



INTERNATIONAL SYSTEMS TDS – North America

METALUX 2™ UV Curable Filler Primer

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TD Sheet CS161 rev. 8/13/07

- Description:** METALUX 2™ UV Curable Primer is a high build primer that cures in two (2) minutes, using appropriate ultra violet light. This product applies easily with excellent sanding, while providing maximum color holdout with no shrinkage of film after cure.
- Product and Additives:** METALUX 2™ UV Curable Primer 9742
- Basic Raw Materials:** UV curable urethane resins
- Suitable Substrates:**
- Properly cleaned steel, aluminum, and galvanized steel.
 - Thoroughly sanded and cured paint adjoining metal at feather edge.
 - Cured body filler.
 - Rigid and semi-rigid plastics using Plastic Adhesion Promoter.
- Surface Preparations:**
- Degrease, and 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:** Product is ready to spray.
- Pot Life:** No pot life restrictions when in container.
Note: Place lid back on container and on spray gun cup immediately after dispensing to avoid exposure to UV rays.
- Process:**
- Shake or stir product before use. Be sure that primer is thoroughly mixed.
 - Apply in light coats until build is desired or 2 to 3 wet coats. Product is slightly transparent; **do not apply to full hiding**. In 2 to 3 wet coats, film build will average 5-6 mills wet, coverage is very deceptive.
 - If a second application of UV Primer Surfacer 9742 is needed, fully cure and sand before applying additional material. Total maximum dry film should not exceed 14 mils.
 - Apply product; allow a two (2) minute flash off prior to exposing to UV curing light.
 - Position the UV lamp at 6-12" from surface and expose the primer for two (2) minutes to UV light.
 - For maximum performance, a UV curing lamp is preferred. If curing with natural sunlight, up to 20 minutes may be necessary for complete curing.
 - Light intensity and film thickness will affect curing and adhesion. Overcast days will hinder curing with natural sunlight.
 - Final sanding using P600 or finer grit before applying topcoat.
 - Re-clean repair remove sanding residue before topcoating.
- Spray Gun Settings:**
- | | | | | |
|-----------------|-------------|-----------------|---------------|---------------------|
| HVLP Gravity | 1.4 – 1.6mm | 0.4 – 0.5 (Bar) | 6 – 8 (PSI) | * <u>At the cap</u> |
| High Efficiency | 1.4 – 1.6mm | 1.7 – 2.4 (Bar) | 25 – 35 (PSI) | Inlet Pressure |
| Conventional | 1.4 – 1.6mm | 2.0 – 2.7 (Bar) | 30 – 40 (PSI) | Inlet Pressure |
- Note:** Refer to spray gun manufacturer for further information regarding inlet pressures.
- Film Thickness:** ± 50 microns / 2 mil (per coat)
- Drying Time:**
- | | |
|-----------------|---|
| To Overcoat: | As soon as sanding and cleaning are done. |
| To Flat (Sand): | After 2 to 3 minute cure and surface is cool. |

Recoatibility: Chemspec 2K Primers and Topcoat products in the automotive range.

Recommended Equipment:

- Dedoes, Model # UV2004KLB, UV 450
- HS Hotshot UVA400A 400 watts with clear or light blue UV filter.
- Pro Motorcar # 6737
- Uview #410000 Xpress Cure™

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. Wear proper eye and skin protection from UV source.