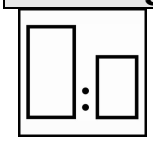
Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Description

High-build, isocyanate free, two-pack sanding primer filler surfacer with extremely fast air and force drying properties. Autosurfacer Rapid has excellent application and sanding properties and provides good enamel hold-out with all Sikkens topcoats.

Sanding application



100 Autosurfacer Rapid

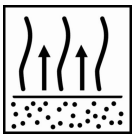
50 Autosurfacer Rapid Hardener

Use Sikkens measuring stick
No. 1 Black

Spray gun set-up:
1.5-1.8 mm

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

2-3 x 1 coat



Between coats:
5-7 minutes at 20°C

Before curing:
5-7 minutes at 20°C

45 minutes at 20°C
3 coat application

20 minutes at 60°C

Final sanding step: P500
See TDS S8.06.01

Recoatable with all Sikkens topcoats

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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Suitable substrates

Existing finishes
Steel
Galvanized steel
Aluminium
Washprimer CF
OEM electro coat (sanded)
Glass Reinforced Polyester laminates (GRP)
Polyester bodyfillers

Autosurfacer Rapid will provide adequate adhesion if applied directly to steel, however, we advise for systems which should meet the highest standards to apply Autosurfacer Rapid over Sikkens Washprimer . Allow for a minimum of 15 minutes flash-off time at 20°C after Washprimer application.

Autosurfacer Rapid can be applied on plastics parts which have been preceded by;
Plastoflex Primer or 2K Plastic Primer.

Product and additives

Autosurfacer Rapid

Hardeners Autosurfacer Rapid Hardener

Additives Autocryl Structure Paste (Fine); additive to create different surface textures; TDS 6.27, 6.29.
Elast-o-Actif; to elasticize Autosurfacer Rapid making it suitable for plastic parts. See S8.06.03

Basic raw materials

Autosurfacer Rapid: Special acrylic resins
Autosurfacer Rapid Hardener: Blocked polyamines of high molecular weight.

Surface preparation

Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.

Sanding; final dry sanding steps; P180 – P280
Rigid OEM electro coated parts; final dry sanding steps; P180 – P280
Sikkens polyester bodyfillers and Polysurfacer; finished with;P180 - P280
Featheredge sanding for spot repair, finish outer area with P320 - P400
For detailed surface preparation see TDS S8.06.02

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

Stir before use

Autosurfacer Rapid

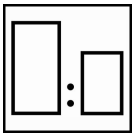
FOR PROFESSIONAL USE ONLY

Stir Autosurfacer Rapid thoroughly before mixing.

Tinting

If necessary, Autosurfacer Rapid can be tinted with up to 10 parts by volume with either;
Autocryl LV 420 or Autocryl Plus LV MM toners.

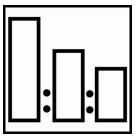
Mixing Autosurfacer Rapid Light / Dark grey
Autosurfacer Rapid Light- and Dark Grey can be mixed in different mixing ratios.
In the next table Quick-Mix grey shades are visible; these Quick-Mix grey shades can easily be mixed by volume with a Sikkens mixing stick or by weight.



Light - Dark		
100 : 0	Light grey	
100 : 10	Medium light grey	
5 : 1	Medium grey	
100 : 50	Medium dark grey	
0 : 100	Dark grey	

Autosurfacer Rapid mixtures with either a topcoat MM colour or grey combination must be stirred thoroughly before adding Autosurfacer Rapid Hardener.
Stir thoroughly once more before adding additional reducer (if required).

Mixing



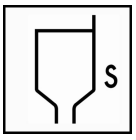
Sanding (rolling):

100	Autosurfacer Rapid
50	Autosurfacer Rapid Hardener

Flexible parts

Once elasticized to the required level, Autosurfacer Rapid can be applied on plastic parts. All flexible plastic parts should be pre-coated with a suitable plastic primer (in the case of virgin plastic), or OEM finish.
See TDS.S8.06.3.

Viscosity



Sanding/Rolling
21-24 seconds Din-cup 4 at 20°.

Spray gun set-up / application pressure

Spray gun	Fluid tip-set-up	Application pressure
	Sanding	
Gravity feed	1.5-2.0 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

	Wet on wet	
Gravity feed	1.2-1.4 mm	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

Autosurfacer Rapid:	30 minutes at 20°C.
Autosurfacer Rapid with Elast-o-Actif:	60 minutes at 20°C.

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.

Rolling
Apply one light 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. Use the edge of the roller to prime awkward areas (door handle). Finally, squeeze remaining paint from roller and smooth off the repair, the rolling should be executed from the outside, in an inward direction. Each additional coat should be started within the preceding coat area.

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.

Drying time sanding

45 minutes at 20°C.	30 minutes at 40°C.	20 minutes at 60°C.

Drying times relate to recommended application (3 coats) and object temperature.

Allow 5 minutes flash off prior to infra red curing
The panel must not reach a temperature above 100°C while curing.
For additional infra red drying information; see TDS S9.01.01

Final sanding

Final sanding step P500
- *Initial sanding steps may be executed with a coarser sanding grit; P360 - P400*
- *Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.*
- *For detailed surface preparation see TDS S8.06.02*

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

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

Sanding in case of roller application
Pre sand by block with a coarser sanding grit; free-cut P360 - P400 In order to remove the coarser surfacer structure due to roller application. Sanding is best executed working from the centre of the repair to the outer edge (inside out).

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

Recoatable with

All Sikkens topcoats

Film thickness

By using the recommended application;

Sanding	Per coat	40 - 60 µm
	3 coats	120 - 180 µm
Rolling application	Per coat	30 - 40 µm
	3 coats	90 -120 µm

Material usage

By using the recommended application, the theoretical material usage is:
- o ± 5 m²/liter RTS mixture for Autosurfacer Rapid sanding.
- o ± 10 m²/liter RTS mixture for Autosurfacer Rapid wet-on-wet/non sanding.

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

VOC

2004/42/IIB(c)(540)540
The EU limit value for this product (product category: IIB. c) in ready to use form is max. 540 g/liter of VOC.
The VOC content of this product in ready to use form is max. 540 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.
- o *Product shelf life data see TDS S9.01.02*

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