



TECHNICAL DATA INDEX

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1K ETCH FILLER PRIMER



4:1
2K Thinner



Visc.
18-20 Secs



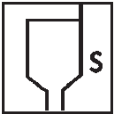
Description:	A one pack, etch filler primer for use on aluminum and galvanized steel surfaces. No additional priming necessary. Can also be used on steel anti corrosive properties. Not recommended to overcoat with basecoat.
Product:	8823
Basic Raw Materials:	Acidic
Suitable Substrates:	To aluminum, galvanizing and steel - good
Surface Preparation:	<ul style="list-style-type: none">- Degrease, then flat with P180 - P280 grit.- Abrade steel with P80 - P280 grit.- Dry sand P360 - P400 grit.- Existing surfaces wet flat P280 - P400 grit, dry flat P180 - P280 grit.
Mixing Ratio:	Thin 25 - 30% with METALUX 2 2K thinners to spray visc. Of 18" F4 @ 25°C.
Application:	Apply 2-3 single coats.
Cleaning of Equipment:	Lacquer thinners
Drying Time:	20 minutes @ 25°C Before sanding and overcoating leave for 3 hours Hard dry 3 hours
Film Build:	± 35 microns
Sanding Properties:	Good
Health & Safety:	Contains VOC therefore, avoid breathing in vapours



1K GREY PRIMER



2:1
2K Thinner



Visc.
18-20 Secs

**Description:**

A one pack, spot repair primer with good adhesion to steel with fast curing and anti-corrosive properties. This is NOT an etch primer. It has been developed for overcoating with polyester base coats.

Products:

8852

Suitable Substrates:

Adhesion to Steel - good. Top Coat adhesion to primer good.

Surface Preparation:

- Degrease, then flat with P180 - P280 grit.
- Abrade steel with P80 - P180 grit.
Dry sand P360 - P400 grit.
- Existing surfaces wet flat P280 - P400 grit,
dry flat P180 - P280 grit.
- Clean with prekleen and tack rag.

Mixing Ratio:

2:1 (VOL) **METALUX 2** 2K thinners to spray visc.
Of 18-20" F4 @ 25°C.
Supply viscosity 70-74 F4 @ 25°C.
S.G. ± 1.085.
NVC ± 40%.

Application:

Apply 2 single coats.

Cleaning of Equipment:

Use lacquer thinners.

Drying Time:

Surface dry 8 minutes @ 25°C. Hard dry 30 minutes
(for sanding and overcoating).

Recommended Sanding:

Lightly scuff with P1000 or P1200 for dust nibs.

Film Build:

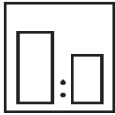
30 microns.

Health & Safety:

Contains VOC's therefore, avoid breathing in vapours.
Observe normal hygiene habits when using.



ETCH FILLER PRIMER



2:1
2K Toner



Visc.
18-20 Secs



Flash off
5-10 mins



Description:

High-build two-pack acid etch primer surfacer for car refinishing and new body work. Provides etching to bare metal at the same time reasonable build.

Product and Additives:

METALUX 2 Etch Filler Primer, 8786
METALUX 2 2 Activator, 8787
METALUX 2 2K Thinner, 1159

Basic Raw Materials:

METALUX 2 Etch Filler Primer: PVB and U/F resins
METALUX 2 Activator: Acidic Solution

Suitable Substrates:

METALUX 2 Etch Filler Primer can be applied over
- Existing Finishes except Thermoplastic Acrylics and NC products,
- Bare steel, wood, polyester laminates,
- Can be applied on aluminum and galvanizing.

Surface Preparation:

- Degrease, then flat bodyfillers with P180 - P280 grit,
- Abrade steel with P80 - P180 grit.
Dry sand P360 - P400 grit.
- Existing surfaces wet flat P280 - P400 grit,
dry flat P180 - P280 grit.

Mixing Ratio:

2 parts by volume **METALUX 2** Etch Filler Primer,
1 part by volume **METALUX 2** Activator
Thin to 18 secs Ford 4 @ 25°C using
METALUX 2 2K Thinner (if required)

Pot Life:

24 hours @ 25°C

Process:

Apply one to two single wet coats depending on build required allowing 5 - 10 minutes flash off between coats.

Spray Gun Settings:

Gravity Feed: 1.5mm - 1.8mm 2.00mm tip 2-4 bar
Syphon Feed: 1.8mm - 2.2mm 2.00mm tip 2-4 bar

Film Build:

± 25 micron per coat

Cleaning of Equipment:

Use lacquer thinners

Drying Time:

Dry to flat - 30 minutes @ 25°C

Recommended Flattening:

Wet flat initially P500 - P600 grit
Finally wet flat with P800 - P1000 grit
Dry flat initially P280 grit
Dry flat finally with P360 - P400 grit

Recoatibility:

All Chemspec products except **METALUX 2** Basecoat, in the car refinish range

Health & Safety:

Refer to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment. Warning catalyst contains Acidic Solution. For further information, refer Material Safety Data Sheet upon request.



