



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

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2 PACK ISO-FREE PRIMER-ISOLATOR (HIGH BUILD)

Description

A high build primer filler isolator with excellent adhesion, build and hold out properties. May be thinned to reduce the viscosity for use as a lower build Isolator or primer/surfacer.

Features

Fast drying and easy sanding properties. Excellent dry sanding.
May be tinted up to 10% with 2 Pack Iso-Free tinters.
Excellent adhesion
High build. Up to 60 microns per coat.
Isocyanate free.

Suitable Substrates

Properly prepared steel, aluminium, galvanised steel, fibreglass, body filler, and original current vehicle refinishing systems. As an isolator over sound, well cured (minimum 6 months) enamels and acrylic lacquers such as HiChem Quick Dry Enamel, Super Enamel, Acrylic Lacquer and Auto Enamel.
This product is also suitable for use over MDF, timber and Craftwood.

Surface Preparation

1. Steel: Thoroughly clean surface with *Prepwash*. Abrade all surfaces to be primed. Ensure bare steel is thoroughly clean and free of rust by grinding, sanding and/or treating with *Deoxidiser Rust Remover Gel*. Clean again with *Prepwash*.
2. Aluminium: Abrade with *Methylated Spirits* and coarse abrasive pad (such as Scotchbrite). Clean again with *Methylated Spirits*. Prime within 4 hours.
3. Galvanised Steel: Abrade with *Methylated Spirits* and coarse abrasive pad (such as Scotchbrite). Clean again with *Methylated Spirits*.
4. Fibreglass: Wash with *Prepwash*. Thoroughly sand with 400 grit paper. Wash again with *Prepwash*. Repeated solvent washing may be necessary to remove mould release agents on new moulded parts.
5. As an Isolator over existing paint work: Flat with ultra fine sanding pad or P800 WD paper using soap and water. Degrease with *Prepwash*.
6. As a primer over existing paintwork: Clean surface with *Prepwash*. Sand surface with 400-600 grit paper. Degrease with *Prepwash*.

Mixing

Stir the *Iso-Free High Build Primer Filler* to a uniform consistency before adding the hardener.

1. As a High Build Primer Filler
4 parts by volume *2 Pack Iso-Free Primer Filler*
1 part *2 Pack Iso-Free Hardener 31 Normal*.
2. As an Primer/Surfacer Isolator
4 parts *2 Pack Iso-Free Primer Filler*
1 part *2 Pack Iso-Free Hardener 31 Normal*.
1 part *Thinner 701N Normal*

Notes: In both situations 1. and 2. above *Iso-Free High Build Primer Filler* may be tinted with *2 Pack Iso-Free Solid Colours*. Use up to 10% before addition of *Hardener 31 Normal*.
As these are two component reactive materials, only mix sufficient for the immediate job.
In higher temperatures, say 25°C and above, Iso Free Hardener 31 **Slow** may be used.

Pot Life

8 hours at 20°C; 6 hours at 25°C; 4 hours at 30°C.
DO NOT USE AFTER THESE PERIODS HAVE EXPIRED.

Application

(1). As a High Build Primer Filler Isolator:

(Approximately 50-60 microns per coat)

Using a gravity feed or suction spray gun with a 2mm nozzle set up, spray up to three coats to a maximum dry film thickness of 200 microns. Allow 10-15 minutes flash-off between coats at 20°C. Longer times should be allowed between coats at lower temperatures.

(2). As an Primer/Surfacer Isolator

(Approximately 25 microns per coat)

Using a gravity feed or suction spray gun with a 1.4 to 1.8 mm nozzle setup. Apply up to 3 light coats to a dry film thickness of 60-80 microns. Allow 10-15 minutes flash-off between coats at 20°C. Longer times should be allowed between coats at lower temperatures.

Drying Time

(1). As a High Build Primer Filler:

Allow overnight drying at room temperature before sanding with P600-P800 paper. Wet sanding is preferred. Ensure that all water is removed before finishing coats are applied as any moisture left on the surface could lead to premature failure of the system.

Baking may be undertaken after the final coat has dried for 30 minutes. Bake for 35 minutes at 60°C.

IR curing may also be used. Use Medium Wave 17KW. After a flash off time of 5 minutes, expose for 35 minutes on medium at a distance of 40-60 cm.

(2). As an Primer/Surfacer Isolator

Air drying: Allow for minimum of overnight drying at 20°C. Allow longer at lower temperature. Sand with P600-800 WD paper before further coatings are applied. Do not sand through.

Baking may be undertaken after the final coat has dried for 30 minutes. Bake for 35 minutes at 60°C.

IR curing may also be used. Use Medium Wave 17KW. After flash off time of 5 minutes, expose for 35 minutes on medium at a distance of 40-60 cm.

Clean up:

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

Storage:

Store in a cool dry area. Keep lids tightly closed.

Health & Safety:

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

For further information refer to the Material Safety Data Sheets.

Packaging and Product Codes:

2 Pack Iso-Free High Build Primer Filler 4 Litre 2PIFPI4

2 Pack Iso-Free Hardener 31 Normal 1 Litre 2PIFH1

2 Pack Iso-Free High Build Primer/ Filler 1 Litre 2PIFPI

2 Pack Iso-Free Hardener 31 Normal 250ml 2PIFH250

<u>Thinners</u>	<u>60 litre</u>	<u>20 litre</u>	<u>4 litre</u>	<u>1 litre</u>
Thinner 701 Normal	T701N60	T701N20	T701N4	T701N1
Thinner 701 Slow	T701S60	T701S20	T701S4	N/A

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.