

# DULUX<sup>®</sup> AUTOSPEED<sup>®</sup>

## 488 89287 2K HS PRIMER FILLER



Dulux Australia  
ABN 67 000 049 427

488 89287 Dulux AUTOSPEED<sup>®</sup> 2K HS Primer

### Product Name:

488-89287 Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K HS Primer

### Product Description:

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K HS Primer is a premium quality two pack High Solids polyurethane primer that can be used as a filler or surfacer in auto refinishing. It provides excellent build and excellent hold out.

### Substrates

Suitably prepared:

- Existing finishes
- Polyester Filler
- Bare steel surfaces
- OEM Primer
- Fibreglass

### Product & Additives:

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K HS Primer 488-89287

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K 4:1 Hardener- Normal 980-89291

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> RP 4:1 Hardener- Fast 980-89794 Cold Temperatures/ Rapid Production

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Thinner- Normal 920-89292

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> RP Thinner - Fast 920-89819 Cold Temperatures/ Rapid Production








	<b>Mixing Ratio</b>	4 Part 488-89287
	<b>Hardener</b>	1 Part 980-89291 Large Areas or 1 Part 980- 89794 Small Areas
	<b>Thinner</b>	Filler 5-10% 920-89292 or 920-89819 2 to 3 coats Max Surfacer 15-20% 920-89292 or 920-89819 2 to 3 coats Max
	<b>Spray Viscosity</b> DIN Cup 4 @ 25°C	22 - 24 seconds
	<b>Gravity Feed</b>	<b>Fluid Tip:</b> CONVENTIONAL: 1.5 - 1.8mm HVLP: 1.5 - 1.9mm <b>Spraying Pressure:</b> 340 kPa. 70 kPa. Or refer to manufacturer's recommendations
	<b>Suction Feed</b>	CONVENTIONAL: 1.7 - 2.0mm HVLP Gravity Feed: 1.8 - 2.2mm 340 kPa. 70 kPa. Or refer to manufacturer's recommendations
	<b>Air Flash</b>	5 - 10 minutes air flash between coats

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	<b>Baking/Drying</b>	3 hours @ 20°C 30 mins @ 60°C
	<b>Infrared</b>	<b>Short wave:</b> 8 mins <b>Medium wave:</b> 10 - 15 mins
	<b>Sanding - Manual</b>	<b>Wet:</b> P600 - P800 Grit
	<b>Sanding - Manual</b>	<b>Dry:</b> P400 - P600 Grit
	<b>Sanding - Mechanical</b>	<b>Dry:</b> P400 - P600 Grit
	<b>Spraying</b>	Use air fed mask at all times. Refer applicable AS/NZS Standards
	<b>Pot Life</b>	When mixed, 45 minutes @ 20°C
	<b>Application</b>	Filler 2 to 3 coats Surfacer 2 coats

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### Weight Mixing Ratios for 488-89287 Autospeed 2K Primer and Flex 485-89930

#### **a. Using the Intelligent balance and adding by percentage addition**

**Note:** This order of addition must be maintained when using the intelligent balance. The RFU volume is approx 50% larger than the initial volume of primer.

488-89287 Autospeed primer	100
485-89930 Flex Additive	7.3%
980-89291 2K Primer Hardener	23.8%
920-89292 2K Thinner	5.4%

The quantity of thinner added can be varied to suit your spraying conditions. See notes below regarding alternate thinners and hardener.