2K HS DARK BEIGE OR GREY FILLER PRIMER



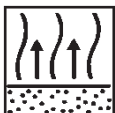
4:1 Normal
Hardner/
5:1 MS
Hardener



Visc.
18-20 Secs



Gravity
Feed



Flash off
5-10 mins



Description: High-build two-pack primer surfacer for car refinishing and new bodywork. Provides an ideal substrate for all car refinishing.

Product and Additives: **METALUX 2** 2K HS Filler Dark Beige (9334)/ Grey (9339) Primer easy sand
METALUX 2 Normal or MS Hardeners see below
METALUX 2 2K Thinner Fast, 1177/Normal, 1159/Medium/Slow, 1171

Special Additives: **METALUX 2** Soffflex Additive, 8795

Basic Raw Materials: **METALUX 2** 2K HS Filler Primer: acrylic resin
METALUX 2 Hardener: poly-isocyanate resin

Suitable Substrates: **METALUX 2** 2K HS Filler Primer can be applied over
- Existing Finishes except Thermoplastic Acrylics and NC products
- Bare steel, wood, polyester laminates,
- Not suitable for aluminum, pre-coated steel or galvanized steel.

Surface Preparation:
- Degrease, then flat bodyfillers with P180 - P280 grit,
- Abrade steel with P80 - P180 grit.
Dry sand P360 - P400 grit.
- Existing surfaces wet flat P280 - P400 grit,
dry flat P180 - P280 grit.

Mixing Ratio:
4:1 with Normal **METALUX 2** Hardeners
5:1 with MS **METALUX 2** Hardeners
Thin to 18-20 secs Ford 4 @ 25°C using appropriate **METALUX 2** 2K Thinner. (20-25 % Thinner).

Pot Life: 45 minutes @ 25°C.

Process: Apply one to three single wet coats depending on build required allowing 5-10 minutes flash between coats.

Spray Gun Settings: Gravity Feed: 1.5mm - 1.8mm 2.00mm tip 2-4 bar
Syphon Feed: 1.8mm - 2.2mm 2.00mm tip 2-4 bar

Film Build: ± 40 micron per coat

Cleaning of Equipment: Use lacquer thinners.

Drying Time: Dry to Flat - 4 hours @ 25°C
- 30 minutes @ 60°C
- 15 minutes using IR

Recommended Flattening: Wet flat initially P500 - P600 grit
Finally wet flat with P800 - P1000 grit
Dry flat initially with P280 grit
Dry flat finally P360 - P400 grit

Recoatibility: All Chemspec products in the car refinish range.

Health & Safety: Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



2K HS FILLER PRIMER TONERS



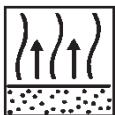
4:1 Normal Hardener/
5:1 MS Hardener



Visc.
18-20 Secs



Gravity Feed



Flash off
5-10 mins



Description:

Coloured, high-build two-pack primer surfacer for car refinishing and new bodywork. Provides an ideal substrate for all car refinishing. The system comprises six coloured surfaces (white, black, yellow, blue, green & red), which can be mixed with each other using simple mixing formulae.

Product and Additives:

METALUX 2 2K HS Filler Primer Toners - White (9341), Black (9342), Red (9343), Blue (9344), Yellow (9345) and Green (9346)

METALUX 2 Normal or MS Hardeners - see below

METALUX 2 2K Thinners, Fast (1177), Normal (1159), Medium/Slow (1171)

Special Additives:

METALUX 2 Softflex Additive, 8795

METALUX 2 HF Clear, 8751

Basic Raw Materials:

METALUX 2 2K HS Filler Primer Toners: acrylic resin
METALUX 2 Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 2K HS Filler Primer Toners can be applied over

- Existing Finishes except Thermoplastic Acrylics and NC products,
- Bare steel, wood, polyester laminates,
- No suitable for aluminium, pre-coated steel or galvanized steel.

Surface Preparation:

- Degrease, then flat bodyfillers with P180 - P280 grit,
- Abrade steel with P80 - P180 grit.
Dry sand P360 - P400 grit.
- Existing surfaces wet flat P280 - P400 grit,
dry flat P180 - P280 grit.

Mixing Ratio:

As for sanding surfaces which will be top coated either with 2K enamel or basecoat/clearcoat:

4:1 with Normal **METALUX 2** Hardeners or

5:1 with MS **METALUX 2** Hardeners by volume

Thin to 18-20 secs Ford 4 @ 25°C using appropriate

METALUX 2 2K Thinner. (20-25 % Thinner).

As for interior colours (i.e. underbody work) which will not be top coated:

10 % HF Clear (8751) by volume, then either

4:1 with Normal **METALUX 2** Hardeners or

5:1 with MS **METALUX 2** Hardeners by volume

Thin to 18-20 secs Ford 4 @ 25°C using appropriate

METALUX 2 2K Thinner. (20-25 % Thinner).

Pot Life:

45 hours @ 25°C

Process:

Apply one to three single wet coats depending on build required allowing 5 - 10 minutes flash between coats.

