

















## Technical Data Sheet

Date of issue	Revision Date	Version
03/12/06	01/02/13	2.4
Product Code	Product Name	
<b>HSP_-</b>	<b>HS Primer Grey</b>	
	<b>HS Primer White/Tintable</b>	

'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

	<b>SURFACE PREP</b> Surface must be clean & dry		<b>TINTING RATIO</b> White Primer only Up to 10% with primer tinter		<b>MIXING RATIO</b> 4:1 Primer Filler 4:1:1 Primer Surfacer
	<b>CONVENTIONAL - GUN SET UP</b> 1.7~2.2 Fluid tip 15~20 cm Spray distance 40~60 psi Air pressure 15~25 cm Fan size		<b>HVLP - GUN SET UP</b> 1.5~1.8 Fluid tip 10~15 cm Spray distance 20~30psi at the cap 15~25 cm Fan size		<b>NUMBER OF COATS</b> 1~4 coats
	<b>CURE TIMES @ 25°C</b> <b>High Build Primer</b> Overnight >8 hours <b>Surface Primer</b> Air dry 15~20mins then bake: 30min @ 60°C		<b>THEORETICAL COVERAGE</b> 6~8 m <sup>2</sup> per litre		<b>FLASH TIME @ 25°C</b> 5~10 min between coats Medium Hardener 10~15 min between coats Slow Hardener
	<b>SPRAYING VISCOSITY</b> Ford 4 Cup:45~47 sec. @ 25°C		<b>SAFETY</b> Always wear appropriate safety clothing, gloves, breathing & apparatus		<b>MSDS</b> Observe all safety precautions in relation to this products Material Safety Data Sheet
	<b>CLEAN UP</b> Clean equipment with Gun Wash, Reducer or Thinners		<b>POT LIFE</b> Up to 1.5 Hours @ 20°C		<b>STORAGE</b> 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.

**FLASH 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.

For further information refer to the DNA® Training Manual, or contact your DNA® Distributor for Technical Support.

**Note:** Custom painting can be difficult. All products should be fully tested prior to commencing any job to determine suitability, final finish and overall appearance. All information and data provided by DNA® is given in good faith and intended to be a general guide only. DNA® shall not accept liability as a result of any failure or lack of expertise on the part of the applicator, condition of substrates, lack of, or incorrect preparation, use of incompatible materials, equipment failure or 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. Should a product be defective, DNA® shall replace the defective product, or, at its sole discretion refund the purchase price.

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