

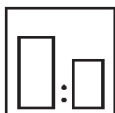


PROFESSIONAL QUALITY

Automotive Primer



2K HS BEIGE OR GREY FILLER PRIMER



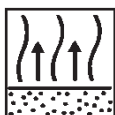
4:1 Normal
Hardener/
5:1 MS
Hardener



Visc.
18-20 Secs



Gravity
Feed



Flash off
5-10 mins



Description:

High-build two-pack primer surfacer for car refinishing and new bodywork. Provides an ideal substrate for all car refinishing.

Product and Additives:

METALUX 2 2K HS Beige (9334)/Grey (9339)
Filler Primer easy sand
METALUX 2 Normal or MS Hardeners see below
METALUX 2 2K Thinner Fast, 1177/Normal,
1159/Medium/Slow, 1171

Special Additives:

METALUX 2 Soft Flex Additive, 8795

Basic Raw Materials:

METALUX 2 2K HS Filler Primer: acrylic resin
METALUX 2 Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 2K HS Filler Primer can be applied over

- Existing Finishes except Thermoplastic Acrylics and NC products
- Bare steel, wood, polyester laminates,
- Not suitable for aluminum, pre-coated steel or galvanized steel.

Surface Preparation:

- Degrease, then flat bodyfillers with P180 - P280 grit,
- Abrade steel with P80 - P180 grit.
Dry sand P360 - P400 grit.
- Existing surfaces wet flat P280 - P400 grit,
dry flat P180 - P280 grit.

Mixing Ratio:

4:1 with Normal **METALUX 2** Hardeners
5:1 with MS **METALUX 2** Hardeners
Thin to 18-20 secs Ford 4 @ 25°C using appropriate
METALUX 2 2K Thinner. (20-25 % Thinner).

Pot Life:

45 minutes @ 25°C.

Process:

Apply one to three single wet coats depending on build required allowing 5-10 minutes flash between coats.

Spray Gun Settings:

Gravity Feed:	1.5mm - 1.8mm	2.00mm tip	2-4 bar
Syphon Feed:	1.8mm - 2.2mm	2.00mm tip	2-4 bar

Film Build:

± 40 micron per coat

Cleaning of Equipment:

Use lacquer thinners.

Drying Time:

Dry to Flat - 4 hours @ 25°C
- 30 minutes @ 60°C
- 15 minutes using IR
Wet on Wet - 30 minutes flash off

Recommended Flatting:

Wet flat initially P500 - P600 grit
Finally wet flat with P800 - P1000 grit
Dry flat initially with P280 grit
Dry flat finally P360 - P400 grit

Recoatability:

All Chemspec products in the car refinish range.

Health & Safety:

Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.