



HiChem Industries Pty Ltd.
73 Hallam South Road Hallam, Vic 3803
Phone (03) 9796 3400 Fax (03) 9796 4500
ACN 006-542-767



PRODUCT INFORMATION SHEET

G:\SECURE\Product Information\TWO-PACK\PRIMERS\2 PACK HS EZI SAND PRIMER FILLER.doc 5-8-05

2 PACK HS EZI-SAND PRIMER FILLER

Description

A universal two pack high solids primer suitable for three methods of application: Primer Filler, Primer Surfacer and Non Sanding Primer.

This is a two pack system comprising a pigmented base co-reacted with an isocyanate hardener yielding a high build filler with excellent adhesion and corrosion resistance. *2 Pack Thinner HPFT* is used to reduce the viscosity for use as a lower build primer/surfacer and as a non sanding primer. These products are characterised by exceptional ease of application, flow and sanding.

Uses

Suitable for use on properly prepared bare metal, fibreglass, plastic, sanded polyester body filler and spray putty, sound existing paint finishes and HiChem 2 Pack Primers.

Features

Filler, Surfacer and Non sand in one
Easy to sand
May be tinted up to 10% with *HiChem 2 Pack CVI Finish* tinters and *HiChem 2 Pack Colour* tinters.
Excellent adhesion
High build
Corrosion resistance

Suitable Substrates

Properly prepared bare metal, fibreglass, body filler, and original current vehicle finishing systems. TPA finishes (ie thermoplastic acrylic) must be isolated first with *2Pack Iso-Free Primer/Isolator*. May be applied over *2 Pack Red Primer* and *2 Pack Iso-Free Primer/Isolator*.

This product is also suitable for use over MDF timber and Craftwood.

Surface Preparation

Thoroughly clean surface with *Prepwash*. Abrade all surfaces to be primed. Ensure bare metal is thoroughly clean and free of rust by sanding and/or treating with *Deoxidiser and Rust Remover Gel*. Clean again with *Prepwash*. Non ferrous surfaces such as aluminium and galvanised steel should be primed with *2 Pack Red Primer* prior to application of *2 Pack Ezi-Sand Primer Filler*.

In restoration work where there is full panel stripping back to bare metal, the application of *2 Pack Red Primer* will give maximum adhesion and durability.

Mixing/Thinning

- As a High Build Spray Filler-Mix 4 parts by volume *Ezi-Sand Primer Filler* with 1 part *2 Pack Hardener 41*.
- As a Primer/Surfacer- Mix 4 parts *Ezi-Sand Primer Filler* with 1 part *2 Pack Hardener 41* and 2 parts *2 Pack Thinner HPFT*.
- As a non sanding primer mix 4 parts by volume *Ezi-Sand Primer Filler* 1 part *2 Pack Hardener 41* and 3 parts *2 Pack Thinner HPFT*.

Ezi-Sand may be tinted with up to 10% *2 Pack CVI Finish* tinters or *2 Pack Colour* tinters prior to addition of *Hardener 41*.

Mixing of the base and hardener should be completed before adding thinner.

As these are two component reactive materials, only mix sufficient for the immediate job.

Do not use other hardeners or thinners. *2 Pack Thinner HPFT* contains additives to aid curing.

Application

(a) As a high build spray filler

Use a gravity feed spray gun at 275-410 kPa (40-60 psi) and a 2.0-2.7mm nozzle set up.

Apply 1-3 coats allowing 10-15 minutes flash off time between coats. Apply approximately 50-60 microns per coat.

Air dry overnight or bake at 60°C for 30 minutes after a flash off time of 30 minutes. Sand with 600-800 grit paper prior to top coating.

(b) As a primer/surfacer

Use a gravity feed or suction spray gun at 275-410 kPa (40-60 psi) and a 1.7 to 2.0 mm nozzle setup.

Apply 1-2 coats allowing 10-15 minutes flash off time between coats. Apply approximately 25 microns per coat.

Air dry 6 hours or bake at 60°C for 20 minutes after a flash off time of 10 minutes. Sand with 600-800 grit paper prior to top coating.

(c) As a non sanding primer

Use a gravity feed or suction spray gun at 275-410 kPa (40-60 psi) and a 1.7 to 2.0 mm nozzle setup.

Apply 1-2 coats allowing 10-15 minutes flash off time between coats.

Air dry minimum 15 minutes to maximum 8 hours before top coating. Do not bake. If 8 hours is exceeded sand with 600-800 grit paper prior to top coating.

Full cure takes approx. 7 days.

Pot Life

1 hour at 20°C.

Spraying under conditions of high humidity will reduce the pot life of the coating. We do not recommend the use of this coating when the relative humidity is 80% or higher.

Clean up:

All equipment must be cleaned with *Superglow multipurpose thinner* before the material gells, ie within the pot-life period.

Packaging and Product Codes:

<i>2 Pack HS Ezi-Sand Primer Filler</i>	4 Litre	Prod.Code 2PESPF4
<i>2 Pack Hardener 41</i>	1 Litre	Prod.Code 2PH411
<i>2 Pack Thinner HPFT</i>	1 Litre	Prod.Code HPFT1

Health & Safety:

For Automotive and Industrial use only.

Refer to the Safety guidelines and warnings set out on the labels.

The 2 Pack Hardener and mixed material contains free isocyanates.

For further information refer to the Material Safety Data Sheets.

The information contained in the bulletin is presented in good faith based on thorough field and laboratory testing but without warranty. It is recommended that all products be tested by the end user to ensure the suitability of the product for particular application under the user-factory conditions.