

TECHNICAL DATA SHEET

442 PROFILE 2K HB PRIMER FILLER (4:1)

DESCRIPTION -

442 PROFILE 2K HB PRIMER FILLER (4:1) is a two pack urethane spraying filler with excellent filling properties, minimal shrinkage and rapid cure. It gives excellent hold out to all two component top coats and in conjunction with a suitable etch primer is the ideal foundation for CARMMASTER 2K ENAMEL.

SUITABLE SUBSTRATES -

442 PROFILE 2K HB PRIMER FILLER (4:1) has excellent adhesion to a variety of surfaces, such as, existing vehicle finishes, including aged acrylic lacquer, baked enamel, body fillers and spraying polyester putties. Whilst adhesion to bare metal is satisfactory, it is nevertheless recommended that all bare metal areas are first primed with a suitable etch primer before application of 442 PROFILE 2K HB PRIMER FILLER (4:1).

NOTE: 442 CARMMASTER 2K PRIMER FILLER (4:1) can only be used in "spot" repair, or part panel repair, of baked enamel or 2 Pack enamel surfaces. For all other substrates, especially thermoplastic acrylic lacquer, the complete panel must be coated.

SURFACE PREPARATION -

All surfaces to be painted must be clean, dry and free from contamination and be well sanded.

BARE STEEL: Remove mill scale, rust and clean. Sand with 150 grit paper and prime with 429 PARAPHOS PRIMER SURFACER. Sand before applying 442 PROFILE 2K HB PRIMER FILLER (4:1).

ALUMINIUM: Thoroughly clean and degrease. Abrade with nylon abrasive pad and prime with 429 PARAPHOS PRIMER SURFACER. Sand before applying 442 PROFILE 2K HB PRIMER FILLER (4:1).

FIBREGLASS: Thoroughly clean surface including washing with detergent solution to remove residual mould release agents and wax. Sand with 150 grade paper.

ZINC COATED STEEL: Thoroughly clean and degrease and abrade with nylon abrasive pad. Prime with 429 PARAPHOS PRIMER SURFACER which should be sanded prior to application of 442 PROFILE 2K HB PRIMER FILLER (4:1).

NOTE: Due to considerable variations in alloy composition of commercial zinc coated steel sheet, variable surface characteristics result in variable adhesion of subsequent paint coatings. Before commencement of a job, an adhesion check by means of a test patch should be conducted to ensure satisfactory performance. If in doubt, use 408 EPOTEC PRIMER SURFACER.

SURFACE PREPARATION (cont)

EXISTING FINISHES:

Clean and degrease with 123 H.D. WAX AND GREASE REMOVER and sand thoroughly with 320 grit paper.

NOTE: Do NOT use over cracked or crazed surfaces or over surfaces already exceeding 250 microns in total build. Such surfaces should be stripped or mechanically sanded down.

MIXING RATIO -

Mix four parts by volume of 442 PROFILE 2K HB PRIMER FILLER (4:1) -PACK A with one part by volume of 442 PROFILE 2K HB PRIMER FILLER (4:1) HARDENER - PACK B and one part by volume of PROTEC R199 PARAGLAZE REDUCER.

POT LIFE -

Once mixed as detailed above, the useable life of the mix should be considered as approximately 1 - 2 hours. These periods are dependant on the ambient conditions and would be considerably reduced at temperatures higher than 25°C. Do NOT attempt to use material that has commenced to gel.

APPLICATION -

Apply 3 to 4 full wet coats allowing 5 - 10 minutes flash off between coats.

DRYING -

Air dry. At normal ambient conditions 442 PROFILE 2K HB PRIMER FILLER (4:1) is:

DUST FREE 5-10 minutes

TOUCH DRY 1 hour

DRY TO SAND 2 hours

LOW BAKE Ready to sand after 30 minutes @ 60°C

SANDING -

Recommended procedure is to wet sand, initially with 320 - 400 grit paper and finish with 500 - 600 grit paper. Can be dry sanded but suitable respirator must be worn to eliminate inhalation of sanding dust.

NOTE: - 442 Profile 2K HB Primer is a high performance / high productivity product. It is formulated to cure quickly as can be seen from the drying times above. Do not leave in primed condition without topcoating for any lengthy period. This means specifically, if you have low baked the primer, topcoat it that day. If air drying at ambient temperature, then leave no longer than overnight air drying prior to topcoating. Always topcoat as soon as possible otherwise, sand and reprime before topcoating. If left too long to dry the primer will cure too hard and the topcoat could suffer an adhesion loss.

CLEANING UP - RECOATING -

Use R199 PARAGLAZE REDUCER

442 PROFILE 2K HB PRIMER FILLER (4:1) is designed for recoating with 606 CARMASER 2K ENAMEL.

PACK SIZES -

442 PROFILE 2K HB PRIMER FILLER (4:1) 4 Litre.

442 PROFILE 2K HB PRIMER FILLER (4:1) HARDENER PACK B 1 Litre

PRECAUTIONS -

Avoid breathing vapour and contact with skin. Ensure all mixing and handling of hardener and paint containing hardener is carried out under working conditions that prevent skin contact or inhalation of vapour. Wear impervious gloves in a ventilated booth filled with an effective filtered exhaust system. Wear a suitable respirator when dry sanding as inhalation of sanding dust may be harmful.

Do NOT smoke whilst handling this material.

Breathing of fumes or spray mist can cause sensitisation and asthma like reaction. Persons suffering from chronic respiratory problems should not use this product.

Hardener is extremely sensitive to moisture and should be used as soon as possible after opening.
Keep all containers thoroughly closed when not in use.

HEALTH AND SAFETY -

442 PROFILE 2K HB PRIMER FILLER (4:1) contains flammable solvents and must be kept away from heat and open flames. Do not smoke whilst handling this product. 442 PROFILE 2K HB PRIMER FILLER (4:1) HARDENER - PACK B also contains a maximum content of 0.3% volatile free Isocyanate. Avoid breathing the vapour and unnecessary skin contact. Breathing vapour, spray mist or dust from sanding is harmful and may cause lung irritation and asthma-like respiratory reaction. Keep containers thoroughly sealed when not in use. When spraying mixed material (Pack A to which Pack B has been added) the operator must wear a positive pressure air supplied full face respirator. The spray area must be isolated from other people whilst spraying is in progress and until all spray mist has been effectively dispersed. Spray in a booth fitted with an effective filtered exhaust system and comply to local regulations regarding spray painting.

FIRST AID -

- Eyes:** If paint splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists.
- Skin:** If paint splashed on skin, wash affected area thoroughly with soap and water. If irritation persists seek medical aid. Remove all contaminated clothing and launder before re-use.
- Inhalation:** If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist.
- Ingestion:** If swallowed, give glass of water to drink and seek medical assistance. **Do not** induce vomiting.

Consult separate Material Safety Data Sheet for more detailed Health and Safety information.

ISSUED: APR 2005

This information is furnished without warranty, representation, inducement or licence of any kind except that it is accurate to the best of Protec Pty Ltd's knowledge or obtained by Protec Pty Ltd from sources believed by it to be accurate and Protec Pty Ltd does not assume any legal responsibility for use or reliance upon the same. Customers

are encouraged to conduct their own tests. This information is non-controlled. It is the responsibility of the user to ensure that the issue is current.