



Technical Data Sheet

AUTOFIL PRIMER HS

DESCRIPTION:

Autofil Primer HS is an excellent 2K urethane primer surfacer. Providing medium to high build application for excellent filling and surfacing results. Quick drying properties and can be sanded in 90 minutes or can be forced dried.

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Autofil Primer HS (Grey)	4301	Gallon
Autofil Primer Hardener	4404	Quart
Autosolv Urethane Reducer	2651, 2751, 2851, 2951	Gallon

COMPATIBLE SUBSTRATES:



Autofil Primer may be applied to properly prepared:

- Polyester Body Fillers & Putties
- Self Etching Primers
- Epoxy Primers
- Previously Painted Surfaces
- Properly Prepared OEM Finishes

SAFETY ASPECTS:

Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS and product label are available upon request.

SURFACE PREPARATION:



Wash area with soap and warm water. Thoroughly clean area with Autokote Pre-Kleen or Autokote Final-Kleen.

Block sand with #180 - #220 grit. Final sand with #320 grit or finer. Featheredge OEM paint. Surface must be clean and dry.

Note: For optimum adhesion and corrosion protection, bare metal surfaces should be coated with Etchkote or Metl-Etch before applying primer surfacer.

Note: Autofil Primer HS may be applied to the inside surfaces of non-sanded OEM E-coated parts that have been thoroughly cleaned and degreased using Final-Kleen wax and grease remover.

MIXING RATIOS:



High Build <i>(Recommended)</i>	4 Parts 1 Part	Autofil Primer HS Autofil Primer Hardener
Normal Build	4 Parts 1 Part 1 Part	Autofil Primer HS Autofil Primer Hardener Autosolv Urethane Reducer



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GUN SETUP:



TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Gravity:	1.6 mm - 1.8 mm	30 - 45 psi @ gun
HVLP	1.6 mm - 1.8 mm	8 - 10 psi @ air-cap

NUMBER OF COATS:

Apply 2 to 3 coats of Autofil Primer HS allowing 10 minutes flash time between coats, depending on temperature. Longer flash times will ensure better color holdout and less shrinkage.

FILM THICKNESS:

Approximately 1.5 - 2.0 mils per single coat.

FLASH TIMES:

10 minutes between coats

PURGE TIME:

5 minutes

DRYING TIMES:



METAL TEMP	DUST FREE	DRY TO SAND
75°F/24°C	N/A	90 minutes
140°F/60°C		20-30 minutes

Note: For best appearance and holdout, allow to air dry overnight prior to sanding and topcoating.

Note: Dry to sand times will vary according to temperature and number of coats.

SANDING:

When using as a primer surfacer:

Allow Autofil Primer HS to cure thoroughly before sanding.

Sand primer surfacer with 180 to 320 grit sandpaper then finish sand according to next application:

320 to 400 grit for Sealer

400 to 500 grit for Single Stage Topcoat System

400 to 600 grit for Basecoat

CLEANING EQUIPMENT:

Clean equipment with AutoKote Lacquer Thinner.



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TECHNICAL DATA:



Color	Gray
Activator/Hardener	Autofil HS Primer Hardener
Reducer	Urethane Reducer (Optional)
Mix Ratio	4:1 - High Build 4:1:1 - Medium Build
Pot Life	30 minutes at 68°F-75°F
Number of Coats	2-3 full wet coats
Flash Time	10 minutes
Purge Time	5 minutes
Dry Time	<i>Air Dry</i> 90 minutes @ 75°F/24°C <i>Force Dry</i> 20-30 minutes @ 140°F/60°C
Gun Set-Up	Refer to Table on Page 2
Actual V.O.C.	4.12 lbs/gal (494 g/L)
Regulatory V.O.C.	4.50 lbs/gal (539 g/l)
% Solids RTS by Wt.	53.9% @ 4:1 51% @ 4:1:1
Package Size	Gallon
Case Quantity	4 Gallons
Shelf Life	12 months unopened

All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.

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