




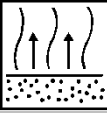
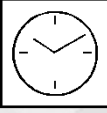







AL421/425/427_V
2K Primer Surfacer

Description	AUTOLUX® 2K Primer Surfacers, AL421/AL425/AL427, are fast drying, white/grey/dark grey, 2 pack acrylic primer filler/surfacers.		
Products	Primer:	AL421 <i>Autolux</i> 2K Primer Surfacer - White	
	Hardener:	AL425 <i>Autolux</i> 2K Primer Surfacer - Grey AL427 <i>Autolux</i> 2K Primer Surfacer - Dark Grey	
	Thinner:	AL512 <i>Autolux</i> MS Hardener - Fast (Up to 18°C) AL514 <i>Autolux</i> MS Hardener - Standard (18 - 25°C) AL516 <i>Autolux</i> MS Hardener - Slow (25 - 35°C) AL651 <i>Autolux</i> Fast Thinner (15 - 25°C) AL652 <i>Autolux</i> Standard Thinner (20 - 30°C) AL653 <i>Autolux</i> Extra Slow Thinner (25 - 35°C)	
Surface Preparation		Degrease the surface thoroughly before and after sanding.	 Old finishes: Machine sand P240-P320 grit Bare metal: Machine sand P120-P180 grit Bodyfiller: Machine sand P120-P180 grit
Mixing		<i>Autolux</i> 2K Primer Surfacer AL421/425/427 <i>Autolux</i> MS Hardener AL512/514/516 <i>Autolux</i> MS Thinner AL651/652/653 Pot Life: at 20°C	Mixing Ratio by volume: Primer Surfacer 5 Parts 1 Part 1 Part 45 - 60 minutes
Application		HVLP/Compliant gun:	Fluid Tip 1.5 – 1.8mm, Air pressure – refer to spraygun manufacturers information
Coats		Primer Surfacer 2 – 4 coats (75 – 150 microns dry film)	
Flash Time		5 – 10 minutes between coats at 20°C.	
Drying		Air Dry at 20°C:	4 – 5 hours to sand and topcoat
		Short / Medium Wave I.R.	Flash off 5 mins, 10 – 20 mins* *Depending on IR equipment used
		Force Dry:	20 - 30 minutes at 60°C to sand and topcoat
Sanding prior to topcoat	AL421/425/427 2K Primer Surfacer must be sanded prior to overcoating or topcoating		 Dry sand by machine or by hand or wet sand – refer to relevant Technical Data Sheet of product being applied for sanding grades. 
			
Process Notes Clean up equipment immediately after use, using <i>Autolux</i> Thinner or another suitable solvent. Dispose of waste in accordance with applicable regulations.			
VOC Information The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.			

These products are for professional painting only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the Material Safety Data Sheet. March 2014.

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