

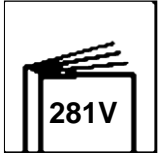


MAXI-BUILD 4:1 PRIMER

1.856.4024

(1.954.4000/6000/8000) Hardeners

FAST 2K HIGH STRUCTURE ACRYLIC FILLER FOR SPEED AND BUILD. GREY (4024)



Maxi-Build 4:1 Primers are a range of high structured 2K primers optimised for high build spot repairs & panel repairs in the refinish bodyshop. Maxi-Build 4:1 has outstanding sag resistance, fast flash off & drying. The Maxi-Build 4:1 range sand well & give good final gloss & appearance after application of topcoat. Maxi-Build 4:1 primer can be used over a wide range of substrates such as sound original paintwork, etch primed bare steel, & polyester body fillers.

SUBSTRATES

Unfinished, degreased and sanded sheet steel (small areas only).
Etch primer all other bare metals and large areas of bare steel.
Polyester putty, glass fibre reinforced plastic and gel-coat, sanded with P280-320 paper.
Old paintwork in good condition, sanded.

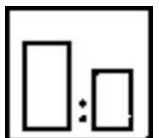
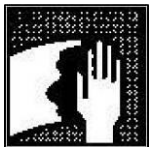
Important: When painting old solvent sensitive paintwork, make sure that the surface is free from cracks, and always apply to the entire panel. **Maxi-Build** is not suitable for isolating thermoplastic paints or those likely to flake off, but is restricted to even-out surfaces with different absorption rates.

PREPARATION

Clean existing paintwork surface with water (preferably warm) and detergent. Sand paintwork with P280-320 paper. Degrease with anti silicone Degreaser 3600 or AQUAMAX® Precleaner.

In order to guarantee maximum corrosion resistance on bare metal 1-2 coats of HP Aerosol Primer can be applied first.

	FILLER	
	VOLUME	WEIGHT
MAXI-BUILD 4:1	4	1000g
HARDENER 4000/6000/8000	1	150g
THINNER	1	135g
	Note: For accurate activation and thinning, weight mixing is recommended (See page 3).	
VISCOSITY DIN4, 20°C	32-38"	
POT LIFE	30 minutes @ 20°C	



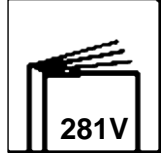


MAXI-BUILD 4:1 PRIMER

1.856.4024

(1.954.4000/6000/8000) Hardeners

HARDENERS - THINNERS



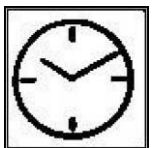
HARDENER	4000	Slow	Partial and spot repairs above 25°C
	6000	Rapid	Partial and spot repairs up to 25°C.
	8000	Extra rapid	Spot repairs below 25°C.
THINNERS	4320	Slow	All repairs above 30°C
	2710 4310	Normal	Repairs between 20°C - 30°C
	4305	Fast	Small repairs below 25°C

APPLICATION



CYCLE	<u>PRIMER FILLER</u>	
Equipment	<i>Compliant</i>	<i>HVLP</i>
Gravity Gun Fluid Tip (mm)	1.8 - 1.9	1.8 - 1.9
Spray-Gun pressure (bar)	Refer to spraygun manufactures recommendations	
Number of coats	3 full coats (with intermediate flash off)	
Interval Between Coats	Until fully matt – Normally 3-5minutes	
Recommended thickness	120-150 microns	
Maximum thickness	150-200 microns	

DRYING



	AIR DRY 20°C	Bake 60°C (Metal)
Ready for sanding (at 120 microns)		
Using 8000 Rapid Hardener	1.5 hours	15mins
Using 6000 Hardener	2.5 hours	20mins
Using 4000 Hardener	3 hours	30mins
INFRA-RED		
Flash-off before drying	5mins	t
Medium wave	Guide time 10-15 minutes depending on the equipment used. Refer to manufacturers recommendations	
Lamp to Panel	Infrared drying times given require the short wave infrared lamp to be positioned 70-100 cm away from the panel.	

