



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ 2K HS Filler Primer

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TD Sheet CS131 rev. 9/26/07

- Description:** A High-build two pack, primer filler (surfacers) for automotive refinishing and new bodywork. Provides an excellent substrate for all refinishing with excellent gloss hold out.
- Product and Additives:** METALUX 2™ 2K HS Filler Primer, 9339 (Grey)
METALUX 2™ MS Hardener Fast, 9091 / Medium, 9092 / Slow, 9093 / Ultra Fast, 9082
METALUX 2™ 2K Thinner Normal, 1159 / Fast, 1177 / Slow, 1171
- Special Additives:** METALUX 2™ Softflex Additive, 8795
- Basic Raw Materials:** METALUX 2™ 2K HS Filler Primer: acrylic resin
METALUX 2™ MS Hardener : poly-isocyanate resin
- Suitable Substrates:** METALUX 2™ 2K HS Filler Primer can be applied over:
- Cured, catalyzed urethane and enamel finishes.
 - Sanded, clean bare steel.
 - METALUX 2™ Etch Filler Primers
 - New bodywork; bodyfiller.
- Note:** Not suitable for aluminum, precoated steel or galvanized steel, lacquer type surfaces.
- Surface Preparations:**
- Degrease then flat bodyfiller with P180 – P280 grit.
 - Abrade steel with P80 – P180 grit. Dry sand P360 – P400 grit.
 - Existing surfaces (Featheredge) wet flat P280 – P400 grit, dry flat P180 – P280 grit.
- Mixing Ratio:** Mix by volume: 5 parts primer to 1 part MS Hardener.
Thin to spray viscosity of 18 secs with # 4 Ford @ 25°C using METALUX 2™ 2K Thinners.
Maximum RFU VOC 4.1
- Pot Life:** 45 minutes @ 25°C / 77° F
- Process:** Apply 1 to 3 single wet coats depending on desired film build. Allow a 5 to 10 minute flash between coats.
- Spray Gun Settings:**
- | | | | | |
|-----------------|-------------|-----------------|---------------|----------------|
| HVLP Gravity | 1.5 – 1.8mm | 0.5 – 0.6 (Bar) | 8 – 10 (PSI) | * At the cap |
| High Efficiency | 1.5 – 1.8mm | 2.0 – 2.7 (Bar) | 30 – 40 (PSI) | Inlet Pressure |
| Conventional | 1.8 – 2.2mm | 2.7 – 3.4 (Bar) | 40 – 50 (PSI) | Inlet Pressure |
- Note:** Refer to spray gun manufacturer for further information regarding inlet pressures.
- Film Thickness:** ± 40 microns / 1.5 mils per coat
- Drying Time:**
- | | |
|-------------------------------|-----------------------------------|
| To Flat (Sand): | 1 hours @ 25°C / 77° F (per coat) |
| | 30 minutes @ 60°C / 140° F |
| | 15 minutes Using Infrared |
| wet-on-wet for small repairs: | 30 minutes @ 25°C / 77° F |
- Recoatibility:** All Chemspec topcoats in the automotive range.
Note: Topcoat within 6-7 hours after initial sanding.
- Cleaning Equipment:** Clean equipment immediately with quality lacquer thinner or urethane reducer.
- Health & Safety:** Reference 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.