

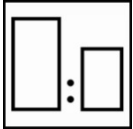
Autosurfacers[®] Rapid

FOR PROFESSIONAL USE ONLY

Description

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

Sanding application



100 Autosurfacers Rapid
 50 Autosurfacers Rapid Hardener / HT



Use Sikkens measuring stick
1 Black

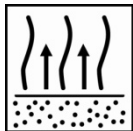


Spray gun set-up:
 1.5-2.0mm

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

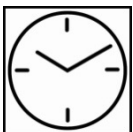


1-3 x 1 coat



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



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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

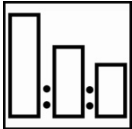
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Wet-on-wet (non sanding) application



100 Autosurfacers Rapid
 50 Autosurfacers Rapid Hardener / HT
 40 Plus Reducers



Use Sikkens measuring stick

12 Green

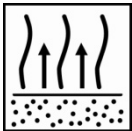


Spray gun set-up:
 1.3-1.5 mm

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



1 coat



After application,
 prior to topcoat application:
 15 minutes at 20°C

Recoat within:
 24 hours at 20°C



Recoat with all Sikkens topcoats



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Suitable substrates

Existing finishes	OEM electro coat (sanded)
Steel	Glass Reinforced Polyester laminates (GRP)
Galvanized steel	Polyester bodyfillers
Aluminium	Sikkens Polysurfacers
Washprimer 1K CF	1K All Plastic Primer

Autosurfacers Rapid will provide adequate adhesion if applied directly to steel.

However, it is advised to use Sikkens Washprimer 1K CF in the following cases:

- a. When the system is required to meet the highest standard
- b. Repairs that requires an extensive metal priming such as complete panel

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

Autosurfacers Rapid can be applied on plastics parts which have been preceded by; 1K All Plastic Primer.

Product and additives

Autosurfacers Rapid Light Grey

Hardeners Autosurfacers Rapid Hardener
 Autosurfacers Rapid Hardener HT; to use at temperatures of 35°C-45°C.

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.

Additives Elast-O-Actif; to elasticize Autosurfacers Rapid making it suitable for plastic parts. See TDS S8.06.03

Basic raw materials

Autosurfacers Rapid: Special acrylic resins
 Autosurfacers Rapid Hardener: Blocked polyamines of high molecular weight.
 Autosurfacers Rapid Hardener HT: Blocked polyamines of high molecular weight with slower solvents.

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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 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 Autosurfacers Rapid using appropriate surface cleaner. Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Stir before use



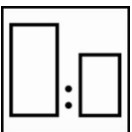
Stir Autosurfacers Rapid thoroughly before mixing.

Tinting

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

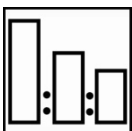
Autosurfacers Rapid mixtures with either a topcoat MM color or grey combination must be stirred thoroughly before adding Autosurfacers Rapid Hardener.

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



Light – Dark Ratio			
100 : 0	Light grey		
100 : 50	Medium light grey		
100 : 100	Medium grey		
100 : 50	Medium dark grey		
0 : 100	Dark grey		

Mixing



Sanding (rolling):

100 Autosurfacers Rapid
50 Autosurfacers Rapid Hardener (HT)

Non sanding (wet-on-wet):

100 Autosurfacers Rapid
50 Autosurfacers Rapid Hardener (HT)
40 Plus Reducers

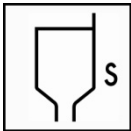
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Flexible parts

Once elasticized to the required level, Autosurfacers 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 S8.06.03


Viscosity



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

Non Sanding (wet-on-wet)
 16-18 seconds Din-cup 4 at 20°C.

Spray gun set-up / application pressure

Spray gun	Fluid tip-set-up	Application pressure
	<u>Sanding</u> Gravity feed HVLP max 0.6-0.7 bar at the air cap 1.5-2.0 mm	1.7-2.2 bar at the spray gun air inlet
	<u>Wet on wet</u> Gravity feed HVLP max 0.6-0.7 bar at the air cap 1.3-1.5 mm	1.7-2.2 bar at the spray gun air inlet

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

Pot-life

Autosurfacers Rapid:	30 minutes at 20°C.
Autosurfacers Rapid with Hardener HT:	30 minutes at 35°C.
Autosurfacers Rapid non sanding/wet-on-wet:	60 minutes at 20°C.
Autosurfacers Rapid with Elast-o-Activ:	60 minutes 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.

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

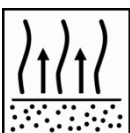


45 minutes at 20°C. 30 minutes at 40°C. 20 minutes at 60°C.
 Drying times relate to recommended application (3 coats) and object temperature.
 Drying time Autosurfacers Rapid Hardener HT; 45 minutes at 35°C.



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

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°C.

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

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Denibbing wet-on-wet (non sanding/surfacer)

For minor defects (e.g. dust) Autosurfacers Rapid 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!

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



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

Sanding	per coat	1.5 - 2.4 mils	40 - 50 µm
	3 coats	6.6 - 7.5 mils	120 - 180 µm
Rolling application	per coat	1.1 - 1.5 mils	30 - 40 µm
	3 coats	3.5 - 4.7 mils	90 - 120 µm
Wet-on-wet	1 coat	0.7 - 1.0 mils	20 - 25 µm

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Theoretical coverage

Sanding: Ready for use mixture at 1 μ m dry film thickness: $\pm 354 \text{ m}^2/\text{liter}$

Wet-on-wet: Ready for use mixture at 1 μ m dry film thickness: $\pm 353 \text{ m}^2/\text{liter}$

By using the recommended application, the theoretical material usage is:
 $\pm 5 \text{ m}^2/\text{liter}$ RTS mixture for Autosurfacers Rapid sanding.
 $\pm 10 \text{ m}^2/\text{liter}$ RTS mixture for Autosurfacers 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

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.
Product shelf life data see TDS S9.01.02

Akzo Nobel Car Refinishes (Singapore) Pte Ltd

Address: 3 Changi Business Park Vista, #05-01 Akzo Nobel House, Singapore 486051

Tel: +65 6635 5262

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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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Head Office

AkzoNobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com