




Metalux™ 934X 2K High Solids Primers



COMPONENTS 934X 2K HS Primers
MS Hardeners 909X
Reducers (1156, 1157, 1158)



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




MIX RATIO 4 : 1 : 1



DRY TIME To sand – 1 hour (per coat)



VISCOSITY Zahn #3 18-20 seconds
Ford #4 18-20 seconds



VOC 494 grams / liter
4.12 lbs / gallon



GENERAL

DESCRIPTION

Metalux™ 934X High Solids Primers are very diverse colored, high-build, 2 component primer toners designed for car refinishing and new bodywork. Provides an ideal substrate for all car refinishing. The system comprised of six rich colors (white, black, yellow, blue, green & red), which can be mixed with each other using simple mixing formulas. Used for matching under hood colors as well as interior colors when integrated with Metalux® clears for added durability.

COMPATIBLE SUBSTRATES

Thoroughly sanded OEM finishes adjoining metal. Thoroughly sanded and cured paint adjoining metal. Properly cleaned and prepared steel, aluminum, galvanized steel following an etch primer. Properly prepared semi-rigid plastic and fiberglass.

COLOR

- 9341 White
- 9342 Black
- 9343 Red
- 9344 Blue
- 9345 Yellow
- 9346 Green

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



MIXING

COMPONENTS

Primer: Mix 4 parts Primer to 1 part MS Hardener to 1 part appropriate Metalux Urethane Reducer. (spray viscosity of 18-20 secs with Ford #4 @ 77°F / 25°C)

Component	Volume
Metalux 2K HS Primers (9343 Red, 9344 Blue, 9345 Yellow, 9346 Green)	4
Metalux MS Hardeners (9082 Ultra Fast, 9091 Fast, 9092 Medium, 9093 Slow)	1
Metalux Universal Reducers (1156 Fast, 1157 Medium, 1158 Slow)	1

As for interior colors (i.e. underbody work) which will not be top coated: 10% METALUX® (9700 or 9701) Clearcoat by volume, then mix by volume: 5 parts Primer to 1 part MS Hardener to 1 part appropriate Metalux Universal Reducer. (spray viscosity of 18-20 secs with Ford #4 @ 77°F / 25°C)

As a wet on flash sealer: 4 Parts Primer to 1 Part MS Hardener to 2 Parts METALUX® Universal Reducer (1156, 1157, 1158)

Package Sizes

- 1 liter

INITIAL APPLICATION VISCOSITY

ZAHN #3 Viscosity 18-20 seconds

POT LIFE

45 Minutes @77°F (25°C)



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.4 - 1.6 mm	1.0 - 1.5 (Bar)	6 - 8 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	1.0 - 1.5 (Bar)	17 - 19 PSI	At gauge

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

SURFACE PREPARATION

Decrease then sand body filler with P180-P320 grit sandpaper. Abrade steel with P180-P320 grit sandpaper. Existing surfaces: P180-P400 grit sandpaper. Large bare metal areas must be etched primed.

APPLICATION

Apply 1 – 3 single wet coats depending on desired film build. Allow 5 – 10 minute flash off between coats.



DRY TIMES

AIR DRY

77°F (25°C)

To sand

1 hour (per coat)

FORCE DRY

30 minutes @140°F (60°C)

INFRARED SHORT WAVE

15 minutes full power @36"

NOTE: Must be topcoated within 6 hours after sanding. After 6 hours, rescuff. As a sealer, rescuff after 3 hours.



PHYSICAL PROPERTIES

Recommended Film Thickness	± 40 microns / 2.0 mils per coat
VOC as Applied – Black/White	4.08 lbs/gallon (RFU)
VOC as Applied – Yellow/Blue/Green/Red	4.12 lbs/gallon (RFU)
Mixed Volume Solids	50-55% (Average)
Theoretical Coverage	N/A
Recommended Coats	1-3 (x1)
DFT per Coat	Approximately 2.0 mils
ZAHN #3 Viscosity	18-20 Seconds
Pot Life	45 Minutes @77°F(25°C)

STORAGE CONDITIONS

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

PERFORMANCE PROPERTIES

Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6 hrs. Base (NaOH) – No effect, 6 hrs. Skydrol – No effect, 24 hrs.
Film Hardness	2H
Impact Resistance	Forward – 100 in/lbs Reverse – 80 in/lbs
Flexibility	Pass Conical Mandrel

VOC REGULATED AREAS

VOC as Applied – Black/White	489 grams/liter 4.08 lbs/gallon
VOC as Applied – Yellow/Blue/Green/Red	494 grams/liter 4.12 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.



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.

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In the United States and Canada:

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