#### **b. Using an ordinary balance and adding by grams.**

Volume of RFU Primer (ml)	488-89287 Primer (g)	485-89930 Flex (g)	980-89291 Hardener* (g)	920-89292 Thinner ** (g)
50	47.89	3.50	12.22	3.34
100	95.78	7.0	24.43	6.79
150	143.7	10.5	36.65	10.18
200	191.6	14.0	48.86	13.58
250	239.5	17.5	61.07	16.98
300	287.3	21.0	73.29	20.37
350	335.2	24.5	85.50	23.77
400	383.1	28.0	97.72	27.16
450	431.0	31.5	109.9	30.56
500	478.9	35.0	122.15	33.95
550	526.8	38.5	134.4	37.35
600	574.7	42.0	146.6	40.74
650	622.6	45.5	158.8	44.14
700	670.5	49.0	171.0	47.53
750	718.4	52.5	183.2	50.93
800	766.2	56.0	195.4	54.32
850	814.1	59.5	207.7	57.72
900	862.0	63.0	219.9	61.11
950	909.9	66.5	232.1	64.50
1000 (1L)	957.8	70	244.3	67.9

\* Use 980-89294 Autospeed RP 2K Primer Hardener for improved production times

\*\* Use 920-89819 Autospeed RP Thinner in cold weather or 920-89847 Autospeed Hot Weather Thinner as required.

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### Weight Mixing Ratios for 488-89287 Autospeed 2K Primer

#### **b. Using the Intelligent balance and adding by percentage addition**

**Note:** This order of addition must be maintained when using the intelligent balance. The RFU volume is approx 50% larger than the initial volume of primer.

488-89287 Autospeed primer	100
980-89291 2K Primer Hardener	15.8%
920-89292 2K Thinner	15.8-31.5%

The quantity of thinner added can be varied to suit your spraying conditions. See notes below regarding alternate thinners and hardener.

#### **c. Using an ordinary balance and adding by grams 10% Thinner.**

Volume of RFU Primer (ml)	488-89287 Primer (g)	980-89291 Hardener* (g)	920-89292 Thinner ** (g)
50	57.70	9.10	3.32
100	115.41	18.20	6.64
150	173.11	27.31	9.97
200	230.82	36.41	13.29
250	288.52	45.52	16.62
300	346.23	54.62	19.94
350	403.93	63.73	23.27
400	461.64	72.83	26.59
450	519.34	81.94	29.92
500	577.05	91.04	33.24
550	634.75	100.15	36.57
600	692.46	109.25	39.89
650	750.16	118.36	43.22
700	807.87	127.46	46.54
750	865.57	136.57	49.87
800	923.28	145.67	53.19
850	980.98	154.78	56.52
900	1038.69	163.88	59.84
950	1096.39	172.99	63.17
1000 (1L)	1154.10	182.09	66.49

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**d. Using an ordinary balance and adding by grams 20% Thinner.**

<b>Volume of RFU Primer (ml)</b>	<b>488-89287 Primer (g)</b>	<b>980-89291 Hardener* (g)</b>	<b>920-89292 Thinner ** (g)</b>
<b>50</b>	53.72	8.47	6.19
<b>100</b>	107.43	16.95	12.38
<b>150</b>	161.15	25.42	18.57
<b>200</b>	214.87	33.90	24.76
<b>250</b>	268.59	42.38	30.95
<b>300</b>	322.30	50.85	37.14
<b>350</b>	376.02	59.33	43.33
<b>400</b>	429.74	67.80	49.52
<b>450</b>	483.45	76.28	55.71
<b>500</b>	537.17	84.76	61.90
<b>550</b>	590.89	93.23	68.09
<b>600</b>	644.60	101.71	74.28
<b>650</b>	698.32	110.18	80.47
<b>700</b>	752.04	118.66	86.66
<b>750</b>	805.76	127.14	92.85
<b>800</b>	859.47	135.61	99.04
<b>850</b>	913.19	144.09	105.23
<b>900</b>	966.91	152.56	111.42
<b>950</b>	1020.62	161.04	117.61
<b>1000 (1L)</b>	1074.34	169.52	123.80

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## For Safe Handling:

Please refer to the Material Safety Data Sheet number: 462 for this product before use.

**In the event of an emergency contact: 1 800 033 111 (ALL HOURS), NZ 0800 734 607**

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