



Autothane High Build Primer

467-57799

This product is for professional use only


Product Description

Autothane High Build Primer is a high build, easy sanding two pack acrylic urethane primer filler that can be used in primer surfacer mode or in filler mode. It is suitable for use in bodyshop car refinishing. 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 High Build Primer	467-57799
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	5-10%	(Filler mode)
	15-30%	(Surfacer mode)

Viscosity DIN 4

	DIN 4 cup at 25°C	
	30-40 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



1-2 hours at 25°C

Drying Times

Air Dry



8 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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The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at their own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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