Spray Gun Settings:

Gravity Feed: 1.5mm - 1.8mm 2.00mm tip 2-4 bar

Syphon Feed: 1.8mm - 2.2mm 2.00mm tip 2-4 bar

Film Build:

± 40 micron per coat

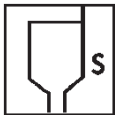
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2K HS FILLER PRIMER TONERS - Continued



4:1 Normal
Hardener/
5:1 MS
Hardener



Visc.
18-20 Secs



Gravity
Feed



Flash off
5-10 mins



Cleaning of Equipment: Use lacquer thinners

Drying Time: Dry to flat - 4 hours @ 25°C
- 30 minutes @ 60°C
- 15 minutes using IR

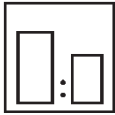
Recommended Flattening: Wet flat initially P500 - P600 grit
Finally wet flat with P800 - P1000 grit
Dry flat initially P280 grit
Dry flat finally with P360 - P400 grit

Recoatibility: All Chemspec products in the car refinish range

Health & Safety: Refer to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



2K TINTING FILLER



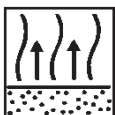
2:1 Metalux 2
2K Toners



4:1 Normal
Hardner/
5:1 MS
Hardener



Visc.
18-20 Secs



Description:

High-build two-pack primer surfacer for car refinishing and new bodywork. Filler can be tinted to improve opacity of the top coat. Provides an ideal substrate for all car refinish.

Product and Additives:

METALUX 2 2K Tinting Filler, 8797 - Easy Sand
METALUX 2 Normal or MS Hardeners see below
METALUX 2 2K Thinner Fast, 1177/Normal,
1159/Medium/Slow, 1171
METALUX 2 2K Toners

Special Additives:

METALUX 2 Softflex Additive, 8795

Basic Raw Materials:

METALUX 2 2K Tinting Filler: acrylic resin
METALUX 2 Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 2K Tinting Filler can be applied over

- Existing Finishes except Thermoplastic Acrylics and NC products
- Abrade steel P80 - P180 grit. Dry sand P360 - P400 grit.
- Existing surfaces wet flat P280 - P400 grit, dry flat P180 - P280 grit.

Mixing Ratios:

2:1 with **METALUX 2** 2K Toners to obtain desired colour then mix 4:1 with Normal **METALUX 2** Hardeners OR 5:1 with MS **METALUX 2** Hardeners
Thin to 18-20 secs Ford 4 @ 25°C using appropriate **METALUX 2** 2K Thinner

Pot Life:

45 minutes @ 25°C.

Process:

Apply one to three single wet coats depending on build required allowing 5-10 minutes flash between coats.

Spray Gun Settings:

Gravity Feed: 1.5mm - 1.8mm 2.00mm tip 2-4 bar
Syphon Feed: 1.8mm - 2.2mm 2.00mm tip 2-4 bar

Film Build:

± 40 micron per coat

Cleaning of Equipment:

Use lacquer thinners.

Drying Time:

Dry to Flat - 4 hours @ 25°C
- 30 minutes @ 60°C
- 15 minutes using IR

Recommended : Flatting

Wet flat initially P500 - P600 grit
Finally wet flat with P800 - P1000 grit
Dry flat initially with P280 grit
Dry flat finally P360 - P400 grit

Recoatibility:

All Chemspec products in the car refinish range

Health & Safety:

Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.

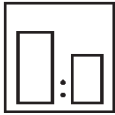
POLYPROP FILLER PRIMER



Description:	A one pack filler primer for polypropylene plastic substrates.
Code:	8850NF
Specifications:	Viscosity: 15-20 seconds F4 @ 25°C (RFU) Solids: >30% S.G.: 0.950 1.050
Suitable Substrate:	Polypropylene
Preparation:	Clean thoroughly at least 3 to 4 times, each time using fresh Silicone Remover to ensure that the surface is clean and free of contamination (if possible clean in conjunction with 3M scotchbrite ultra fine or a small nail brush). Allow to evaporate and dry thoroughly. Now wipe in <u>one direction</u> with Anti Static Degreaser with a cloth.
Paint System:	Materials Required: <ul style="list-style-type: none"> - Anti Static Degreaser (9145) - METALUX 2 Polyprop Filler Primer (8850NF) - METALUX 2 2K HS Primer (9334/9339) - Softflex Additive (8795) - Top coat required.
Application Priming:	<ul style="list-style-type: none"> - Apply 2 single coats (ready for use) METALUX 2 Polyprop Filler Primer. Spray pressure 4 Bar. - Allow to flash off 5 mins/20°C - To Overcoat : 10 minutes @ 25°C / 77°F. - To Flat (Sand): 4 hours @ 25°C / 77°F. - 20 minutes @ 60°C / 140°F. - Apply METALUX 2 2K HS Primer mixed as follows for extra build if required (or apply top directly). 10% Softflex Additive then 4:1 or 5:1 with appropriate hardener (ref. HS Primer datasheet). Thin with 2K thinner to approximately 15 secs Ford 4 Cup. - Apply 2 thin coats. - Spray pressure 4 bars - Flash off 10 mins.
Top Coat Procedures:	<ul style="list-style-type: none"> - METALUX 2 2K enamel solid colour. Mix 10% Softflex Additive before adding your selected hardener 2:1. Thin with 2K thinner to 17-18 secs viscosity Ford 4 Cup. - Apply 2 thin coats allowing 5-10 minutes. Flash off between coats. - Air dry overnight or low bake 30 mins @ 60°C
Two Stage Basecoat - Clear coat:	<ul style="list-style-type: none"> - Thin METALUX 2 basecoat as normal with the basecoat thinner 40-50% to 16 secs. Ford 4 Cup. - Apply 2 cross coats. - Allow at least 15 mins flash off. - METALUX 2 HF Clear. Mix 10% Softflex Additive before adding selected hardener 2:1. Thin with 2K thinner to 17-18 secs viscosity Ford 4 Cup. - Apply two coats only.
Cleaning of Equipment:	Use lacquer thinners.
Health & Safety:	Contains VOC's therefore, avoid breathing in vapours. Observe normal hygiene habits when using.



