



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ 2K 2.1 VOC HS Filler Primer

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TD Sheet CS134 rev. 1/07/09

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 2.1 VOC HS Filler Primer, 9741 (Grey) METALUX 2™ 2.1 VOC Hardeners: Fast, 9731, Medium, 9732 and Slow 9733 METALUX 2™ 2K Low VOC Thinner 9710		
Special Additives:	METALUX 2™ Softflex Additive, 8795		
Basic Raw Materials:	METALUX 2™ 2K 2.1 VOC HS Filler Primer: acrylic resin METALUX 2™ Hardener : poly-isocyanate resin		
Suitable Substrates:	METALUX 2™ 2K 2.1 VOC HS Filler Primer can be applied over: <ul style="list-style-type: none"> - 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:	<ul style="list-style-type: none"> - 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 2.1 VOC Hardener. Thin to spray viscosity of 18 secs with # 4 Ford @ 25°C/ 77° F using METALUX 2™ 2K Low VOC Thinner (Typically 30-40% reduction) Maximum RFU VOC 2.1		
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) * <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
	Note: Refer to spray gun manufacturer for further information regarding inlet pressures.		
Film Thickness:	± 50 microns / 2.0 mils per coat at 40% reduction		
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.		