



Automotive coatings OEM
Primer-surfacer, water dilutable

Basis Polyester stoving system

	Guide Formulation PTJ 5247 F.1 of Covestro	A 14404.0 [1]
Grinding stage	Setaqua B E 270 (1)	4.22
	Distilled water	8.24
	Dimethylethanolamine, 10 % in water	0.60
	Surfynol 104, 50 % in n-methyl-pyrrolidone)*	0.54
	Additol XW 395 (1)	0.54
	Sachtleben R-FD-I (3)	10.82
	Bayferrox 303 T (4)	0.12
	SILLITIN P 87 (5)	10.99
	Aerosil R972 (2)	0.37
	Dispex Ultra FA 4436 (6)	0.54
Let-down stage	Setaqua B E 270 (1)	25.39
	Dimethylethanolamine, 10 % in water	3.65
	Maprenal MF 904/97 (7)	3.83
	Distilled water	30.15
Total % by weight		100.00
)* replace by Surfynol 104 E (2)	

- Suppliers**
- (1) Allnex
 - (2) Evonik Industries
 - (3) Venator Materials Corporation
 - (4) Lanxess
 - (5) HOFFMANN MINERAL
 - (6) BASF
 - (7) Ineos Melamines



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Technical Data

Solids content (parts by weight)	46.4 %
Organic volatile matter of binders (parts by weight)	5.6 %

Adjust viscosity with distilled water to approx. 40 s (ISO flow cup 5 mm)

Stoving conditions:	10 min room temperature
	10 min 75°C
	20 min 165°C

Ratio of binders (solid resins)

Bayhydrol E 270 : Maprenal MF 904/97	approx.	85 : 15
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Pigments and additives related to solid binders in %

Sachtleben R-FD-I	approx.	44.40
Bayferrox 303 T	approx.	0.50
SILLITIN P 87	approx.	45.10
Aerosil R972	approx.	1.50
Additol XW 395	approx.	2.20
Surfynol 104, 50 % in n-methyl-pyrrolidone	approx.	2.20
Hydropalat 3216	approx.	2.20

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