



# Autothane HS Primer Filler

## 467-49413

This product is for professional use only

### Product Description

Autothane HS Primer Filler is a high solids two pack acrylic urethane primer that can be used as a filling primer or as a primer surfacer. It is suitable for use in bodyshop car refinishing where a warrantable repair is not required. It can be used with Autothane HS Hardener as well as with Autothane HS Fast Hardener (for smaller areas or where a faster system is required).

### Products and Additives

PRODUCT	Autothane HS Primer Filler	467-49413
HARDENER	Autothane HS Hardener Normal	980-49415
HARDENER	Autothane HS Hardener Fast	980-49426
REDUCER	Autothane Thinner	920-49417

### Mixing Ratio



By Volume:

Autothane Primer	4 parts
Autothane Hardener	1 part
Autothane Thinner	0–5% (Filler mode) 10–15% (Surfacer mode)

### Viscosity DIN 4



DIN 4 cup at 25°C

30–35 seconds	(Filler mode)
18–25 seconds	(Surfacer mode)

### Spray Gun and Pressure



	Conventional	HVLP/RP
Gravity Feed	1.5–2.0 mm 300–380 kPa	1.5–2.0 mm 2-3 bar
Suction Feed	1.8–2.2 mm 300–380kPa	

### Application

#### Number of Coats



Apply 3 full wet even coats  
90-120µm in Primer Surfacer Mode  
120-170 µm in Filler Mode

#### Flashoff Time



5–10 minutes between coats

#### Potlife



45-60 mins at 25°C

#### Drying Times

##### Air Dry



3-6 hours at 25°C

##### Bake



30 min at 65°C (980-49415)  
25-30 mins at 65°C (980-49426)

#### Points to Note

1. Correct safety equipment including goggles, gloves and an air-fed mask should be worn when handling or spraying catalysed Autothane HS Primer Filler as it contains isocyanate.
2. Good ventilation and extraction must be provided in the working environment.
3. Do not smoke while using this material.
4. To ensure maximum adhesion and impact resistance, Autothane HS Primer Filler must be sanded and coated within 72 hours of application. After this time it should be sanded and recoated with itself.

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Drying times quoted are average times at 25°C. Film thickness, humidity and shop temperature can all affect drying times.