BASECOAT



2:1



Visc.
16 Secs



Flash off
4-8 mins.



Description:

One-pack basecoat designed for private cars, commercial vehicles and equipment; as well as for repair to existing OEM two and three coat systems, as well as design work. These basecoats have been formulated with the highest quality range of light fast pigments to meet the OEM colour standards. Good coverage, flow and ease of application provide the refinisher with a quality product. **METALUX 2** basecoats must be overcoated with a clearcoat.

Product and Additives:

METALUX 2 Basecoat
METALUX 2 Pearl basecoat
METALUX 2 Mica basecoat
METALUX 2 Basecoat thinners, 1155/1154

Suitable Substrates:

METALUX 2 can be applied over

- Existing Finishes except Thermoplastic Acrylics and NC products
- All current Chemspec preparatory products with exception of washprimer and 2K etch primer filler.
- Ideal over **METALUX 2** 2K HS Dark Beige or Grey Filler Primer

Surface Preparations:

Degrease then wet flat P800 - P1000 grit or dry flat P360 - P400 grit. Degrease.

Mixing Ratio:

Thin to 16 secs Ford @ 25°C for spraying
 2 parts (by vol) **METALUX 2** Basecoat
 1 part (by vol) **METALUX 2** Basecoat Thinners

Process:

Apply 2 single coats with 4-8 minute flash off between coats. A third single coat may be required with colours difficult to cover. Drop the air pressure to 2 bar and apply a final drop coat. Flash off for 15 minutes before applying clear.

Sanding:

Dust nibs can be removed with P1000-P1500 after 5-10 minutes.

Spray Gun Settings:

Gravity Feed:	1.2mm - 1.5mm	2 - 4 bar
Syphon Feed:	1.4mm - 1.6mm	2 - 4 bar
HVLP:	1.3mm - 1.4mm	

Film Build:

± 10 micron

Cleaning of Equipment:

Use Lacquer thinner

Recoatibility:

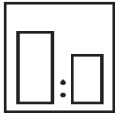
Must be recoated with clear after 15 minutes and before 8 hours.

Health & Safety:

Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



HF CLEAR



2:1



Visc.
15-18 Secs



Description:

Two-pack clearcoat formulated for the **METALUX 2** basecoat system. It has been designed as both a touch up and respray clearcoat, where "invisible" repairs to the OEM factory finish is desired.

Products and Additives:

METALUX 2 HF Clearcoat, 8751
METALUX 2 2K Hardener Fast, 8750 / Medium, 8767 / Slow, 9072 / Express, 9335
METALUX 2 2K Thinner Normal, 1159 / Fast, 1177 / Slow, 1171

Special Additives:

METALUX 2 Matting Base, 8794
METALUX 2 Accelerator, 8784
METALUX 2 Softflex Additive, 8795

Basic Raw Materials:

METALUX 2 HF Clear: acrylic resin
METALUX 2 2K Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 HF Clear has been designed to be applied over **METALUX 2** Basecoats.

Mixing Ratio:

100 parts by volume of **METALUX 2** HF Clear
50 parts by volume **METALUX 2** 2K Hardener of your choice
Thin 10-20% with **METALUX 2** 2K Thinner to 15-18 secs Ford 4 @ 25°C
- **METALUX 2** Accelerator. Add 2% to 5%. Next add hardener and thinner as specified
- Plastic Parts Softflex Additive. First add the required percentage (10% for rigid plastic, 20% for flexible plastic). Next add hardener and thinner as specified.

Pot Life:

When mixed 4 hours @ 25°C

Process:

Apply three single wet coats with 5-10 minutes flash off between coats.

Spray Gun Settings:

Gravity Feed:	1.2mm - 1.5mm	3 - 4 bar
Syphon Feed:	1.4mm - 1.6mm	3 - 4 bar

Film Build:

20 - 25 micron per coats for HF Clear.

