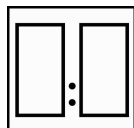


# Priming Filler 680 Grey

FOR PROFESSIONAL USE ONLY

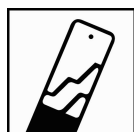
## Description

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



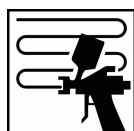
Use Sikkens measuring stick

**1** Black

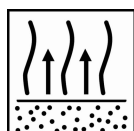


Spray gun set-up:  
1.5-1.8 mm

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

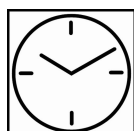


2-3 x 1 coat



Between coats:

5-10 minutes at 20°C



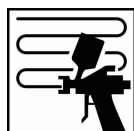
30 minutes at 20°C

15 minutes at 60°C

3 coat application



Final sanding step: P500  
See TDS S8.06.02



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  
Steel  
Washprimer 1K CF

Polyester bodyfillers  
Kombi Filler

*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 20°C after washprimer application.*

## Product and additives

Priming Filler 680 Grey

**Thinner** Thinner X

## Basic raw materials

Nitrocellulose combinations

## Surface preparation



Remove contamination using an appropriate cleaner



Final dry sanding steps; P220 - P320

*For detailed surface preparation see TDS S8.06.02*



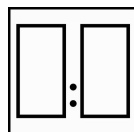
Remove contamination using an appropriate cleaner  
*Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

## Stir before use



Stir Priming Filler 680 Grey thoroughly before use.

## Mixing

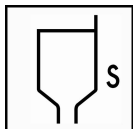


**100** Priming Filler 680 Grey  
**100** Thinner X

# Priming Filler 680 Grey

FOR PROFESSIONAL USE ONLY

## Viscosity



18-22 seconds Din Cup 4 at 20°C.

## Spray gun set-up / application pressure



**Spray gun**

Gravity feed

**Fluid tip-set-up**

1.5-1.8 mm

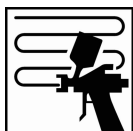
**Application pressure**

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

## Pot-life

1 day at 20°C.

## Application

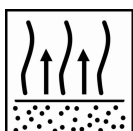


2-3 x 1 coat

## Film thickness

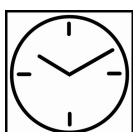
30-40 µm

## Flash off time



5-10 minutes at 20°C between coats.

## Drying time



30 minutes at 20°C

20 minutes at 40°C

15 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 temperature should not exceed 100°C.  
For additional information, see TDS S9.01.01

# Priming Filler 680 Grey

FOR PROFESSIONAL USE ONLY

## Final sanding



Final sanding step P500

*For detailed surface preparation see TDS S8.06.02*



Final sanding step P1000

*For detailed surface preparation see TDS S8.06.02*



Remove contamination using an appropriate cleaner.

## Recoatable with

All Sikkens solvent borne topcoats

## Material usage

By using the recommended application, the theoretical material usage is  $\pm 6 \text{ m}^2/\text{liter RTS mixture}$ .

*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 Solvent or solvent borne guncleaners

## Product storage

Product shelf-life is determined when products are stored unopened at 20°C.

Avoid extreme temperature fluctuation.

*Product shelf life data see TDS S9.01.02*

AkzoNobel Car Refinish bv.

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Tel: +31(0)71308-6944

## FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

**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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