



2K Hi Fill Primer

High solids primer surfacer for 2K topcoats

7010 - line

Description

- 2-pack modified urethane high build primer

Properties

- High film build per coat
- Eliminates need for separate putty coat
- Easy sanding

Typical Applications

- Truck and car refinishing
- Steel fabrications

General Data

- Weather resistance Excellent
- Solvent resistance Resists splashes of most common solvents; not recommended for continuous immersion
- Chemical resistance Good
- Abrasion resistance Good
- Heat resistance up to 105°C (dry heat)
- Suitable primers Rhinogrip® Etch Primer

Specifications (at 25°C and 50% relative humidity)

- Resin type..... Acrylic urethane
- Mixing ratio.....4 : 1
- Solids content.....50% (by volume)
- Typical film thickness (per coat)..... 75 microns (dry)
150 microns (wet)
- Theoretical coverage..... 4 - 7m² / L @ 75 microns dry film thickness
- Touch dry..... 15 - 30 minutes
- Hard dry..... 4 hours
- Full cure..... 5 days
- Recoating..... after 16 hours
- Force dry..... 30 min. @ 50°C
- Pot life.....2 hours (depending on temperature and level of thinner added)
- Gloss..... Satin
- Colour..... Grey
- Shelf life..... minimum 12 months (in cool, dry conditions; unopened containers)

Surface Preparation

- Bare steel surfaces must be degreased, then subjected to abrasive blasting (to AS 1627.4 Class 2½) or abrasion with a suitable power cleaning tool (e.g. disc sander)
- Not suitable for application directly to bare metal. Refer to recommendations in Coatings Systems below.

Mixing recommendation

- Mix only the quantity required for the job
- Mix Pack A with Pack B in the ratio 4:1
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even mixing of the two parts
- Thin up to 25% by volume with Wagon Paints' T1 PU Spray Thinner (see Application directions), and stir as above

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Application

- May be spray applied using airless or conventional air spray equipment
- **Airless Spray** nozzle size.....0.33 - 0.38 mm
nozzle pressure.....2200 - 3000 psi (15 - 20mPa)
volume of thinner.....up to 5%
- **Air Spray** nozzle size.....1.8 - 2.2 mm
nozzle pressure.....55 - 70 psi (350 - 450kPa)
volume of thinner.....up to 25%
- **Cleaning solvent** T1 PU Spray Thinner
- **Sanding** Sand cured primer with medium – fine grade paper prior to topcoat application

Coating Systems

Substrate	Primer 1	Primer 2	Topcoat
Aluminium	Rhinogrip [®] Etch	2K Hi Fill Primer	Rhinothane [®] T or AC
Galvanised Iron	Rhinogrip [®] Etch	2K Hi Fill Primer	Rhinothane [®] T or AC
Steel	Rhinogrip [®] Etch	2K Hi Fill Primer	Rhinothane [®] T or AC
Zincseal / Zinalume	Rhinogrip [®] Etch	2K Hi Fill Primer	Rhinothane [®] T or AC

Caution: Store 2K Hi Fill Primer Packs A & B in a cool, dry location. Do not allow water to contaminate the products.
Must not be applied over damp surfaces.
Do not apply when the air/surface temperatures are below, or are likely to fall below, 10°C or the relative humidity is above 70%.

Safety precautions

- **Refer to the relevant Material Safety Data Sheets for Pack A and Pack B**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

Packaging Group II **UN No.** 1263 (Pack A); 1866 (Pack B)

Pack sizes 4 litre (Pack A)
 1 litre (Pack B)

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These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



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