Cleaning of Equipment:

Use lacquer thinners

Drying Time:

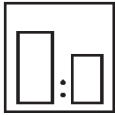
Dust free	30 min @ 25°C
Hard Dry	24 hours @ 25°C
Recoatable	after full cure (± 7 days @ 25°C)
Force dry	45 min @ 60°C metal

Health & Safety:

Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



MS CLEARCOAT



2:1



Visc.
15-18 Secs



Description:

Two-pack high build medium solids clear coat formulated for the **METALUX 2** basecoat system. It has excellent gloss and flow characteristics. **METALUX 2** MS Clear ensures a higher film build after application of only two coats. This means substantial savings in both application time and product usage.

Product and Additives:

METALUX 2 MS Clearcoat, 9090
METALUX 2 MS Hardener Fast, 9091 / Medium, 9092 / Slow, 9093 / Ultra Fast, 9082
Note: Own Special Hardener
METALUX 2 Thinner Normal, 1159 / Fast, 1177 / Slow, 1171

Special Additives:

METALUX 2 Matting Base, 8794
METALUX 2 Accelerator, 8784
METALUX 2 Softflex Additive, 8795

Basic Raw Materials:

METALUX 2 Clear: acrylic resin
METALUX 2 Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 MS Clear has been designed to be applied over **METALUX 2** Basecoats.

Mixing Ratio:

100 parts by volume of **METALUX 2** MS Clear
 50 parts by volume **METALUX 2** MS Hardener of your choice
 Thin 10-20% with **METALUX 2** 2K Thinner to 15-18 secs
 Ford 4 @ 25°C

Note: For the Ultra Fast system (9082).
 Mix 100 parts by volume **METALUX 2** MS Clear
 50 parts by volume **METALUX 2** 2K Ultra Fast
 50 parts by volume **METALUX 2** 2K Thinners

METALUX 2 Accelerator. Add 2% to 5%. Next add hardener and thinner as specified (not recommended for with Ultra Fast Hardener)

Plastic Parts Softflex Additive. First add the required percentage (10% for rigid plastic, 20% for flexible plastic). Next add hardener and thinner as specified.

Pot Life:

When mixed 4 hours @ 25°C for 9091, 9092 & 9093
 When mixed 3 hours @ 25°C for 9082

Process:

Apply two single wet coats with 5 10 minutes flash off between coats for **METALUX 2** MS Clear.

Spray Gun Settings:

Gravity Feed:	1.2mm - 1.5mm	3 - 4 bar
Syphon Feed:	1.4mm - 1.6mm	3 - 4 bar

Film Build:

25 30 micron per coat for MS Clear.

Cleaning of Equipment:

Use lacquer thinners

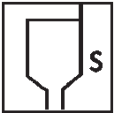
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MS CLEARCOAT- Continued



2:1



Visc.
15-18 Secs



Drying Time:

Dust free	30 min @ 25°C
Hard Dry	24 hours @ 25°C
Recoatable	after full cure (± 7 days @ 25°C)
Force dry	45 min @ 60°C metal when using 9091, 9092 & 9093
	15 min @ 60°C metal when using 9082

Health & Safety:

Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



VOC 4.2 SPEEDCLEAR



Description: Two-pack high build VOC compliant clearcoat. It has excellent gloss and flow characteristics. **METALUX 2** VOC 4.2 speedclear ensures a higher film build after application of only two coats. This means substantial savings in both application time and product usage. Designed for spot and panel application over basecoat. **METALUX 2** VOC 4.2 Speedclear has a VOC of <4.2 lbs/gal.

Product and Additives: **METALUX 2** VOC 4.2 Speedclear
METALUX 2 MS Hardener Fast, 9091/
Medium, 9092/Ultra Fast, 9082

} *Note: Own special Hardener*

Special Additives: **METALUX 2** 2K Matting Base, 8794
METALUX 2 Softflex Additive, 8795

Basic Raw Materials: **METALUX 2** VOC 4.2 Speedclear :acrylic resin
METALUX 2 Ultrafast Hardener :poly-isocyanate resin

Suitable Substrates: **METALUX 2** VOC 4.2 Speedclear has been designed to be applied over **METALUX 2** Basecoat.

Mixing Ratio: 100 parts by volume of **METALUX 2** VOC 4.2 Speedclear
50 parts by volume of **METALUX 2** Ultra Fast Hardener
Accelerator not recommended
Plastic Parts
- Softflex additive. First add the required percentage (10% for rigid plastic, 20% for flexible plastic).
Next add the Hardener.

Pot Life: When mixed 3 hours at 25°C
Do not try to thin clear after thickening has occurred.
Do not use.
Note: Accelerators and temperature will affect pot life.

Process: As an overall or full-panel clearcoat
- Allow basecoat to dry for 15 minutes
- Apply one medium wet coat and then
- Apply 2 full coats of clear for proper film build and protection (2.0 mils dry film minimum). Excessive amounts of clear will retard drying and curing, and may cause die-back.
- A 3rd coat may be applied if extensive sanding and polishing is anticipated.
- Do not apply more clear after 1 hour of applying previous coats of clear.

