



Technical Data Sheet

Date of issue	Revision Date	Version
03/12/06	11/06/19	2.6
Product Code	Product Name	
HSP_-	HS Primer Grey	
	HS Primer White/Tintable	

'HS' Primer™ (filler/surfacer) is an Ultra High Build 2K primer-filler which can be thinned (reduced) and then be used as a low build primer surfacer. 'HS' Primer™ is an easy to use primer that offers excellent adhesion, very high build, corrosion resistance, has excellent flow and leveling properties is quick drying and very easy to sand, wet or dry! 'HS' Primer™ is a versatile High-Solid primer that is designed to be used on a large variety of surfaces including plastics, ferrous and non-ferrous metals, timber, craft wood and fibreglass, in fact it can be used on almost any surface and dries to a matte finish. 'HS' Primer™ (filler/surfacer) is able to be used for spot, panel and overall applications for motor vehicle repairs, custom painting, cabinet making, industrial and commercial applications.

'HS' Primer™ White (filler/surfacer) is a fully tintable white primer system specifically created for today's increasing range of custom basecoat colours and effects. The correct ground or basecoat colour is critical for both coverage and for achieving many of today's unique colours and effects.

'HS' Primer *Always check that you have the latest TDS*



SURFACE PREP

Surface must be clean & dry



TINTING RATIO

White Primer only
Up to 10% with primer tinter



MIXING RATIO

4:1 Primer Filler
4:1:1 Primer Surfacer



CONVENTIONAL - GUN SET UP

1.7~2.2 Fluid tip
15~20 cm Spray distance
40~60 psi Air pressure
15~25 cm Fan size



HVLP - GUN SET UP

1.5~1.8 Fluid tip
10~15 cm Spray distance
20~30psi at the cap
15~25 cm Fan size



NUMBER OF COATS

1~4 coats



CURE TIMES @ 25°C

High Build Primer
Overnight >8 hours

Surface Primer

Air dry 15~20mins then bake:
30min @ 60°C



THEORETICAL COVERAGE

6~8 m² per litre



FLASH TIME @ 25°C

5~10 min between coats
Medium Hardener
10~15 min between coats Slow
Hardener



SPRAYING VISCOSITY

Ford 4 Cup:45~47 sec.
@ 25°C



SAFETY

Always wear appropriate safety
clothing, gloves, breathing &
apparatus



MSDS

Observe all safety precautions in
relation to this products Material
Safety Data Sheet



CLEAN UP

Clean equipment with Gun
Wash, Reducer or Thinners



POT LIFE

Up to 1.5 Hours @ 20°C

STORAGE

1 Year in cool, dry conditions

QUICK APPLICATION GUIDE:

1. Prepare your base as you would most other substrates.
2. Apply 1 to 3 coats.
3. Allow to flash off properly between coats.
4. Allow to fully cure.

DETAILED APPLICATION GUIDE:**CLEANING**

Use DNA™ Prep Clean 'X'™ to ensure surface is completely free of all contaminants. For substrates other than un-primed plastic or fiberglass; wipe surface using DNA™ Wax & Grease Remover.

SUBSTRATE

For un-primed plastic or fiberglass; clean surface thoroughly and apply **DNA™ Plastic Primer** / adhesion promoter (refer to relevant TDS). Lightly sand difficult substrates as required to assist with adhesion.

*All bare metal, galvanized, plated steel or fiberglass areas must be coated with a DNA™ Etch Primer or Epoxy Primer.

PREPARATION

Clean all areas with Prep Clean 'X'
Final wipe with suitable tack cloth.

MIXING

Tinting ~ White Primer Only
White primer can be used without tinting
Tint before adding hardener
Tint up to 10% with primer tinter



High Build Primer Filler 4:1
4 Part HS Primer
1 Part HS Primer Hardener



Surface Primer 4:1:1
4 Part HS Primer
1 Part HS Primer Hardener
1 Part HS Primer Reducer

Note: Use of reducers will contribute to longer drying and sanding times, slow reducer should only be used when spraying large areas or in hot conditions.

SPRAYING

Strain mixed primer into paint gun.
High Build Primer Filler
Apply up to 4 medium coats with 50% spray overlap. Allow flash time between each coat.

Spraying cont.

Surface Primer

Apply up to 3 light coats with 50% spray overlap. Allow flash time between each coat.

**OFF @ 25°C****High Build Primer Filler**

5-10 mins Medium Hardener
10-15 min Slow Hardener
Between each coat

Surface Primer

5-10 mins Medium Hardener
10-15 min Slow Hardener
Between each coat
20~30mins if baking.

CURING TIME @ 25°C**High Build Primer Filler**

Air dry: 12 hours.
Baking: Air dry for 15-20 mins then bake @ 60°C Metal temp for 40 mins.

Surface Primer

Air dry: 8 hours.
Baking: Air dry for 15~20mins, then bake @ 60°C for 30mins.

Caution: Do not use this product if humidity is 80% or above and ALWAYS ensure 'HS' Primer™ is fully cured and dry before over-coating.

SANDING**High Build Primer Filler**

May be orbital sanded using P240-P600 (dry) wet sanding must be undertaken with care, use P320~800 paper.

Surface Primer

May be orbital sanded using P400~P600 dry or P600~P800 wet.

OVER-COATING

Refer relevant products TDS for full Technical Data Specifications.



Ensure all moisture is removed before applying your finishing coats as any water trapped may lead to a loss of gloss & de-lamination.

Apply your chosen DNA™ special effect coating, basecoat or 2K clear coat.

Important Information:

- Always check you have the latest Technical Data Sheet
- Always buy enough product to complete the entire job
- Products are for Professional Use Only

Warranty:

DNA will replace any faulty or defective goods.

You must always spray out a test panel and **fully test prior to commencing any job** to determine suitability, final finish and overall appearance. Goods are guaranteed for 12 months if stored in cool dry conditions. All information and data provided is given in good faith and intended as a **general guide only** for use by qualified professional painters and DNA will not accept liability as a result of any failure or lack of expertise on the part of the applicator, condition of substrates, lack of preparation, use of incompatible materials, equipment failure, use of incorrect equipment or any other reason beyond the control of DNA and further offers no warranties of whatever nature express or implied as to merchantability or fitness for a particular use or purpose and shall not accept liability for any specific or consequential damage as a result of using these products unless otherwise agreed to in writing. DNA paints reserves the right to make changes to formulations and on rare occasions batches may have slight variations such as colour or tone, these are not covered by warranty.

If any goods are defective, you must not proceed to the job. Stop work immediately and contact your distributor or DNA Paints and point out the defect.

Any faulty goods must be returned at the customers expense to the distributor or DNA paints with a copy of the original invoice or other proof of purchase to obtain a replacement of the faulty product or a refund for the cost of the goods. The benefits provided to the consumer by the warranty are in addition to other rights and remedies available to the consumer under the law.

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