



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ Direct to Metal Filler Primer

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TD Sheet CS133 rev. 12/6/07

Description:	METALUX 2™ Direct to Metal Filler Primer (DTM) is a non-isocyanate, chromate-free filler that may be applied directly to larger areas of bare metal without the need of first applying an etch filler. When used as a medium or high build filler (surfacers), DTM offers excellent corrosion protection on bare metal and OEM substrates, that easily sands by hand or machine.															
Product and Additives:	METALUX 2™ Direct to Metal Filler Primer 9722 (Grey) METALUX 2™ Activators 9720 (medium) 9721 (slow) METALUX 2™ 2K Thinner Normal, 1159 / Fast, 1177 / Slow, 1171															
Special Additives:	None															
Basic Raw Materials:	METALUX 2™ Direct to Metal Filler Primer : epoxy-urethane hybrid resin															
Suitable Substrates:	METALUX 2™ Direct to Metal Filler Primer can be applied over: <ul style="list-style-type: none"> - New bodywork; bodyfiller. - Sanded, clean bare steel. - Cured, catalyzed urethane and enamel finishes. Note: Do Not apply over lacquer type or soluble finishes.															
Surface Preparations:	<ul style="list-style-type: none"> - Degrease then flat bodyfiller with P180 – P280 grit. - Abrade steel with P80 – P180 grit. Dry sand P150 – P220 grit. - Existing surfaces (Featheredge) wet flat P280 – P400 grit, dry flat P180 – P280 grit. Note: Aluminum surfaces should be sanded or scuffed with fine grit sandpaper or scuff pad.															
Mixing Ratio:	Mix by volume 4 parts DTM Primer to 1 part DTM Activator. Reduce up to 25% using METALUX 2™ 2K Thinner. Mixed VOC 4.8															
Pot Life:	30 minutes @ 25°C / 77° F Note: Reducing the primer will extend pot life slightly.															
Process:	Apply 1 to 3 single wet coats depending on desired film build. Allow for a 10 to 15 minute flash between coats. Note: Overnight dry is best when applying 3 coats.															
Spray Gun Settings:	<table border="0" style="width: 100%;"> <tr> <td style="width: 30%;">HVLP Gravity</td> <td style="width: 15%;">1.8 – 2.0mm</td> <td style="width: 15%;">0.5 – 0.6 (Bar)</td> <td style="width: 15%;">8 – 10 (PSI)</td> <td style="width: 25%;">* <u>At the cap</u></td> </tr> <tr> <td>High Efficiency</td> <td>1.8 – 2.0mm</td> <td>2.0 – 2.7 (Bar)</td> <td>30 – 40 (PSI)</td> <td>Inlet Pressure</td> </tr> <tr> <td>Conventional</td> <td>1.8 – 2.0mm</td> <td>2.7 – 3.4 (Bar)</td> <td>40 – 50 (PSI)</td> <td>Inlet Pressure</td> </tr> </table> Note: Refer to spray gun manufacturer for further information regarding inlet pressures.	HVLP Gravity	1.8 – 2.0mm	0.5 – 0.6 (Bar)	8 – 10 (PSI)	* <u>At the cap</u>	High Efficiency	1.8 – 2.0mm	2.0 – 2.7 (Bar)	30 – 40 (PSI)	Inlet Pressure	Conventional	1.8 – 2.0mm	2.7 – 3.4 (Bar)	40 – 50 (PSI)	Inlet Pressure
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Film Thickness:	± 40 microns / 1.5 mil per coat															
Drying Time:	To Flat (Sand) : <table border="0" style="margin-left: 20px;"> <tr> <td>1 hour @ 25°C / 77° F (per coat)</td> </tr> <tr> <td>30 minutes @ 60°C / 140° F</td> </tr> <tr> <td>15 minutes using Infrared</td> </tr> </table>	1 hour @ 25°C / 77° F (per coat)	30 minutes @ 60°C / 140° F	15 minutes using Infrared												
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Recoatibility:	All Chemspec topcoats in the automotive range.															
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.															