



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ Waterbased Plastic Primer

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TD Sheet CS143 rev. 11/21/07

Description:	9760 Waterbased Plastic Primer is a uniquely developed, high build primer surfacer, designed for use by bumper recycling and refinishing professionals. 9760 is quick drying with easy sanding using either wet or dry methods. Excellent gloss retention is maintained when topcoated with two-stage and single stage topcoat systems.															
Product and Additives:	METALUX 2™ Waterbased Plastic Primer 9760 (Black) 1.3 VOC RFU.															
Special Additives:	None															
Basic Raw Materials:	METALUX 2™ Waterbased Primer : emulsion resin															
Suitable Substrates:	METALUX 2™ Waterbased Primer can be applied over: - Pre-primed PP-EDPM/TPO plastic bumper covers with Polypropylene Primers 3812 or 8850NF - OEM factory primed bumper covers - Cured, catalyzed urethane and enamel re-finishes															
Surface Preparations:	Clean thoroughly at least 3 to 4 times, each time using fresh silicone remover to ensure that the surface is clean and free of contamination. Allow to evaporate and dry thoroughly. Now wipe in <u>one direction</u> with Anti Static Degreaser using a clean cloth.															
Mixing Ratio:	Product is ready for use, no further reduction is required. Option: To further reduce, use distilled or de-ionized water up to 10% by volume.															
Pot Life:	No Restrictions															
Process:	Apply 1 to 3 single wet coats depending on desired film build. Allowing for a 10 minute flash between coats.															
Spray Gun Settings:	<table border="0"> <tr> <td>HVLP Gravity</td> <td>1.8 – 2.0mm</td> <td>0.5 – 0.6 (Bar)</td> <td>8 – 10 (PSI)</td> <td>* At the cap</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> <p>Note: Refer to spray gun manufacturer for further information regarding inlet pressures.</p>	HVLP Gravity	1.8 – 2.0mm	0.5 – 0.6 (Bar)	8 – 10 (PSI)	* At the cap	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) : 1 hour @ 25°C / 77° F (Per Coat) 30 minutes @ 60°C / 140° F 15 minutes using Infrared															
Recoatibility:	All Chemspec topcoats in the automotive range.															
Cleaning Equipment:	Clean equipment immediately with warm/hot <u>water</u> follow with MEK, Acetone or quality lacquer thinner.															
Shelf Life:	Note: PROTECT FROM FREEZING 1 year @ 25°C / 77° F. See batch No.															
Health & Safety:	Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.															