



Art.-No.: 6.4400.1000

**4400**

## 1K WB-Express Primer

### Characteristics

This 1K waterborne primer-surfacer is designed for automotive finishes. Recoatable with all common solvent-borne and water-borne 1K and 2K finishing paints. Very fast drying and easy to sand. Can be used as insulating groundcoat for thermoplastic old coatings. High anti-corrosive protection. Adhesivity to iron, steel, aluminium, galvanized substrates and plastic. According to regulations on VOC.  
Consumption: 6 - 8 m<sup>2</sup> / liter (approx. 50 µm dry coat thickness)

### V.O.C. Value

EC limiting value for product (cat. B/c): 250 g/l (2007).  
This product contains max. 1 g/l VOC [ 0.008 lbs/gal

### Tech Tip

A noticeable acceleration of the drying time is achieved by increasing the air speed and by lower relative air humidity. Over 50 % reduction in drying time by using air blowers. (Material can be dry after 30 seconds and sandable after 1 minute).  
Store protected against frost. During the operation, keep the spray gun cup closed to avoid the hardening. Deep the spray gun nozzle in water after use.  
Optimal processing conditions:  
Air temperature: 20 - 25 ° C;  
Object temperature > 15 ° C;  
rel. Humidity: 40 - 60%,  
Air speed: > 0.3 m / s

### Application

From + 10 ° C and up to 75% relative humidity. Ensure adequate supply and exhaust air.

#### Processing:

HVLP: Spray pressure: 2.0 - 3.0 bar (0.7 bar nozzle internal pressure) / Spray nozzle: 1.2 - 1.3 mm / Spray: 2  
High pressure: Spray pressure: 3 - 4 bar / Spray nozzle: 1.2 - 1.3 mm / Spray: 2

#### Drying:

Object temp. 20 ° C: can be sprayed over after 60 minutes, dust-dry after 25 minutes, dry after 60 minutes, sandable after 4 hours  
Object temp. 60 ° C: can be sprayed over after 30 min., Dust-dry after 5 min., Touch-proof after 20 min., Sandable after 30 min.  
IR drying (short wave): sandable after 8 min.

### Technical Data

Colour	light grey (ca. RAL 7011) ?????
Dilution	0660 demineralised water, 0 - 5% by weigh
Spraying viscosity 20°C	35 - 40 s 4 mm DIN
Coat thickness / dry film	50 - 70 µm
Flash - Off	5 - 8 Min. zwischen den Spritzgängen (bis matt abgelüftet)



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## Storage and Transportation

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Keep dry and frost-protected.  
In tightly closed original containers at least 12 months shelf life.