

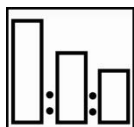
Multi Use Filler Xcel

FOR PROFESSIONAL USE ONLY

Description

Sikkens Multi Use Filler Xcel is a two component primer for general use in Automotive refinishing cars. By using a different mixing ratio, Sikkens Multi Use Filler Xcel can be used as Sanding as well as Non sanding versions. And also, to achieve colors closely resembling to the most popular basecoat colors i.e. different shades of primer can be arrived by mixing Sikkens Primer with Sikkens Topcoats.

Sanding application



100 Multi Use Filler Xcel
 25 P25 / P35 /Xcel Hardeners
 25 Plus Reducers



Use Sikkens measuring stick

5 Orange

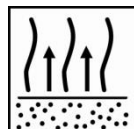


Spray gun set-up:
 1.8-2.0mm

Application pressure:
 2.0-2.5 bar at the air inlet
 HVLP max 0.6-0.7 bar at the air cap



2-3 x 1 coat



Between coats:
 5-10 minutes at 20°C

Before curing:
 5-10 minutes at 20°C



3-3.5 hours at 30°C with P25/P35
 1.5 hours at 30°C with Xcel Hardener
 2-3 coat application

30 minutes at 60°C



Final sanding step: P500



Recoatable with all Sikkens topcoats

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Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

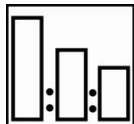
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Description

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Wet-on-wet (non sanding) application



100 Multi Use Filler Xcel
 50 P25 / P35 Hardeners
 30 Plus Reducers



Use Sikkens measuring stick

1 Black

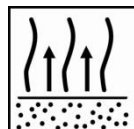


Spray gun set-up:
 1.3-1.4mm

Application pressure:
 1.7-2.2 bar at the air inlet
 HVLP max 0.6-0.7 bar at the air cap



1 coat



Flash off time:
 15 minutes at 20°C
 prior to topcoat application.

Recoat within:
 24 hours at 20-30°C



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Suitable substrates

Existing finishes	OEM electro coat (sanded)
Steel	Polyester bodyfiller
Galvanized steel	Aluminium
Original finishes, including thermoplastic acrylics	Glass Reinforced Polyester laminates (GPR)

Multi Use Filler Xcel will provide adequate adhesion if applied directly to steel.

Allow for a minimum of 15 minutes flash-off time at 20°C after Washprimer application.

However, we advise using Sikkens Washprimer 1K CF in the following case(s):

- a. When the system is required to meet high corrosion protection standards.
- b. Repairs that requires an extensive metal priming such as complete panel.

Product and additives

Multi Use Filler Xcel

Hardeners P25 , P35 and Xcel

Plus Reducers Plus Reducer Extra Fast; to use in extremely cold temperatures, temperature range: 10°C-15°C.
 Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.
 Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 20°C-30°C.
 Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 25°C-35°C.
 Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 35°C.

Basic raw materials

Multi Use Filler Xcel: Acrylic polyol resins
 P Hardeners and Xcel hardener: Polyisocyanates
 Plus Reducers: Mixture of solvents

Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner.



Sanding; final dry sanding steps; P220 - P320
 Rigid OEM electro coated parts; final dry sanding steps; P220 - P320
 Sikkens polyester bodyfillers and Polysurfacers; finished with; P120 - P220
 Featheredge sanding for spot repair, finish outer area with P400
 For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Multi Use Filler Xcel using appropriate surface cleaner. Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

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Stir before use



Stir Multi Use Filler Xcel thoroughly before mixing.

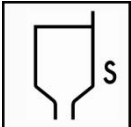
Tinting

If necessary, Multi Use Filler Xcel can be tinted with up to 10 parts by volume with either; Autocryl Plus MM toners.

Multi Use Filler Xcel mixtures with either a topcoat MM color or grey combination must be stirred thoroughly before adding Hardener.

Stir thoroughly once more before adding additional reducer (if required).

Viscosity



Sanding
 18-24 seconds Din-cup 4 at 20°C.

Non Sanding (wet-on-wet)
 14-16 seconds Din-cup 4 at 20°C.

Spray gun set-up / application pressure



Spray gun

Gravity feed

Gravity feed

Fluid tip-set-up

Sanding
 1.8-2.0 mm

Wet on wet
 1.3-1.5 mm

Application pressure

2.0-2.5 bar at the spray gun air inlet
 HVLP max 0.6-0.7 bar at the air cap

1.7-2.2 bar at the spray gun air inlet
 HVLP max 0.6-0.7 bar at the air cap

For maximum build use a larger fluid tip and lower the application pressure.

Pot-life

Sanding version: 45 min to 1 hour at 20°C

Nonsanding version: 1 hour at 20°C

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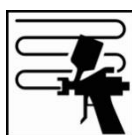
Application

Sanding

Apply one coat over the total sanded area. Next apply the 2nd and 3rd coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.

Allow each coat to flash-off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry by air support
Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow.

For maximum build use a larger fluid tip and lower the application pressure.



Wet-on-wet (non sanding)

Apply 1 full wet coat over the total area.

Optional application; apply one thin coat, followed by a full wet coat.

Allow each coat to flash-off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry with air support. Flash-off between the coats is dependent on ambient temperature, applied layer thickness.

NOTE: For large areas, or in temperature over 30°C, it is advisable to use P35 to avoid dry overspray.

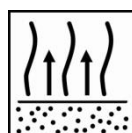
Film thickness

By using the recommended application:

Sanding version, 2-3 coats: 50-60 µm per layer

Wet-on-wet (non sanding version), 1 coat: 25-30 µm per layer

Flash off time wet-on-wet (non sanding/surfacers)



Allow for a minimum flash off time of 15 minutes at 20°C prior to topcoat application.

Apply topcoat within 24 hours at 20-30°C.

Should this maximum time be exceeded, abrade the surface with P500 dry or P1000 wet sanding paper.

Denibbing time wet-on-wet (non sanding/surfacers)

For minor defects (e.g. dust) Multi Use Filler Xcel can be denibbed with either P500 dry or P1000 wet sanding paper. After a drying time of longer than 24 hours thorough sanding is necessary!

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Final sanding



Final sanding step P500
Initial sanding steps may be executed with a coarser sanding grit; P320 - P400
Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
For detailed surface preparation see TDS S8.06.02



Final sanding step P1000
Initial sanding steps may be executed with a coarser sanding grit P600 - P800
Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of the topcoat using an appropriate surface cleaner.

Recoatable with

All Sikkens topcoats

Theoretical coverage

By using the recommended application, the theoretical material usage is:
7 m²/liter per coat at 50 µm and 9 m²/liter per coat at 30 µm.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

Product storage

Product shelf-life is determined when products are stored unopened at 5-35°C.
Avoid extreme temperature fluctuation.
Product shelf life data see TDS S9.01.02

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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