Full Bake Cycle For Heavy Buffing/Compounding or Assembly
- No purge time is necessary.
- Bake 30-35 minutes at 60°C.
- Allow a 1-2 hour cool down prior to assembling or buffing.
- Do not bake basecoat prior to clearing adhesion loss between colour and clear may occur.

Quick Bake Cycle For Light Polishing or Out of Dust
- No purge time is necessary
- Bake 10-15 minutes at 60°C
- Allow a 1-2 hour cool down prior to assembling of buffing.

... Continued on page 14



VOC 4.2 SPEEDCLEAR - Continued



2:1



Special Notes

- Use in shop temperatures that are maintained above 25°C for the first 24 hours of cure cycle.
- Ensure surfaces are up to shop temperature prior work.
- Use a mixing cup for accurate volume measurements.
- **METALUX 2** VOC 4.2 Speedclear will be water resistant in 24 hours. Note: Do not allow raindrops to dry on a new finish for 3-4 days to prevent staining.
- Urethane coatings take 5-7 days to properly cure. Care should be taken during first week of washing. Do not use a pressure washer on fresh clear.
- Do not use over lacquer.

Spray Gun Settings: Gravity Feed: 1.2mm - 1.5mm 3 - 4 bar
Syphon Feed: 1.8mm - 2.2mm 3 - 4 bar

Film Build: 25 30 micron per coat for MS Clear

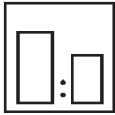
Cleaning of Equipment: Clean equipment immediately after use with lacquer thinners.

Drying Time: Dust Free - 15 mins @ 25°C
Dry to Polish - 1,5 hours @ 25°C
Dry to Buff - 6-8 hours @ 25°C
Force Dry - 15 mins @ 60°C metal (light polish)
35 mins @ 60°C metal (heavy buffing)

Health & Safety: Refer to text on label.
Flammable - keep away from sources of ignition.
No smoking.
Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



2K POLYURETHANE



2:1
10-20%
2K Thinner



Visc.
15-18 Secs



Description:

Two-pack acrylic enamel for passenger cars, commercial vehicles and equipment. Designed for universal application. For new work and repairs. The outstanding durability, high gloss and excellent flow make this product an excellent choice for the car refinisher and DIY enthusiast.

Product and Additives:

METALUX 2 2K Polyurethane
METALUX 2 Hardener Fast, 8750 / Medium, 8767 / Slow, 9072 / Express, 9335
METALUX 2 Thinner Normal, 1159 / Slow, 1171 / Fast, 1177

Special Additives:

METALUX 2 Matting Base, 8794
METALUX 2 Accelerator, 8784
METALUX 2 Softflex Additive, 8795

Basic Raw Materials:

METALUX 2 : acrylic resin
Hardener: poly-isocyanate resin

Suitable Substrates:

METALUX 2 can be applied over
- Existing finishes except Thermoplastic Acrylics and NC products
- All **METALUX 2** Primers

Surface Preparation:

Degrease then wet flat P800 - P1000 grit or dry flat P360 - P400 grit. Wipe with Benzine.

Mixing Ratio:

100 parts by volume of **METALUX 2** 2K Polyurethane
50 parts by volume **METALUX 2** Hardener
Thin 10-20% with **METALUX 2** Thinners to 15-18 secs Ford @ 25°C
- **METALUX 2** Accelerator. Add 2% to 5%.
Next add hardener and Thinner as specified.

Pot Life:

When mixed, 4 hours @ 25°C

Process:

Apply 2 coats allowing 5-10 minutes flash off between coats.

Spray Gun Settings:

Gravity Feed:	1.2mm - 1.5mm	3 - 4 bar
Syphon Feed:	1.4mm - 1.6mm	3 - 4 bar

Film Build:

± 25 micron per coat

Cleaning of Equipment:

Use lacquer thinners

Drying Time:

Dust free	30 min @ 25°C
Hard Dry	24 hours @ 25°C
Recoatability	after full cure (± 7 days @ 25°C)
Force dry	45 min @ 60°C metal

Health & Safety:

Ref to text on label. Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



MATTING BASE



Description: **METALUX 2** Matting Base is a specially formulated product designed only for the **METALUX 2** 2K range of products.

Code: 8794

Application: Add the required amount of matting base and stir in thoroughly, add the selected hardener 2:1

Mixing Ratio:

- MATT	600ml / 1lt of METALUX 2	60%
- SEMI-MATT	500ml / 1lt of METALUX 2	50%
- SHEEN	300ml / 1lt of METALUX 2	30%

Health & Safety: Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



ACCELERATOR



Description:

METALUX 2 Accelerator has been formulated as an additive to the **METALUX 2** 2K system to speed up the initial cure of the product. It is ideally used at low temperatures or where small touch up requires a faster cure.

Code:

8784

Mixing Ratio:

Add 2% to 5% of **METALUX 2** Accelerator (1 cap to 3 caps) to the base i.e. **METALUX 2** solid colour or clear before the addition of the hardener - for 1 lt.