Make sure that **Maxi-Build 4:1 Primer** is fully cool & completely hardened before sanding so as to avoid possible absorption and shrinkage.



MAXI-BUILD 4:1 PRIMER

1.856.4024

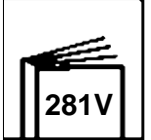
(1.954.4000/6000/8000) Hardeners

WEIGHT MIXING CHARTS

WEIGHT MIXING FIGURES 4 : 1 : 1

Weights are in grams & cumulative. Do not tare the balance between additions

Target Paint Volume.	0.25 L	0.33 L	0.50 L	0.66 L	1.00 L
4024	278	371	557	742	1114
Hardener 4000/6000 / 8000	320	426	640	852	1280
Thinner 27XX 43XX	359	478	718	956	1435



RECOATABILITY

Fully recoatable after curing and sanding.

SANDING

DRY	Single Layer Direct Gloss - P360 or finer	Basecoat – P400 or finer
WET	Single Layer Direct Gloss – P600 or finer	Basecoat – P800 or finer

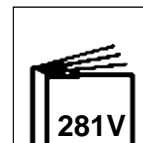


MAXI-BUILD 4:1 PRIMER

1.856.4024

(1.954.4000/6000/8000) Hardeners

MIXING MACHINE STORAGE - PRE-THINNED MODE



It is possible to store the larger 2L pack of Maxi-Build 4:1 4024 Grey on the mixing machine pre-thinned. Thinner is added to the primer pack & the material stirred on a mixing machine. With M4 being the most often used MultiGrey shade, this saves time in product preparation – only the hardener needs to be added at a 5:1 ratio.

1. Take a new 2L tin of 1.856.4024 Maxi-Build 4:1 primer and hand stir.
2. Add 0.5L of one of the recommended MaxMeyer thinners.
(There is sufficient space in the 2L can to add thinner)
3. Hand stir to fully incorporate the thinner with the primer.
4. Attach a mixing machine stirring lid to the tin.
5. Place on the mixing machine and stir for 5 mins.
6. Stir twice daily or ideally just before use.

(Do not leave the pre-thinned product for more than 2 weeks without stirring)

To make Pre-thinned material ready to spray, Mix as follows:

	Volume	Weight
Mixing Ratio: Pre-thinned 1.856.4024 Maxi-Build 4:1	5 vol	100g
Hardener (See Page 2)	1 vol	13g

- The pre-thinned mode is also available through PAINTMANAGER® Software.

TOPCOATING

MAXI-BUILD 4:1 primer can be directly topcoated with *AQUAMAX & UHS DURALIT EXTRA* basecoat

If primer surfacers are left for more than 2 days after sanding, they should be sanded again prior to application of further undercoat or topcoat.

PAINTING FLEXIBLE PLASTICS

MAXI-BUILD 4:1 primer can be used on suitably cleaned and primed flexible plastics. 20% AD1208 plast (1.975.1208) should be added to the MAXI-BUILD primer before adding hardener & thinner in the normal way.



MAXI-BUILD 4:1 PRIMER

1.856.4024

(1.954.4000/6000/8000) Hardeners

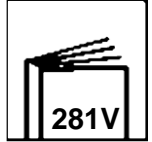
VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU directive code.

NOTE: Combinations of this product with 1.975.1208 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.



TECHNICAL DATA

Pack sizes	1.856.4024 – 2L
Storage	In a cool place away from heat source
Theoretical coverage	4.0 sqm/l mixed ready for use, 100 microns thickness



SAFETY AND HANDLING

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:

www.maxmeyer.com



For further information, please contact:

PPG Industries (UK) Limited. MaxMeyer Division Customer Service & Sales Group, Needham Road, Stowmarket, Suffolk. IP14 2AD, England.

Tel: 01449 771779 Fax: 01449 773495

MaxMeyer, the MaxMeyer logo and AquaMax are trademarks of PPG industries Ohio, Inc..

Copyright © 2021 PPG Industries Ohio, Inc. All rights reserved.

Copyright in the above product numbers that are original is asserted by PPG Industries Ohio, Inc..