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## PRODUCT INFORMATION SHEET

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# 2 PACK HIGH BUILD PRIMER FILLER

### Description

This is a two pack system comprising a pigmented base co-reacted with an isocyanate hardener yielding a high build filler with excellent adhesion and corrosion resistance. A thinner is available to reduce the viscosity for use as a lower build primer/surfacer. These products are characterised by exceptional ease of application, flow and sanding.

### Features

May be tinted up to 10% with 2K tinters.  
Excellent adhesion  
Very high build  
Corrosion resistance

### Suitable Substrates

Properly prepared bare metal, fibreglass, body filler, and original current vehicle finishing systems. TPA finishes (ie thermoplastic acrylic) must be isolated first with 2Pack Primer/Isolator. May be applied over 2 *PACK RED PRIMER* and 2 *PACK ISO-FREE PRIMER/ISOLATOR*.

This product is also suitable for use over MDF, timber and Craftwood.

### Surface Preparation

Thoroughly clean surface with *PREPWASH*. Abrade all surfaces to be primed. Ensure bare metal is thoroughly clean and free of rust by sanding and/or treating with *RUST REMOVER GEL*. Clean again with *PREPWASH*. Non ferrous surfaces such as aluminium and galvanised steel should be primed with 2 *PACK RED PRIMER* prior to application of *HIGH BUILD PRIMER/FILLER*.

In restoration work where there is full panel stripping back to bare metal, the application of 2 *PACK RED PRIMER* will give maximum adhesion and durability.

### Mixing

- a) As a HIGH BUILD SPRAY FILLER  
4 parts 2 *PACK PRIMER FILLER*  
1 part 2 *PACK HARDENER 41*
- b) As a PRIMER/SURFACER  
4 parts 2 *PACK PRIMER FILLER*  
1 part 2 *PACK HARDENER 41*  
1 part *Thinner HPFT*

Mixing of the base and hardener should be completed before adding the requisite thinner. When the base and hardener have been thoroughly mixed **the mixture must be allowed to stand for a minimum of 15 minutes** at 25 Deg C, 20 mins at 20 Deg, this induction period ensures that the full potential of the coating is realised.

### Notes

1. As these are two component reactive materials, only mix sufficient for the immediate job.
2. Do not use other hardeners or thinners in *HIGH BUILD PRIMER/FILLER*. Thinner HPFT contains additives to aid curing.

**Application**

- (a) As a HIGH BUILD SPRAY FILLER  
(Approximately 50-60 microns per coat)  
Using a gravity feed spray gun at 275-410 kPa (40-60 psi) and a 2.0-2.7mm nozzle set up, spray up to three coats allowing 10-15 minutes flash-off between coats.
- (b) As a PRIMER/SURFACER  
(Approximately 25 microns per coat)  
Using a suction spray gun at 275-410 kPa (40-60 psi) and a 1.7 to 2.0 mm nozzle setup. Apply up to 3 coats allowing a 10-15 minutes flash-off between coats
- (c) **Both are tintable with HICHEM 2 PACK SOLID COLOUR with up to 10% additions.**

**Drying Time**

- a) HIGH BUILD SPRAY FILLER  
Drying: Air drying overnight is recommended.  
Baking: After allowing a 30 minute flash off time oven dry for 30 minutes at 60 degrees C.  
After drying sand with P600-P800 paper. Wet sanding must be undertaken with care to ensure that all water is removed before finishing coats are applied as any water trapped in the film could lead to premature failure of the system.
- b)PRIMER /SURFACER  
Air dry 2 hours at 20-25 Degrees C.  
If baking is to be carried out , allow 15-30minutes flash off before placing in the oven. Bake for 30 minutes at 60 degrees C.  
After drying sand with P600-P800 paper. Wet sanding must be undertaken with care to ensure that all water is removed before finishing coats are applied as any water trapped in the film could lead to premature failure of the system.

**Pot Life**

1.5 hours at 20 Degrees C.  
Spraying under conditions of high humidity will reduce the pot life of the coating. We do not recommend the use of this coating when the relative humidity is 80% or higher.

**Clean up:**

All equipment must be cleaned with multipurpose thinner before the material gells, ie within the pot-life period.

**Packaging and Product Codes:**

2 Pack High Build Primer/ Filler	4 Litre	Prod.Code HPF4
2 Pack Hardener 41	1 Litre	Prod.Code 2PH411
2 Pack High Build Primer/ Filler	1 Litre	Prod.Code HPF1
2 Pack Hardener 41	250ml	Prod.Code 2PH41250
Thinner HPFT	1 Litre	Prod.Code HPFT1

**Health & Safety:**

For Automotive and Industrial use only.  
Refer to the Safety Guidelines and warnings set out on the labels.  
The 2 Pack Hardener and mixed material contains free isocyanates.  
For further information refer to the Material Safety Data Sheets.

*The information contained in the bulletin is presented in good faith based on thorough field and laboratory testing but without warranty. It is recommended that all products be tested by the end user to ensure the suitability of the product for particular application under the user-factory conditions.*