



464 PARATHON PRIMER / SURFACER

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DESCRIPTION	<p>464 PARATHON PRIMER / SURFACER is a versatile, quick-hardening machine sanding, two pack primer – surfacer suitable for use in a wide range of repair work in the refinish industry.</p> <p>It is technologically advanced two-pack urethane filler with excellent filling properties, minimal shrinkage and very rapid cure. It gives excellent hold out to all two component basecoat and topcoat systems used in automotive refinishing. 464 PARATHON PRIMER / SURFACER can be tinted with up to 10% by volume of 606 PARAGLAZE ACRYLIC URETHANE ENAMEL to provide a coloured background.</p> <p>It is the ideal foundation for 606 PARAGLAZE ACRYLIC URETHANE ENAMEL and 706 BASECOAT/CLEARCOAT SYSTEM.</p>
PRODUCT #	<ul style="list-style-type: none">• 464 – 6937 PARATHON PRIMER / SURFACER Pack A Groundcoat Grey• 464 – 5560 PARATHON PRIMER / SURFACER Pack A Neutral Base• 464 – 9523 PARATHON HARDENER- Standard Pack B
FEATURES	<p>464 PARATHON PRIMER / SURFACER exhibits the following outstanding properties:</p> <ul style="list-style-type: none">• Easy sanding – particularly designed for mechanical sanding• Excellent corrosion resistance – direct to metal• High build spray filler through to a wet-on-wet surfacer.• Rapid cure• Versatile. Can be used as filler, high build primer or primer surfacer depending on the degree of thinning.• May be tinted to provide a variety of base colour for wet on wet application.• Excellent hold out.
SUITABLE SUBSTRATES	<ul style="list-style-type: none">• 464 PARATHON PRIMER / SURFACER has excellent adhesion to a variety of surfaces and is suitable for use over original vehicle finishes including acrylic lacquer, gel coat, fibreglass and polyester body fillers.• NOTE: 464 PARATHON 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.
DRYING	<p>Air dry. At normal ambient conditions 464 PARATHON PRIMER / SURFACER is:</p> <ul style="list-style-type: none">• DUST FREE 5-10 minutes• TOUCH DRY 30 minutes• DRY TO SAND 2 hours as primer surfacer <p>4 hours as a filler:</p> <ul style="list-style-type: none">• LOW BAKE Ready to sand after 30 minutes @ 60°C

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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. Degrease with R123 HD Wax and Grease Remover and sand with P80 - 180 grit paper. Whilst adhesion to bare metal is excellent, it is nevertheless recommended that all bare areas be first
- **ALUMINIUM:** Thoroughly clean and degrease. Abrade with nylon abrasive pad and prime with 429 PARAPHOS PRIMER SURFACER. Sand before applying 464 PARATHON PRIMER / SURFACER.
- **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 464 PARATHON PRIMER / SURFACER.
- **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 R123 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

FOR USE AS A PRIMER

- Mix four parts by volume of 464 PARATHON PRIMER / SURFACER.
- PACK A with one part by volume of 464 PARATHON PRIMER / SURFACER.
- HARDENER PACK B.

FOR USE AS A PRIMER SURFACER

- Mix four parts by volume of 464 PARATHON PRIMER / SURFACER.
- PACK A with one part by volume of 464 PARATHON PRIMER / SURFACER.
- HARDENER PACK B and 10% by volume of R199 PARAGLAZE REDUCER.

TINTING FOR WET ON WET APPLICATION

- 464 PARATHON PRIMER / SURFACER – Neutral Base may be tinted with 606 PARAGLAZE ACRYLIC URETHANE ENAMEL.
- Up to 10% by volume of 606 Pack A may be added to the 464 Pack A.
- Treat the mixture as total volume of 464 Pack A Prior to the addition of 464 Pack B.
- Do not add 606 Hardener Pack B or 606 Pack A that has been catalysed with 606 Hardener Pack B.
- Thin mixed paint up to 25% by volume of R199 PARAGLAZE REDUCER before application.

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POT LIFE

- Once mixed as detailed above, the useable life of the mix should be considered as between 1 - 2 hours maximum depending on whether it is used as a primer or 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.

APPLICATION

Spray gun fluid tip and working pressure:

	Gun	Fluid tip	Pressure
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

- Apply 1, 2 or 3 full wet coats allowing 5 - 10 minutes flash off between coats. For wet on wet application apply one single full wet coat.

RECOAT

- 464 PARATHON PRIMER / SURFACER is designed for recoating with 606 PARAGLAZE ACRYLIC URETHANE ENAMEL, 706 PARAGLAZE BASECOAT/CLEARCOAT SYSTEM, 604 ACRYLIC URETHANE ENAMEL and 609 COLOURCOAT URETHANE ENAMEL.

SANDING

Recommended Sandpaper Grades:

- For mechanical / manual wet sanding: P500 / P600 followed by P800-P1000.
- For mechanical / manual dry sanding: P280 followed by P360 / P400
- **Do not leave in primed condition for long periods prior to topcoating.**
- **After 72 hours 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

- Use R199 PARAGLAZE REDUCER

PACK SIZES

464 PARATHON PRIMER / SURFACER PACK A

- 1 Litre, 4 Litre.

464 PARATHON PRIMER / SURFACER 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

464 PARATHON PRIMER / SURFACER contains flammable solvents and must be kept away from heat and open flames. Do not smoke whilst handling this product. 464 PARATHON PRIMER / SURFACER 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.