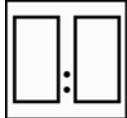


Priming Filler 680 Grey

FOR PROFESSIONAL USE ONLY

Description

Quick drying, universal one-pack primer-surfacer for spot and panel repairs of vehicles.
Suitable for both dry and wet sanding.



100 Priming Filler 680 Grey

100 Thinner X



Use Sikkens measuring stick

No. 1 Black



Spray gun set-up:
1.5-1.8 mm

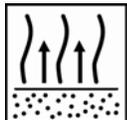
Application pressure:

28-30 psi (1.7-2.2 bar) at the air inlet

HVLP max 8-10 psi (0.6-0.7 bar) at the air cap



2-3 x 1 coat



Between coats:

5-10 minutes at 70°F (20°C)



30 minutes at 70°F (20°C)

15 minutes at 140°F (60°C)

3 coat application



Final sanding step: P500

See TDS S8.06.01



Recoatable with all Sikkens solvent borne 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

Priming Filler 680 Grey

FOR PROFESSIONAL USE ONLY

Description

Quick drying, universal one-pack primer-surfacer for spot and panel repairs of vehicles.
Suitable for both dry and wet sanding.

Suitable substrates

Existing finishes	Polyester bodyfillers
Steel	Kombi Filler
Washprimer EM CF	

Priming Filler 680 Grey will provide adequate adhesion if applied directly to steel, however, we advise for systems which should meet the highest standards to apply Priming Filler 680 Grey over Sikkens Washprimer. Allow for a minimum of 15 minutes flash-off time at 70°F (20°C) after Washprimer application.

Product and additives

Priming Filler 680 Grey

Thinner Thinner X

Basic raw materials

Nitrocellulose combinations

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; P220 - P320
Rigid OEM electro coated parts; final dry sanding steps; P220 - P320
Sikkens polyester bodyfillers and Polysurfacer; finished with; P180 - 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 Priming Filler 680 Grey using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

Stir before use

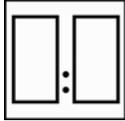


Stir Priming Filler 680 Grey thoroughly before mixing.

Priming Filler 680 Grey

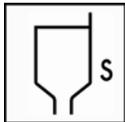
FOR PROFESSIONAL USE ONLY

Mixing



100 Priming Filler 680 Grey
100 Thinner X

Viscosity



18-22 seconds Din-cup 4 at 70°F (20°C).

Pot-life

1 day at 70°F (20°C).

Application

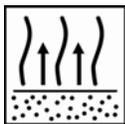


2-3 x 1 coat

Film thickness

By using the recommended application; 1,2-1,6 mils (30-40 µm)

Flash off time



5-10 minutes at 70°F (20°C) between coats.

Drying time



Ready to sand after 30 minutes at 70°F (20°C).
Drying times relate to recommended application (3 coats) and object temperature.

If forced dried, Priming Filler 680 Grey can be sanded after;

- 20 minutes at 100°F (40°C).
- 15 minutes at 140°F (60°C).



Allow 5 minutes flash off prior to infra red curing
The panel must not reach a temperature above 212°F (100°C) while curing.
For additional infra red drying information; see TDS S9.01.01

Priming Filler 680 Grey

FOR PROFESSIONAL USE ONLY

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



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 solvent borne topcoat using an appropriate surface cleaner.

Recoatable with

All Sikkens solvent borne topcoats

Material usage

By using the recommended application, the theoretical material usage is;
± 64 sq. ft./liter 6 m²/liter RTS mixture.

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 70°F (20°C).
Avoid extreme temperature fluctuation.
Product shelf life data see TDS S9.01.02

Priming Filler 680 Grey

FOR PROFESSIONAL USE ONLY

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FOR PROFESSIONAL USE ONLY

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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