





# Metalux™ 9347 High Solids Primer Filler




**COMPONENTS**  
9347 2K Primer Filler  
Hardeners (9082, 9091, 9092),  
Reducers (1156, 1157, 1158)




**APPLICATION**  
1-3 coats  
5-10 minute flash off between coats




**MIX RATIO**  
4 : 1 : 1



**DRY TIME**  
To sand – 45 minutes to 1 hour (per coat)



**VISCOSITY**  
Ford #4  
18 seconds



**VOC**  
534 grams / liter  
4.46 lbs / gallon



## GENERAL

### DESCRIPTION

Metalux 9347 2K HS Primer Filler is a 2 component high-build primer filler (surfacers) for automotive refinishing and new bodywork. 9347 offers fast dry times, delivering excellent sanding characteristics while providing a stable substrate for all refinishing essentials.

**The products referenced herein may not be sold in your market. Please consult your distributor for product availability.**

### COLOR

- 9347 Grey



## MIXING

### COMPONENTS

Mix 4 parts Metalux™ 9347 2K HS Primer Filler to 1 part Metalux MS Hardener to 1 part Metalux Universal Reducer (a spray viscosity of 18 secs with Ford #4 @77°F/25°C). Maximum RFU VOC 4.1 lbs/gal.

NOTE: If used without thinning, can cause improper drying issues.

NOTE: DO NOT mix with Metalux colored primers (9341-9346).

Component	Volume
Metalux 9347 2K HS Filler Primer Grey	4
Metalux MS Hardeners (9082 Ultra Fast, 9091 Fast, 9092 Medium)	1
Metalux Universal Reducers (1156 Fast, 1157 Medium, 1158 Slow)	1



**Package Sizes**

- 1 gallon (3.75 liters)

**INITIAL APPLICATION VISCOSITY**

Ford #4 Viscosity 18 seconds

**POT LIFE**

1 hour @75°F(24°C)




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.4 - 1.6 mm	1.0 - 1.25 (Bar)	6 - 8 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	1.0 - 1.25 (Bar)	17 - 19 PSI	At gauge

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

**SURFACE PREPARATION**

Degrease then sand body filler with P180 – P320 grit sandpaper. Abrade steel with P180 grit sandpaper. Existing surfaces (Featheredge); use P180 – P400 grit sandpaper. Large bare metal areas should be coated with 8816 Metalux 2K Etch Primer before priming with 9347.

**APPLICATION**

Apply 1 – 3 single coats depending on desired film build. Allow 5 – 10 minutes flash off between coats. Brush or roll on for small repairs; apply 1 even coat to beyond the featheredge; a second coat if needed, after the first coat has tacked up, to within ¼ inch of the first coat.




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**DRY TIMES**

**AIR DRY  
75°F (24°C)**

To Sand	45 minutes – 1 hour (per coat)
To Topcoat	Must be sanded first
Rolled or Brushed	Overnight dry is required

**INFRARED SHORT WAVE**

15 Minutes full power @36"

NOTE: Topcoat within 6 – 7 hours after initial sanding or re-scuffing is necessary.




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**PHYSICAL PROPERTIES**

Recommended Film Thickness	± 63.5 microns / 2-3 mils per coat
VOC as Applied	4.46 lbs/gallon (RFU)
Mixed Volume Solids	45.5% (Average)
Theoretical Coverage	Approx. 611 SqFt @ 1 Mil DFT/mixed gallon
Recommended Coats	2-3 (x1)
Film Thickness	2.0 – 3.0 mils per coat
Recommended Dry Film After Sanding	1.5 – 3.0 mils per coat
Pot Life	45 Minutes @77°F(25°C)
Flash Point	See SDS



### STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

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### VOC REGULATED AREAS

VOC as Applied

534 grams/liter | 4.46 lbs/gallon

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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### SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

**Revised: July 2018**

In the United States and Canada:

**1.855.6.AXALTA**  
**metalux.us**