Pot Life / Gel Time:

The potlife of the Accelerator and catalysed product will be reduced by 50% @ 25°C.

Warning:

Use only under guidance from a technical representative.

Health & Safety:

Flammable - keep away from sources of ignition. No smoking. Do not breathe in spray. In case of insufficient ventilation, wear suitable respiratory equipment.



ANTI SILICONE SOLUTION



10% into
final mix



Description:

METALUX 2 Anti Silicone Solution has been formulated to eliminate fish eyes. It can be added to HS primer or **METALUX 2** Top coats when required.

Code:

2008

Basic Raw Materials:

Silicone and solvents.

Mixing Ratio:

Add one capful (15ml) to a 1.5 litre mix (ie. 1litre **METALUX 2** Base + ½ litre **METALUX 2** Hardener).

Warning:

Use carefully and sparingly per instructions.
Excessive use will affect the entire paint shop.

Health & Safety:

Refer to text on label. Is a skin and eye irritant. In case of accidental contact with the skin or eyes, rinse immediately with plenty of water and seek medical attention. Store in a cool place and keep out of reach of children. Keep container closed when not in use.



PREPARATION & PAINTING OF POLYPROPYLENE BUMPERS (NEW BUMPERS)



Description:	Preparation & Painting of polypropylene bumpers (new bumpers).
Preparation:	Clean thoroughly at least 3 to 4 times, each time using fresh silicone remover to ensure that the surface is clean and free of contamination (if possible clean in conjunction with 3M scotch-brite ultra fine or small nail brush). Allow to evaporate and dry thoroughly. Now wipe in <u>one direction</u> with Anti Static Degreaser with a clean cloth.
Paint System:	Materials Required: <ul style="list-style-type: none">- Polypropylene Primer, 3812- HS Primer, 8793; 9334- Softflex Additive, 8795- Fast Hardener, 8750 / Express, 9335- 2K Thinner, 1159, 1171, 1177- Topcoat required
Application Priming:	<ul style="list-style-type: none">- Apply 1-2 coats (ready use) Polypropylene Primer- Allow to flash off 15 mins / 20°C- Now apply HS Primer mixed as follows: 10% Softflex Additive then 4:1 or 5:1 with appropriate hardener. Thin with 2K thinner to approximately 15 secs Ford 4 Cup. Apply <u>2 thin</u> coats.- Spray pressure 4 bars- Flash off 10 mins.
Top Coat Procedures:	<ul style="list-style-type: none">- METALUX 2 2K enamel solid colour. Mix 10% Softflex Additive before adding your selected hardener 2:1. Thin with 2K thinner to 17-18 secs viscosity Ford 4 Cup.- Apply 2 thin coats allowing 5-10 minutes. Flash off between coats.- Air dry overnight or low bake 30 mins @60°C
Two Stage Basecoat - Clearcoat:	<ul style="list-style-type: none">- Thin METALUX 2 basecoat as normal with the basecoat thinner 40-50% to 16 secs. Ford 4 Cup.- Apply 2 cross coats.- Allow at least 15 mins flash off.- METALUX 2 HF Clear. Mix 10% Softflex Additive before adding selected hardener 2:1. Thin with 2K thinner to 17-18 secs viscosity Ford 4 Cup. Apply two coats only.



PREKLEEN



Description:	A clear solvent combination used for the removal of grease, oils and foreign substances before painting. Specially designed to evaporate at the correct rate when used correctly.
Code:	9021
Process:	Use a clean silicone free rag to apply. Do not place rag on opening of container as contamination could occur. Pour Prekleen onto rag or into a separate container and use from this container and then discard. Wipe in one direction with rag soaked in Prekleen. Follow up with a separate clean rag in the same direction. Clean article in sections - not all at once.
Health & Safety:	Flammable. No smoking. Contains VOC's therefore avoid breathing in vapours. Avoid contact with skin, wear gloves. Is a skin and eye irritation. Keep away from children.



ANTI STATIC DEGREASER



Description:	Specifically formulated solvent blend designed to prevent the build up of static. Recommended for use on substrates prone to static build up eg. Polypropylene.
Code:	9145
Product:	Solvent blend.
Required Materials:	Metalux 2 Silicone Remover (9020) Metalux 2 Anti Static Degreaser
Process:	Clean thoroughly at least 3 to 4 times, each time using fresh silicone remover to ensure that the surface is clean and free of contamination. Use a clean rag to apply. Do not place rag on opening of container as contamination could occur. Pour silicone remover onto rag or into a separate clean container and use from this container and then discard. Wipe in one direction only. Follow up with a separate clean rag in the same direction. Clean article in sections - not all at once. Once substrate is thoroughly dry, repeat with Anti Static Degreaser in the same manner using a clean cloth.



THINNERS - FAST, NORMAL, SLOW



Description: Thinners, which offer a great variety of applications within the range of **METALUX 2**, range of car refinishes.

