



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ 1K Etch Filler Primer

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TD Sheet CS135 rev. 9/26/07

- Description:** A one pack, etch / filler primer for use on aluminum and galvanized steel surfaces. No additional priming necessary. Can also be used on steel – anti corrosive properties.
- Product and Additives:** METALUX 2™ 1K Etch 8823
METALUX 2™ 2K Thinner Normal, 1159 / Fast, 1177 / Slow, 1171
- Basic Raw Materials:** Acidic
- Suitable Substrates:** To aluminum, galvanizing and steel – good
- Surface Preparations:**
- Degrease, then flat with P180 – P280 grit.
 - Abrade steel with P80 – P280 grit. Dry sand P360 – P400 grit.
 - Existing surfaces (Featheredge) wet flat P280 – P400 grit, dry flat P180 – P280 grit.
- Mixing Ratio:** Thin 25 – 30% with METALUX 2™ 2K thinners to spray viscosity of 18 seconds with # 4 Ford @ 25°C / 77° F.
Note: Accelerator 8784 is **not** recommended.
Maximum RFU VOC. 5.4
- Pot Life:** 8 hours @ 25°C / 77° F
Note: If mixed primer stands for more than 1 hour, stir contents back into suspension before use.
- Process:** Apply 2 to 3 single wet coats with a 5 to 10 minute flash between coats.
- Spray Gun Settings:**
- | | | | | |
|-----------------|-------------|-----------------|---------------|---------------------|
| HVLP Gravity | 1.3 – 1.5mm | 0.4 – 0.6 (Bar) | 6 – 10 (PSI) | * <u>At the cap</u> |
| High Efficiency | 1.3 – 1.5mm | 1.7 – 2.4 (Bar) | 25 – 35 (PSI) | Inlet Pressure |
| Conventional | 1.4 – 1.6mm | 2.0 – 3.4 (Bar) | 30 – 50 (PSI) | Inlet Pressure |
- Note:** Refer to spray gun manufacturer for further information regarding inlet pressures.
- Film Thickness:** ± 25 microns / 1 mil
- Drying Time:**
- | | |
|-----------------|--------------------------------|
| To Overcoat: | 20 - 30 minutes @ 25°C / 77° F |
| Hard Dry: | 3 hours @ 25°C / 77° F |
| To Flat (Sand): | 3 hours @ 25°C / 77° F |
- Note:** METALUX 2™ 1K Etch must be over-coated within 12 hours. After 12 hours, scuff sand before applying additional primer or color.
- Recoatibility** Chemspec 2K Primers and 2K Topcoat products in the automotive range.
Note: Not recommended to directly topcoat with METALUX 2™ Basecoat .
- Cleaning Equipment:** Clean equipment immediately with quality lacquer thinner or urethane reducer.
- Shelf Life:** 6 Months @ 25°C / 77° F. See batch No.
- 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.