

# K513

## TRANSLUCENT SEALER

### Description

2K polyurethane non-sanding isolating primer.  
Composition based on hydroxylated acrylic copolymers.

### Products

K513	Translucent Sealer
AK210	2K Activator
1225R	H.S. Fillprimer Thinner

### Properties

- Excellent isolation and good filling.
- Can be used as:
  - non-sanding primer sealer;
  - tintable non-sanding primer sealer.

### Substrates

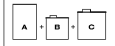







- OEM finishes, including thermoplastic acrylic finishes
- cured repaired finishes
- DuPont primers



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### PRODUCT PREPARATION

	<b>Mixing ratio</b> 	K513	<b>Volume</b>	<b>Weight</b>
		AK210	2	100
		1225R	1	41
			1	38
	<b>VOC</b>	618-625 g/li		
	<b>Pot life at 20°C</b>	2 h 30 min.		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	16 s	
		<b>FORD 4</b>	16 s	
		<b>AFNOR 4</b>	18 s	
	<b>Spray equipment</b>		<b>Fluid tip</b>	<b>Spray distance</b>
		<b>Gravity feed</b>	1.4-1.6 mm	15-25 cm
		<b>Suction feed</b>	1.6-1.8 mm	15-25 cm
		<b>HVLP</b>	1.2-1.4 mm	15 cm
		<b>Pressure feed</b>	1.2 mm	15-25 cm
	<b>Spray pressure</b>	<b>Gravity feed</b>	3.5-4 bar	
		<b>Suction feed</b>	3.5-4 bar	
		<b>HVLP</b>	0.7 bar at nozzle	
		<b>Pressure feed</b>	3.5-4 bar	
	<b>Number of coats</b>	1-2		
	<b>Flash time</b>	Between coats till flat. 30 min. at 20°C before topcoating.		
	<b>DFT</b>	30-50 μ		
<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

##### OEM and cured repaired finishes

- Clean surface with water and soap. Rinse and dry.
- Degrease with 3919S. Wipe dry.
- Wet sand with P600 - P800.
- Dry sand with P280 - P320.
- Clean with 3920S.
- Wipe dry before priming.

Treat bare metal spots with 1 coat 820R (see specific TDS).

#### Equipment cleaning

Use 3608S.

#### Recoatability

At any time after 30 min. at 20°C till maximum 8 h.

#### Remarks

- K513 is tintable with the AM Centari® MasterTints® up to maximum 10 %.
- Do not use activated K513 beyond the pot life nor reduce it further to get viscosity down again.
- Activated material should not be returned to original can of non-activated material.
- Close can of AK210 tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-20°C) before use.

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### RECOMMENDED USE (con'd)

#### Product data

Package viscosity: 896 cp  
Theoretical coverage: 5.6-9.4 m<sup>2</sup>/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
K513	1 - 4	2
AK210	0.5 - 1 - 5	2
1225R	5	2

#### Safety

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