

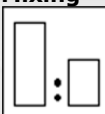

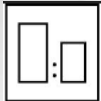





AL441_445_447_V

Autolux Easy-Build 4:1 Primers

Description	AUTOLUX® Easy-Build Primers, AL441/AL445/AL447 White/Grey/Dark Grey are high structure, high solids 2 pack acrylic primers. With fast dry, high build & good sag resistance - they are suitable for spot repair & panel repairs.																
Products	Primer: Hardeners: Thinners:	AL441 <i>Autolux</i> Easy-Build 4:1 Primer - White AL445 <i>Autolux</i> Easy-Build 4:1 Primer - Grey AL447 <i>Autolux</i> Easy-Build 4:1 Primer - Dark Grey AL512 <i>Autolux</i> MS Hardener - Fast (Up to 20°C) AL514 <i>Autolux</i> MS Hardener - Standard (18 - 25°C) AL516 <i>Autolux</i> MS Hardener - Slow (25 - 35°C) AL522 <i>Autolux</i> HS Hardener - Fast (Up to 22°C) AL524 <i>Autolux</i> HS Hardener - Standard (Above 22°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														
<i>Autolux</i> Easy-Build 4:1 Primers may be applied to small areas of bare steel but for best performance <i>Autolux</i> Chromate Free Etch Primer AL411 should be used. Other bare metals such as Aluminium, should always be etch primed.																	
Mixing		<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2" style="text-align: center;">Mixing Ratio</th> </tr> <tr> <th style="text-align: center;">By Volume</th> <th style="text-align: center;">By Weight</th> </tr> </thead> <tbody> <tr> <td><i>Autolux</i> Easy-Build 4:1 Primer AL441/445/447</td> <td style="text-align: center;">4 Parts</td> </tr> <tr> <td><i>Autolux</i> Hardeners AL512/514/516/522/524</td> <td style="text-align: center;">1 Part</td> </tr> <tr> <td><i>Autolux</i> MS Thinner AL651/652/653</td> <td style="text-align: center;">1 Part</td> </tr> <tr> <td>Pot Life: at 20°C</td> <td style="text-align: center;">30 - 40 minutes</td> </tr> <tr> <td>Spray Viscosity: DIN 4 20°C</td> <td style="text-align: center;">32-38 Seconds</td> </tr> </tbody> </table>		Mixing Ratio		By Volume	By Weight	<i>Autolux</i> Easy-Build 4:1 Primer AL441/445/447	4 Parts	<i>Autolux</i> Hardeners AL512/514/516/522/524	1 Part	<i>Autolux</i> MS Thinner AL651/652/653	1 Part	Pot Life: at 20°C	30 - 40 minutes	Spray Viscosity: DIN 4 20°C	32-38 Seconds
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Pre-Thinned		To save preparation time, the 2L pack of AL445 may be pre-thinned and stored on the <i>Autolux</i> mixing machine. <ol style="list-style-type: none"> 1. Take a new 2L tin of AL445 Easy-Build 4:1 primer and hand stir. 2. Add 0.5L of one of the recommended <i>Autolux</i> thinners. (There is sufficient space in the 2L can to add thinner) 3. Hand stir to fully incorporate the thinner with the primer. 4. Attach a mixing machine stirring lid to the tin. 5. Place on the mixing machine and stir for 5 mins. 6. Stir twice daily or ideally just before use. (Do not leave the pre-thinned product for more than 2 weeks without stirring) 															
Pre-Thinned Mixing		To use - Mix with <i>Autolux</i> hardener as shown below. <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="text-align: center;">Volume</th> <th style="text-align: center;">Weight</th> </tr> </thead> <tbody> <tr> <td><i>Autolux</i> Pre-Thinned Easy-Build 4:1 primer</td> <td style="text-align: center;">5 Parts</td> <td style="text-align: center;">100g</td> </tr> <tr> <td><i>Autolux</i> Hardener</td> <td style="text-align: center;">1 Part</td> <td style="text-align: center;">13g</td> </tr> </tbody> </table>			Volume	Weight	<i>Autolux</i> Pre-Thinned Easy-Build 4:1 primer	5 Parts	100g	<i>Autolux</i> Hardener	1 Part	13g					
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Application		HVLP/Compliant gun: Fluid Tip 1.7 - 1.9mm. Air pressure - refer to spraygun manufacturers information															



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<p>Coats</p>	<p>3 coats (150 – 200 microns dry film)</p>		
<p>Flash Time</p>	<p>Until fully matt – normally 3-5 mins at 20°C</p>		
<p>Drying</p>	<p>With AL512/AL522 With AL514/AL524 With AL516</p>	<p>Air Dry/20°C: 1.5 hours. 2.5 hours. 3 hours</p>	<p>Force Dry/60°C (Metal) 15mins 20mins 30mins</p>
<p>Easy-Build 4:1 primers must be sanded prior to overcoating or topcoating</p>			
			<p>Dry sand by machine or by hand or wet sand – refer to relevant Technical Data Sheet of product being applied for sanding grades.</p>
<p>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.</p>			
<p>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.</p>			

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.

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