



May 2006

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# Product Information

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Kondar

## PRODUCT DESCRIPTION

1K PRIMER

A670

Kondar is a grey 1K nitrocellulose primer surfacer. It is fast air-drying, easy to sand and gives good film build in a minimal number of coats. It has unlimited potlife, and is suitable for use under sealers and both 2K and 1K topcoat finishes.

Kondar offers good adhesion to a number of suitably prepared surfaces. These include OE finishes and sound non-synthetic paintwork. Kondar can also be used over bare metal or fibreglass which have been pre-primed with an appropriate PPG etch or epoxy primer.

High build, fast air-drying and easy to sand and repair, Kondar is ideally suited for small repairs. It is ideal for air-dry use and where airborne dirt contamination could be a frequent problem.

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## PREPARATION OF SUBSTRATE - SANDING



***Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.***

Original paintwork or fully cured 2K finishes should be sanded using P240-360 grit discs (dry) or P360-400 grade paper (wet).

Synthetic and 1K finishes, if sound and aged, should be overcoated with a suitable PPG isolating primer before subsequent application of Kondar. D834/5 DP40 Chromate-Free 2K Epoxy Surfacer or D836 Koba Plus are ideal for this purpose - please refer to the appropriate technical data sheets.

Bare steel, aluminium, GRP or fibreglass should be primed with D831/2 Universel Chromate-Free Wash Primer or D834/5 DP40 Chromate-Free 2K Epoxy Surfacer before application of Kondar.

Polyester Bodyfillers should be fully cured then dry-sanded using a sequence of P80 - P120 - P240 grade paper before application of Kondar. Fully cured Spray-Fillers should be sanded with a sequence of P240 - P360 grade paper (dry) or P600 - P800 paper (wet) before application of Kondar

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## PREPARATION OF SUBSTRATE – DEGREASING



Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner:

Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

Please see the **Deltron Cleaners (RLD63)** Technical Data Sheet for appropriate cleaning & degreasing products.

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## MIXING RATIO

A670 Kondar :

**1 vol**

D866 Deltron 2K Primer Thinner:

**approx 1 vol**

A premium quality PPG cellulose thinner may be used as an alternative to D866

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## MIXED PRODUCT DETAILS

Potlife: ***Unlimited***

*Spray viscosity:* **16-18 secs DIN4 / 20°C**

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## APPLICATION AND FLASH OFF



*Spraygun set-up:*

*Gravity* **1.6mm**

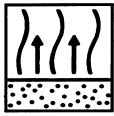
*Suction* **1.6-1.8 mm**

*Spray Pressure:* **See gun manufactures recommendations**

*Number of coats:* **2-3 wet**

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## Application and Flash Off continued



*Flash-off  
between coats at 20°C:*      **10 minutes**

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## DRYING TIMES



*Drying times:  
- Dustfree at 20°C*      **10 minutes**



*Before sanding and  
overcoating at 20°C*      **1-2 hours**

*Total dry film build:  
minimum*      **50µ**

*maximum*      **80µ**

*Theoretical  
coverage †:*      **Approx 3m<sup>2</sup>/litre**

† Theoretical coverage in thinned, ready-to-spray litres, giving a dry film thickness between indicated minimum and maximum values.

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## REPAIR AND RECOATING



*Sanding:*  
- *grade dry*      P240 followed by P360  
- *grade wet*      P600 followed by P800



*Overcoating:*      Most PPG Sealers and Topcoats may be applied over Kondar.  
Please refer to the appropriate technical data sheet(s) for full  
details.

Please see 'Performance and Limitations' section of this TDS.

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## PERFORMANCE AND LIMITATIONS



Kondar should be stirred thoroughly before thinning and before application if left to stand in the spraygun for any length of time.

Kondar is not suitable for use over plastic or other flexible substrates.

Do not attempt to use Kondar over surfaces where film build exceeds 250µ.

Do not apply more than the recommended number of coats. Excessive film build, insufficient flash-off between coats or use of non-recommended thinner will have adverse effects on Kondar's drying time, sandability and topcoat gloss holdout.

After spot-repairing with Kondar, ensure that the repair surface is carefully sanded around the edges before overcoating with topcoat or sealer.

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

The use of HVLP spray equipment can give an increase in transfer efficiency of around 10% depending upon the make and model of equipment used.

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## HEALTH AND SAFETY

**These products are for professional use only**, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: [http://www.ppg.com/PPG\\_MSDS](http://www.ppg.com/PPG_MSDS)

**PPG Industries (UK) Limited.**  
**Auto Refinish**  
**Customer Service and Sales Group,**  
**Needham Road,**  
**Stowmarket,**  
**Suffolk.**  
**IP14 2AD,**  
**England.**  
**Tel: 01449 771775**  
**Fax: 01449 773480**

