

DULUX[®] AUTOSPEED[®]

488 89907 MIRACLE HB PRIMER



Dulux Australia
ABN 67 000 049 427

488 89907 Dulux AutoSpeed[®] Miracle HB Primer

Product Name:

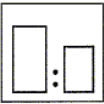





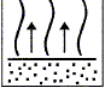
488-89907 Dulux[®] AutoSpeed[®] Miracle HB Primer

Product Description:

Dulux[®] Autospeed[®] Miracle HB Primer is a premium quality two pack High Solids polyurethane primer that can be used as a surfacer in auto refinishing. It has excellent sanding properties and is an ideal primer for 2K colour and base coats.

Product & Additives:

- Dulux[®] AutoSpeed[®] Miracle HB Primer 488-89907
- Dulux[®] AutoSpeed[®] HB 5:1 Multi Hardener 980-89906
- Dulux[®] AutoSpeed[®] Standard Thinner 920-89909
- Dulux[®] AutoSpeed[®] Low Temp Thinner 920-89908 (Small areas & Colder Temperatures)
- Dulux[®] AutoSpeed[®] High Temp Thinner 920-89910 (High Temperatures)
- Dulux[®] AutoSpeed[®] 2K Thinner-XSlow 920-89963
- Dulux[®] AutoSpeed[®] 2K Thinner-Slow 920-89847
- Dulux[®] AutoSpeed[®] 2K Thinner-Normal 920-89292
- Dulux[®] AutoSpeed[®] RP Thinner Fast 920-89819
- Dulux[®] AutoSpeed[®] 2K Hardener Slow 980-S0028
- Dulux[®] AutoSpeed[®] 2K Hardener Normal 980-89290

	Mixing Ratio	5 Parts 488-89907 on weight
	Hardener	1 Part 980-89906 on weight
	Thinner	Surfacer 20-30% Dulux [®] AutoSpeed [®] 2K Thinner-Normal 920-89292 2 to 3 coats Max Filler 10% Dulux [®] AutoSpeed [®] 2K Thinner-Normal 920-89292 , 2-4 coats
	Spray Viscosity DIN Cup 4 @ 25°C	22 - 24 seconds
	Gravity Feed	Fluid Tip: CONVENTIONAL: 1.5 - 1.8mm HVLP: 1.5 - 1.9mm Spraying Pressure: 340 kPa. 70 kPa. Or refer to manufacturer's recommendations
	Suction Feed	CONVENTIONAL: 1.7 - 2.0mm HVLP Gravity Feed: 1.8 - 2.2mm 340 kPa. 70 kPa. Or refer to manufacturer's recommendations
	Air Flash	3-5 minutes air flash between coats








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	Baking/Drying	3 hours @ 20°C 20 mins @ 60°C
	Infrared	Short wave: 8 mins Medium wave: 10 - 15 mins
	Sanding - Manual	Wet: P400 - P800 Grit
	Sanding - Manual	Dry: P400 - P600 Grit
	Sanding - Mechanical	Dry: P400 - P600 Grit
	Spraying	Use air fed mask at all times. Refer applicable AS/NZS Standards
	Substrates	Suitably prepared: <ul style="list-style-type: none"> • Existing finishes • Polyester Filler • Bare steel surfaces • OEM Primer • Gel Coated Fibreglass
	Pot Life	When mixed, 60 minutes @ 20°C
	Application	Surfacer 2 coats Filler 2-4 coats

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Weight Mixing Ratios for 488-89907 Miracle HB Primer and Flex 485-89930

- a. Using the Intelligent balance and adding by percentage addition**
- b. Before applying Miracle HB Primer, a coat of Dulux Plastic Primer (485-89943) must be applied to the surface first. Refer to the Application Guide for painting plastic bumper bars for more detail.**

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.

488-89907 Miracle HB primer	100
485-89930 Flex Additive	20
980-89906 Miracle Hardener	30
920-89909 PT Std. Thinner	20 (on total weight)

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

c. Using an ordinary balance and adding by grams.

Volume of RFU Primer (ml)	488-89907 Primer (g)	485-89930 Flex (g)	980-89906 Hardener (g)	920-89909 Thinner * (g)
50	31.25	6.25	9.45	11.7
100	62.5	12.5	18.8	23.4
150	93.75	18.75	28.15	35.1
200	125	25	37.5	46.8
250	156.25	31.25	46.85	58.5
300	187.5	37.5	56.2	70.2
350	218.75	43.75	65.55	81.9
400	250	50	74.9	93.6
450	281.25	56.25	84.25	105.3
500	312.5	62.5	93.6	117
550	343.75	68.75	102.95	128.7
600	375	75	112.3	140.4
650	406.25	81.25	121.65	152.1
700	437.5	87.5	131	163.8
750	468.75	93.75	140.35	175.5
800	500	100	149.7	187.2
850	531.25	106.25	159.05	198.9
900	562.5	112.5	168.4	210.6
950	593.75	118.75	177.75	222.3
1000 (1L)	625	125	187.1	234

* Use 920-89908 AutoSpeed PT Low Temp Thinner in cold weather or 920-89910 AutoSpeed PT High Temp Thinner as required.

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For Safe Handling:

Please refer to the Material Safety Data Sheet number: 1466 for this product before use.

In the event of an emergency contact: 1 800 033 111 (ALL HOURS)

For further information contact:

Dulux Australia
1956 Dandenong Rd, Clayton,
Victoria, 3168

Australia

ABN 67 000 049 427

Telephone:
1 800 810 114

Fax:
61 3 8787 4502

Dulux New Zealand
31B Hillside Road

Glenfield, Auckland
New Zealand

Telephone:
0800 800 424

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