



## INTERNATIONAL SYSTEMS TDS – North America

### METALUX 2™ 2K Tinting Filler Primer

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TD Sheet CS132 rev. 9/26/07

<b>Description:</b>	A High-build two pack, primer filler (surfacers) for automotive refinishing and new bodywork. This primer can be tinted to improve opacity of transparent topcoat colors. Provides an excellent substrate for all refinishing with excellent gloss hold out.		
<b>Product and Additives:</b>	METALUX 2™ 2K Tinting Filler Primer, 8797 (Beige) METALUX 2™ MS Hardener Fast, 9091 / Medium, 9092 / Slow, 9093 / Ultra Fast, 9082 METALUX 2™ 2K Thinner Normal, 1159 / Fast, 1177 / Slow, 1171		
<b>Special Additives:</b>	METALUX 2™ Softflex Additive, 8795		
<b>Basic Raw Materials:</b>	METALUX 2™ 2K Tinting Filler Primer: acrylic resin METALUX 2™ MS Hardener : poly-isocyanate resin		
<b>Suitable Substrates:</b>	METALUX 2™ 2K Tinting Filler Primer can be applied over: <ul style="list-style-type: none"><li>- Existing surfaces except lacquer finishes.</li><li>- Sanded, clean bare steel.</li><li>- METALUX 2™ Etch Filler Primers</li></ul>		
<b>Surface Preparations:</b>	<ul style="list-style-type: none"><li>- Degrease then flat bodyfiller with P180 – P280 grit.</li><li>- Abrade steel with P80 – P180 grit. Dry sand P360 – P400 grit.</li><li>- Existing surfaces (Featheredge) wet flat P280 – P400 grit, dry flat P180 – P280 grit.</li></ul>		
<b>Mixing Ratio:</b>	<b>Tint primer first</b> , up to 50% by volume using METALUX 2™ Single Stage mixing toners or 5% by volume or weight using METALUX 2™ basecoat toners. Mix by volume: 5 parts pre-tinted 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. 4.2		
<b>Pot Life:</b>	45 minutes @ 25°C / 77° F		
<b>Process:</b>	Apply 1 to 3 single wet coats depending on desired film build. Allow a 5 to 10 minute flash between coats.		
<b>Spray Gun Settings:</b>	HVLP Gravity	1.5 – 1.8mm	0.5 – 0.6 (Bar) 8 – 10 (PSI) * <u>At the cap</u>
	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
	<b>Note:</b> Refer to spray gun manufacturer for further information regarding inlet pressures.		
<b>Film Thickness:</b>	± 40 microns / 1.5 mils per coat		
<b>Drying Time:</b>	To Flat (Sand):	1 hour @ 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	
<b>Recoatibility:</b>	All Chemspec topcoats in the automotive range. <b>Note:</b> Topcoat within 6-7 hours after initial sanding.		
<b>Cleaning Equipment:</b>	Clean equipment immediately with quality lacquer thinner or urethane reducer.		
<b>Health &amp; Safety:</b>	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.		