



AUTOSURFACER 2+1 HS

DESCRIPTION: Autosurfacer 2+1 HS is a High Solids two-part acrylic urethane primer-surfacer, with exceptionally high build for collision repair refinishing work. Easy sanding wet/dry after short drying times. The acrylic urethane character provides minimal or no shrinkage and maximum enamel holdout when topcoat is applied over it.

PRODUCT & ADDITIVES:

PRODUCTS: Autosurfacer 2+1 HS

HARDENERS: Autosurfacer 2+1 HS Hardener

ADDITIVES: For application over plastic parts that have been treated, the use of Autocryl Elast-O-Actif in Autosurfacer 2+1 HS is recommended. See "Flexible Parts" information in this TDS.

BASIC RAW

MATERIALS: Autosurfacer 2+1 HS: acrylic resins
Autosurfacer 2+1 HS Hardener: polyisocyanate resin

SUITABLE SURFACES :

Autosurfacer 2+1 HS can be applied over:

- Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry.
- Any premium polyester bodyfiller sanded with #P180 to #P220 grit dry.
- Steel, degreased and sanded with #P80 then #P120 grit dry.
- Fiberglass gelcoat, degreased and sanded with #P220 to #P320 grit dry. If the gelcoat is broken and has been sanded through, under no circumstances should Autosurfacer 2+1 HS be applied. Recommended is the use of Polysurfacer.
- Autosurfacer 2+1 HS can be applied over one coat of these primers without sanding, after the stated flash off.



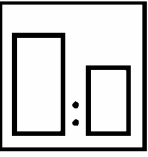
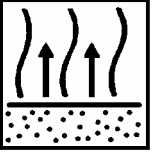



Washprimer EM CF after 30 minutes at 70°F (20°C).

Washprimer CR after 15 minutes at 70°F (20°C)

NOTE: Although Autosurfacer 2+1 HS will provide adequate adhesion and protection when applied directly over bare steel, for larger areas or new vehicles including zinc coating, stainless steel and aluminum, Autosurfacer 2+1 HS must always be applied over a Washprimer.

AUTOSURFACER 2+1 HS

APPLICATION:

- | | | | | | |
|----|--|---|----|--|--|
| 1. |  | Contains acrylic resins and other ingredients. When mixed, also contains isocyanates. | 5. |  | 1-3x1
HVLP Siphon
0.071"-0.087" (1.8-2.2 mm)
HVLP Gravity
0.075"-0.087" (1.9-2.2 mm)
Max 10 psi (max 0.8 bar) |
| 2. |  | 2:1 (100:50)
Autosurfacer 2+1HS
Autosurfacer 2+1HS
Hardener | 6. |  | 5-10 minutes at 70°F (20°C) |
| 3. |  | Use The Sikkens Measuring Stick #1 (Black). | 7. |  | 3 hours at 70°F (20°C)
30 minutes at 140°F (60°C) |
| 4. |  | Stir thoroughly | | | |

MIXING RATIO: 2 parts by volume of Autosurfacer 2+1 HS
1 part by volume of Autosurfacer 2+1 HS Hardener
For easy and accurate mixing, use the first two columns with the Sikkens measuring stick # 1 (Black)

FLEXIBLE PARTS: To 3 parts of Autosurfacer 2+1 HS, add 1 part of Autocryl Elast-O-Actif. For easy and accurate mixing, use the first two columns with the Sikkens measuring stick # 9 (Grey)

Stir this mixture and then add the appropriate hardener at a 2:1 ratio.

NOTE: Do not use Autocryl Accelerator 889 in Autosurfacer 2+1 HS.

**SPRAYING
VISCOSITY:**

15-19 sec. ZAHN cup #2 (15-16 sec. DIN cup #4) at 70°F (20°C).

POT LIFE:

1-1/2 hours at 70°F (20°C)
1 hour at 80°F (27°C)

**APPLICATION
METHOD:**

Spray one, two or three single wet coats, allowing for a flash-off time of 5-10 minutes between coats (depending on temperature and film thickness applied).



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DRYING TIME:

Dry to Sand

	70°F (20°C)	140°F (60°C)
Three coats	3 hours	30 minutes

NOTE:

When using short-wave infrared for drying, the best method is to allow 5 minutes flash after the last coat. Then apply the infrared, 5 minutes at half power and then 8 to 12 minutes at full power, depending on film thickness and lamp type.

**SPRAY GUN
& PRESSURE :**

	Fluid Tip	Spraying Pressure	Fluid Pressure
Siphon Feed	0.071"-0.078" (1.8-2.0 mm)	40-50 psi (3-4 bar)	
Gravity Feed	0.071"-0.078" (1.8 - 2.0mm)	40-50 psi (3-4 bar)	
Pressure Feed	0.039"-0.047" (1.0-1.2 mm)	40-50 psi (3-4 bar)	8-10 psi (0.6-0.8 bar)
HVLP Siphon	0.071"-0.087" (1.8-2.2 mm)	max. 10 psi (max. 0.8 bar)	
HVLP Gravity	0.075"-0.087" (1.9-2.2 mm)	max. 10 psi (max. 0.8 bar)	

**FILM
THICKNESS:**

2.2-2.5 mils per single wet coat.

SANDING:

Dry sand: Pre-sand with #P320 grit paper dry, final sand with #P500 to #P600 grit dry.
Wet sand: Pre-sand with #P500 grit paper wet, final sand with #P600 to #P800 grit wet.

RECOATABILITY:

After sanding and cleaning, Autosurfacer 2+1 HS can be coated with Colorbuild Sealer, Autobase® Plus, Autobase Plus Single Stage Urethane and Autocryl®.

COVER RATE:

Approximately 75 sq. ft./liter of unmixed paint per single coat at 2.5 mils.

**CLEANING OF
EQUIPMENT:**

Clean equipment with Sikkens Cleaning Solvent or lacquer thinner.



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STOCK KEEPING:

COLOR: Grey

**CONTAINER
SIZE:**

Autosurfacer 2+1 HS: 1 gallon (3.785 lt)
Autosurfacer 2+1 HS Hardener: 1 gallon (3.785 lt)
1 quart (0.95 lt)

SHELF LIFE: Autosurfacer 2+1 HS: Two years at 70°F (20°C) if stored unopened.
Autosurfacer 2+1 HS Hardener: One year at 70°F (20°C) if stored unopened.

SAFETY ASPECTS:

**READY TO
SPRAY VOC:**

Mixing Ratio:
2:1 4.3 lb/gal 490 g/liter

NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.