



AUTOMOTIVE PAINTS

# TECHNICAL DATA SHEET

## 289-45711 ONE SHOT PRIMER FILLER

### PRODUCT DESCRIPTION

A high build Alkyd-NC primer filler with excellent topcoat holdout and easy sanding. Fast build and good adhesion make it ideal for use as a spot repair primer filler, particularly over thermoplastic acrylic (TPA).

### SUBSTRATES & PREPARATION



One Shot Primer Filler can be applied over suitably prepared:

- 1K CT Etch Primer
- Sound existing TPA paint finishes which have been degreased with AA-6822 PROTEC® Heavy Duty Wax & Grease Remover and sanded with STARTLINE® P240-P320 dry
- Polyester body fillers

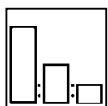


*Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.*

### PRODUCTS

One Shot Primer Filler	289-45711
Multi Midway Thinner	921-01074
G P Lacquer Thinner	921-08102
Protec Heavy Duty Wax & Grease Remover	AA-6822

### MIXING RATIO



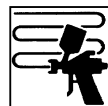
PRODUCT	Primer Surfacer	Primer Filler
One Shot Primer Filler	2 parts	4 parts
Thinner	1 part	1 part

### SPRAYGUN SETTINGS



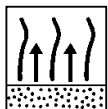
	Conventional	HVLP
GRAVITY	1.6 - 2.0 mm	1.4 - 1.6 mm
SUCTION	1.8 - 2.2 mm	
SPRAY PRESSURE	350 - 400 kPa	10psi at cap (70kPa)

### APPLICATION



- 2 - 4 full even coats

## FLASH OFF (at 25°C)



Primer Filler: 6 - 9 minutes

Primer Surfacer: 5 - 7 minutes

## DRYING TIMES



Air Dry at 25°C

Primer Filler: 50 - 60 minutes

Primer Surfacer: 30 - 40 minutes

**Please Note:** For best results, dry overnight. Drying times will need to be extended under cooler conditions. Seek further advice before spraying.

**TOTAL DRY FILM BUILD** 40 - 80 µm with 2 - 4 coats

## SANDING



Grade Dry: Startline P400 or finer

Grade Wet: Startline P600 for solid colours, P800 for metallics

## PERFORMANCE GUIDELINES

- Topcoat with Dulon Acrylic Lacquer

## EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

## HEALTH AND SAFETY

Refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

For comprehensive Health, Safety and Environmental advice, please refer to relevant Safety Data Sheets and Product Can labels.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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