

# 2K HS PRIMER FILLER



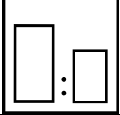

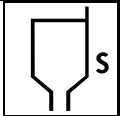


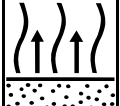
**Description**


- 2K Acrylic Urethane Sanding Filler
- Light Grey in colour
- Cost effective
- Chromate free
- 4L - 23-61781284

**Technical Summary**

- High solids, high build primer filler
- Excellent filling, drying and sanding properties
- Excellent topcoat hold out and edge map resistance
- Good adhesion





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Working process		
	<b>Substrates:</b>	<ul style="list-style-type: none"> <li>• Bare steel, sanded</li> <li>• OEM primers or EDP, sanded</li> <li>• Pre-painted substrates, sanded</li> <li>• Polyester fillers, sanded</li> <li>• Thermoplastic coatings, sanded</li> <li>• Al and Gal Steel, primed with Duxone<sup>®</sup> 1 Pack Etch Primer Surfacer grey</li> </ul>
	<b>Pretreatment / Cleaning:</b>	Clean with Duxone <sup>®</sup> Wax and Grease Remover Sand with P320-P400 dry or P600-P800 wet Clean again with Duxone <sup>®</sup> Wax and Grease Remover
	<b>Application:</b>	Use recommended respirators. Refer to relevant Material Safety Data Sheet (MSDS)
		4:1 with Duxone <sup>®</sup> 2K Hardener
		Up to 150 µm - 10% Duxone <sup>®</sup> 2K Thinner Up to 250 µm - No Thinner
		Up to 150 µm - 18 – 20s DIN 4 / 20°C or 18 – 21s FORD Cup 4 / 20°C Up to 250 µm - 25 – 30s DIN 4 / 20°C or 30 – 36s FORD Cup 4 / 20°C
		1.5 - 1.8 mm 300 – 400 kPa 2 – 4 coats
		1.6 – 1.9 mm 300 – 400 kPa 2 – 4 coats
		5 - 10 min / 20°C before force drying

		20 - 30 minutes / 60°C metal temp. (depending on hardener and film thickness.)
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TECHNICAL DATA SHEET **DUXONE**<sup>®</sup>  
AUTOMOTIVE PAINT SYSTEMS

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		8 - 10 min, short wave
		P800 – P1000, after drying 1 – 3 hours / 20°C (depending on hardener and film thickness)
		P400 – P500, after drying 2 – 4 hours / 20°C (depending on hardener and film thickness)
		2K MS or 2K HS Topcoats Basecoats with 2K MS or 2K HS clearcoats

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## TECHNICAL DATA

<b>Flashpoint:</b>	Above +23°C
<b>Raw Material:</b>	Acrylic Urethane anti corrosive pigments
<b>Specific Gravity:</b>	1.55 g/mL
<b>VOC:</b>	500 g/L
<b>Approx. Coverage:</b>	5.0 m <sup>2</sup> /L at 80 microns DFT
<b>Cleaning of Equipment:</b>	Clean after use with Duxone <sup>®</sup> Gun Wash Solvent
<b>Important Remarks:</b>	For professional use only

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.