



TECHNICAL DATA SHEET

AUTOMEL 640 (2K Urethane Primer Surfacer)

Description

Automel 640 is a quick drying high build urethane 2 Pack Primer Surfacer is designed to give excellent benefits such as Adhesion, Levelling, Colour/Gloss Holdout, Easy to Sand and Fill Scratch Marks.

Compatible Substrates

Properly prepared steel and alumina substrate
properly applied Edgechem under coats
Putties and body fillers
Wash primers and Edgechem filler

Preparation

Existing finishes -degrease, dry sand P220-p320
Polyester Filler - degrease, dry sand with P220-P320
Steel surfaces - degrease, dry sand with P220
Aluminium surfaces - degrease, apply etching primer

Application

2-3 Wet coats, allowing 10 minutes flash time
HVLP 7-8 Psi at air cap
Conventional 30-35 psi at s/gun
Spray gun set up fluid tip 1.5 – 2.0 mm

Mixing

640	640	URETHANE
SURFACER	HARDENER	REDUCER
4	1	1

Pot life - 2 hours @ 27°C

Dry Times

Dust free	-	5-10 minutes @27°C
Flash time	10 minutes @27°C	
Dry to Handle	1 hour @ 27°C	
Dry to sand	2 – 3 hours @ 27°C	

Clean Up

Clean spray gun, mixing cup etc., thoroughly with Edgechem Lacquer Thinner, Edgechem Urethane Reducer or any other appropriate clean up solvent after each use.

Please follow relevant agency guidelines for proper storage and disposal of solvent-borne paint. See MSDS for this product for further instructions.

Properties

VOC	293 g/l OR 2.44 lbs/gal
Shelf life	2 years
Viscosity	CP : 1000-1300
Coverage per coat	20 m²/l
Colour	Yellowish Grey
Flash point	35°C
Density	11.5 – 12.5 lb/gal

Limitations:

Edgechem products should not be combined with components of other product lines.

Precautionary Information:

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have hazards of all its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Medical Response:

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (876)937-3831-4

Material Safety Data Sheet:

Material safety data sheet for the Edgechem products named herein can be obtained from Edgechem Jamaica Limited by emailing researchanddev@edgechem.com