or until hiding is achieved and blend/fade out colour within area.



Balance out the spray edge by polishing with 1500S or 3000S.

#### Method 2

- ① Apply 1 coat 222S.
- ② Apply 1<sup>st</sup> coat colour within the previous application.
- ③ Apply 2<sup>nd</sup> coat or until hiding is achieved and blend/fade out colour within area.
- ④ Apply clear.