Product and Additives: Thinner Fast (1177): for spot and panel repairs.
Thinners Normal (1159): for treatment of large vehicles within the temperature of 20°C - 25°C.
Thinner Slow (1171): for treatment of large vehicles within the temperature range of 25°C - 40°C.

Basic Raw Materials: Various solvents.

Mixing Ratio: Adhere to the mixing ratios specified in the technical data sheets of the above products.



SUPER BLEND THINNERS



Description: Specially formulated solvent designed for dissolving edges of fade-out areas invisibly into the background in the process of spraying topcoats (making spot repairs).

Product and Additives: Super Blend Thinners (1174) can be used in HF Clear, MS Clear, 2K Enamel

Application Process: Follow fading out of the above products, the fade-out area can be resprayed immediately with pure Super Blend Thinner. Perform this in two steps:

- Re-spray the fade-out area sparingly with the Super Blend Thinner
- Immediately thereafter (after 10-15 seconds), re-spray again with Super Blend Thinner



SELECTION OF HARDENERS

					CAN USE SLOW HARDENER WHEN ABOVE 35°C WITH NORMAL REDUCER 1159	
		METALUX 2 HF CLEAR 8751 & SOLID COLOURS	METALUX 2 HF CLEAR 9090	METALUX 2 VOC 4.2 SPEEDCLEAR	METALUX 2 HS 2K PRIMER	METALUX 2 HS 2K PRIMER
		2:1 WITH RECOMMENDED HARDENER			4:1 WITH METALUX 2 2K HARDENERS	5:1 MS HARDENERS
35°C/95°F	SLOW HARDENER	9072	9093	9092 MEDIUM HARDENER	8767 MEDIUM HARDENER	9093
	SLOW REDUCER	1171	1171		1159 NORMAL REDUCER	1159 NORMAL REDUCER
30°C/80°F	MEDIUM HARDENER	8767	9092	9091 FAST HARDENER	8767 MEDIUM HARDENER	9092
	NORMAL REDUCER	1159	1159		1159 NORMAL REDUCER	1159
25°C/75°F	MEDIUM HARDENER	8767	9092	9091 FAST HARDENER	8767 MEDIUM HARDENER	9092
	NORMAL REDUCER	1159	1159		1159 NORMAL REDUCER	1159
20°C/70°F	FAST HARDENER	8750	9091	9082 ULTRA FAST	8767 MEDIUM HARDENER	9091
	NORMAL REDUCER	1159	1159		1159 NORMAL REDUCER	1159
15°C/60°F	FAST HARDENER	8750	9082 ULTRA FAST HARDENER	9082 ULTRA FAST	8767 MEDIUM HARDENER	9091
	NORMAL REDUCER	1159	1177 FAST REDUCER		1177 FAST REDUCER	1177 FAST REDUCER
10°C/50°F						

NOTE: The mixing ratio for **METALUX 2** VOC 4.2 Speedclear is 2:1 with Ultra Fast Hardener (9082), no thinners required.

The mixing ratio for **METALUX 2** MS Clear (9090) with Ultrafast Hardener (9082) is 2 parts Clear : 1 part Hardener : 1 part thinner by volume.

METALUX 2 BINDER ADDITIVE 9299

Description:

A special additive that can be added to both basecoat and 2K topcoats. Specifically designed to lower the overall cost in-the-can without affecting the coverage.



3:1 Binder Additive

Code

9299

Application Process:

Add in a ratio of 3 parts paint to 1 part Binder Additive (by volume) before thinners and hardener. Addition of thinners and hardener remains at the same ratio with or without Binder Additive.





SPOT REPAIR PROCESS

Description: The term spot repair is understood to include all repairs to damaged areas resulting in the repaired area being blended invisibly into the still intact old finish. As a result, the car refinisher is not compelled to spray large panels in the case of minor damage. The spot repair technique also allows minor difference in color and effect between the original car finish and the refinish to be made invisible.



1. Repaired area.
2. Area in which blending will occur
3. Where clear coat will be applied
- A. First coat of Blending Additive (1056)
- B. Second coat of Blending Additive (1056)

Once panel has been sanded and degreased ready for topcoat:

- Reduce 1056 Blending Additive 2:1 with Metalux 2 basecoat thinners.
- One coat of 1056 Blending Additive is applied to the area marked (A) on the panel. Flash off five to ten minutes before next coats.
- Second coat is applied to the area marked (B) on the panel. Avoid applying too close to the edge (about 4 inches away) as it could change the color of the adjacent panel.
- Once 1056 Blending Additive is applied, it is advisable to overcoat the area with your ready mixed color as soon as possible.
- Apply two to three coats of your ready mixed base color by blending into area (2) making sure your primer patch is covered.
- Apply first coat of Clearcoat to the area marked (3) on the panel and the second coat on the entire panel. Due to the reduced mil thickness of a Clearcoat on a blended edge, it may become visible with time. Harsh weather conditions and aggressive polishing will accelerate this process. Subsequently, 'Chemspec will not guarantee blend edges of the Clearcoat. For the Metalux warranty, Clearcoat must be applied to the entire panel.