



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ 2K Etch Filler Primer

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Description:	A two 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. This product is chromate-free and meets the most stringent VOC regulations.		
Product and Additives:	METALUX 2™ 2K Etch Filler Primer, 8816 METALUX 2™ 2K Etch Filler Activator, 8817		
Basic Raw Materials:	METALUX 2™ 2K Etch Filler Primer: PVB and U/F resins METALUX 2™ 2K Etch Filler Activator: Acidic Solution		
Suitable Substrates:	METALUX 2™ 2K Etch Filler Primer can be applied over: <ul style="list-style-type: none">- Existing surfaces (Featheredges) except lacquer finishes.- Bare steel, wood, polyester laminates.- aluminum, galvanizing and steel – good		
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:	1 part by volume METALUX 2™ 2K Etch Filler Primer 1 part by volume METALUX 2™ 2K Etch Filler Activator Maximum RFU VOC. 5.5		
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 1 to 2 single wet coats with 5 – 10 minute flash between coats.		
Spray Gun Settings:	HVLP Gravity	1.4 – 1.6mm	0.5 – 0.6 (Bar) 6 – 8 (PSI) * <u>At the cap</u>
	High Efficiency	1.4 – 1.6mm	2.0 – 2.7 (Bar) 30 – 40 (PSI) Inlet Pressure
	Conventional	1.5 – 1.8mm	2.7 – 3.4 (Bar) 40 – 50 (PSI) Inlet Pressure
	Note: Refer to spray gun manufacturer for further information regarding inlet pressures.		
Film Thickness:	± 18 microns / .7 mils per coat		
Drying Time:	To Overcoat: 20 - 30 minutes @ 25°C / 77° F Hard Dry: 3 hours @ 25°C / 77° F To Flat (Sand): 30 minutes @ 25°C / 77° F Note: METALUX 2™ 2K Etch must be over-coated within 12 hours. After 12 hours, scuff sand before applying additional primer or color.		
Recoatability	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.		