

**TECHNICAL DATA SHEET***Revision date: 20.03.2024***2K HS FILLING PRIMER 5:1**

Article number: 14881, 14882, 14883, 14884, 14885,
14886, 14887, 14888, 14889, 148880,
148890

Colour: black, white, grey, red

Intended use: Car refinishing product/ Filler

General characteristics: 2K HS Filling primer 5:1 is an easy to sand filler with high corrosion resistance, excellent filling capacity and good adhesion to various surfaces for automotive refinishing. Can be used to fill out patches (spot repair) without sagging or edges.
Mixing white, black and grey colours allows to create any shade of grey.

PAINTING PREPARATION PROCESS

Hardener: Chamäleon 288 Hardener for 488/444/467 primer

Mixing ratio (by volume): 5:1

Mixing ratio (by weight):

Primer, g	Hardener, g	Max. density, 20%	Thinner, g	
			Filler, 30%	Wet-on-wet, 50% (non-EU)
153	19	18	26	44
305	39	35	53	88
458	58	53	79	132
610	78	71	106	177
763	97	88	132	221
916	117	106	159	265
1068	136	124	185	309
1221	156	141	212	353
1373	175	159	238	397

1526	195	177	265	442
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Dilution: Chamäleon Thinner 322/323 20 - 30 % as sanding filler; 30 - 40 % (EU VOC)/ 50% (non-EU) as wet-on-wet filler

Spraying viscosity 4 mm DIN (20°C): 30 - 55 s

Pot life at 20 °C: 1 - 3 h

Substrate pre-treatment:

The substrate must be clean, dry, free from rust and grease. Remove old coatings or primers that have not cured or are not sound

Old paint coating	Degrease, dry sand with P220-280, blow off, degrease again
Polyester putties	Dry sand, use P240-320 for final sanding, blow off, degrease
Epoxy primer	Dry sand, use P240-320 for final sanding, blow off, degrease
Wash primer	Apply after drying
Plastics	Degrease, mat with an abrasive finishing pad, degrease again
Steel	Dry sand, use P240-320 for final sanding, blow off, degrease

APPLICATION PROCESS

Processing conditions:

Please only use in an adequate ventilated environment with an ample supply of fresh air. Processing temperature should be at least +12 °C and max. air humidity should not exceed 80%.

Application method	Pressure	Nozzle
Gravity spray gun	2.0 - 2.5 bar	1.5 - 1.9 mm
HVLP	2.0 - 2.5 bar	1.5 - 1.9 mm

Spraying operations	DFT	Consumption
1 - 3	60 - 180 µm	5 - 6 m ² /l

Flash-off time	Between the coatings	Before the oven drying
	5 - 8 min	10 - 15 min

Drying	Sandable
Object temperature 20 °C	3 - 5 h
Object temperature 60 °C	30 - 40 min
IR-Drying shortwave*	8 min
IR-Drying mediumwave*	10 - 15 min

*The temperature of the object should not exceed 60 - 70 °C.

Sanding:

Sand with sandpaper P400 for dry- or P600 for wet sanding for one-coat finishes, for two-coat finishes use P500 for dry- and P800 is recommended for wet sanding

Related Chamäleon products:

Hardener	288 Hardener for 488/444/467 primer
Thinner	322 UNI thinner/323 UNI thinner slow
Elastifier	360 Elastifier
Anti silicone additive	361 Anti silicone additive

Mixing ratios by volume of product

	SV1	SV2	SV3	SV4	SV5	SV6
488 WHITE	100	50		75		
488 GREY		50	100		50	
488 BLACK				25	50	100

VOC regulation:

EU limit value: Category B/c 540 g/l

This product contains max. 540 g/l VOC

Shelf life:

36 months, if stored in tightly closed original containers

This release replaces all eventually earlier issued versions.

For additional information, not contained in this Technical Data Sheet, please contact the supplier via:
info@chamaeleon-produktion.de

For safety information, please refer to the corresponding Safety Data Sheet.