
443 PARAFILL HS FILLER / SURFACER

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DESCRIPTION	443 PARAFILL HS is a technologically advanced two-pack urethane filler with excellent filling properties, minimal shrinkage and very rapid cure. Depending on the degree of thinning it can be used not only as a filler, but also as a high build primer and primer surfacer. It gives excellent hold out to all two component basecoat and topcoat systems used in automotive refinishing. It is the ideal foundation for 606 PARAGLAZE ACRYLIC URETHANE ENAMEL and 706 BASECOAT/CLEARCOAT SYSTEM.
PRODUCT #	<ul style="list-style-type: none">• 443-5214 Parafill HS Filler/Surfacer - Pack A – Beige• 443-6186 Parafill HS Filler/Surfacer - Pack A - Groundcoat Grey• 443-9133 Parafill Hardener - Pack B
FEATURES	443 PARAFILL HS exhibits the following outstanding properties: <ul style="list-style-type: none">• High build• Rapid cure• Easy sanding - even after prolonged drying• Versatile. Can be used as filler, high build primer or primer surfacer depending on the degree of thinning.• Excellent hold out.
SUITABLE SUBSTRATES	<ul style="list-style-type: none">• 443 PARAFILL HS has excellent adhesion to a variety of surfaces and is suitable for use over original vehicle finishes including acrylic lacquer, gel coat, fibreglass and body fillers.• Whilst adhesion to bare metal is satisfactory, it is nevertheless recommended that all bare areas be first primed with 429 PARAPHOS PRIMER SURFACER or 450 RB PRIMER.• NOTE: 443 PARAFILL HS 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.
MIXING	<p>FOR USE AS A FILLER</p> <ul style="list-style-type: none">• Mix four parts by volume of 443 PARAFILL HS PACK A with one part by volume of 443 PARAFILL HARDENER PACK B. <p>FOR CONVENTIONAL</p> <ul style="list-style-type: none">• DO NOT THIN. For HVLP add 5% by volume of R199 PARAGLAZE REDUCER <p>FOR USE AS A HIGH BUILD PRIMER</p> <ul style="list-style-type: none">• Mix four parts by volume of 443 PARAFILL HS PACK A with one part by volume of 443 PARAFILL HARDENER PACK B. For conventional add one part by volume of R199 PARAGLAZE REDUCER. For HVLP add 10% by volume of R199 PARAGLAZE REDUCER <p>FOR USE AS A PRIMER SURFACER</p> <ul style="list-style-type: none">• Mix four parts by volume of 443 PARAFILL HS PACK A with one part by volume of 443 PARAFILL HARDENER PACK B. For conventional add two parts by volume of R199 PARAGLAZE REDUCER. For HVLP add 15% by volume of R199 PARAGLAZE REDUCER.

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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 443 PARAFILL HS.
- **ALUMINIUM:** Thoroughly clean and degrease. Abrade with nylon abrasive pad and prime with 429 PARAPHOS PRIMER SURFACER. Sand before applying 443 PARAFILL HS.
- **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 443 PARAFILL HS
- **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.
- **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.

DRYING

Air dry. At normal ambient conditions 443 PARAFILL HS is:

- DUST FREE 5-10 minutes
- TOUCH DRY 30 minutes
- DRY TO SAND 2 hours as primer surfacer

4 hours as a filler

- LOW BAKE Ready to sand after 20 minutes @ 60°C

POT LIFE

- Once mixed as detailed above, the useable life of the mix should be considered as approximately one hour when used as a filler and 2 hours maximum when used as a primer surfacer.
- 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.

RECOAT

- 443 PARAFILL HS is designed for recoating with 606 PARAGLAZE ACRYLIC URETHANE ENAMEL, 706 PARAGLAZE BASECOAT / CLEARCOAT SYSTEM 604 ACRYLIC URETHANE ENAMEL 609 COLOURCOAT POLYURETHANE ENAMEL.

CLEANING UP

- Use R199 PARAGLAZE REDUCER

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APPLICATION

Spray gun fluid tip and working pressure:

	Gun	Fluid tip	Pressure
FILLER	Gravity Feed	1.8 - 2.0 mm	200 - 275 kPa
	Suction Feed	Not Recommended	
HIGH BUILD PRIMER	Gravity Feed	1.5 - 2.0 mm	300 - 350 kPa
	Suction Feed	1.6 - 2.2 mm	350 - 400 kPa
PRIMER SURFACER	Gravity Feed	1.5 - 1.8 mm	300 - 350 kPa
	Suction Feed	1.5 - 2.0 mm	350 - 400 kPa

HVLP – DeVILBISS - Gravity

Mixing Ratio	4 : 1 V/V
Thinner Ratio / Reducer	See Thinning above
Air Cap Number	105
Fluid Tip (mm)	1.8 – 2.0
Pressure at Air Cap	2 Bar / 29 psi
Paint Visc Flow Cup 25°C	120 sec, 26 sec, 16 sec
Distance from Object	180 – 210 mm

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

SANDING

- Recommended procedure is to wet sand, initially with 320 - 400 grit paper and finish with 800 - 1000 grit paper.
- Can be dry sanded but suitable respirator must be worn to eliminate inhalation of sanding dust.
- **NOTE:** 443 PARAFILL HS 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 backed the coating topcoat it that day. **If airdrying 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.**

PACK SIZES

443 PARAFILL HS PACK A

- 1 Litre
- 4 Litre.

443 PARAFILL 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.

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HEALTH AND SAFETY

443 PARAFILL HS contains flammable solvents and must be kept away from heat and open flames. Do not smoke whilst handling this product. 443 PARAFILL 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 splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists.
Skin	If 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.