

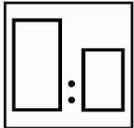
# Autosurfacers Rapid

**FOR PROFESSIONAL USE ONLY**

## Description

High-build, isocyanate free, two-pack sanding primer filler 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



Use Sikkens measuring stick

No.1 Black

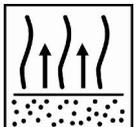


Spray gun set-up:  
1.5-1.8 mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLV 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

20 minutes at 60°C



Final sanding step: P500  
See TDS S8.06.02



Recoat 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

# Autosurfacer Rapid

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## Description

High-build, isocyanate free, two-pack sanding primer filler and 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.

## Suitable substrates

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

*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; 1K All Plastics Primer or 2K Plastic Primer.*

## Product and additives

Autosurfacer Rapid

**Hardeners** Autosurfacer Rapid Hardener

**Additives** Autocryl Structure Paste (Fine); See TDS 6.27, 6.29.  
Elast-o-Actif; See TDS S8.06.03c

## Basic raw materials

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

## Surface preparation



Remove contamination using an appropriate cleaner.



Final sanding steps; P180 – P320

See TDS S8.06.02. for sanding specifications



Remove contamination using an appropriate cleaner.

Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

# Autosurfacer Rapid

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## Stir before use



Stir Autosurfacer Rapid thoroughly before use.

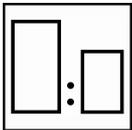
## Tinting

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

### Mixing Autosurfacer Rapid Light / Dark grey

Autosurfacer Rapid Light- and Dark Grey can be mixed in different mixing ratios.

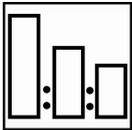
In the next table Quick-Mix grey shades are visible; these Quick-Mix grey shades can easily be mixed by volume with a Sikkens mixing stick or by weight.



Light - Dark		
100 : 0	Light grey	
100 : 10	Medium - light grey	
100 : 100	Medium grey	
50 : 100	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. .*

## Mixing



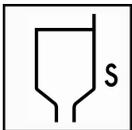
### Sanding / Rolling:

100 Autosurfacer Rapid  
50 Autosurfacer Rapid Hardener  
Use measuring stick 1

## Flexible parts

Once elasticized to the required level, Autosurfacer Rapid can be applied on plastic parts. All virgin plastic parts should be pre-coated with a suitable plastic primer. See TDS.S8.06.3c

## Viscosity



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

## Spray gun set-up / application pressure



### Spray gun

Gravity feed

### Fluid tip-set-up

Sanding  
1.5-2.0 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

Autosurfacer Rapid:  
Autosurfacer Rapid with Elast-o-Activ:

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

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## Application



### Sanding

#### Spot application:

Apply one coat over the total sanded area. Flash off until completely matt and apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat within each preceding coat. Flash off until completely matt after each coat

#### Panel application:

Apply 2-3 coats and flash off until completely matt after each coat.

### Rolling

Apply one light coat over the total sanded area. Flash off until completely matt and apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat within each preceding coat. Flash off until completely matt after each coat

Use the edge of the roller to prime awkward areas (door handle). Finally, squeeze remaining paint from roller and smooth off the repair. 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 temperature should not exceed 100°C.

*For additional information; see TDS S9.01.01*

## 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*



### Sanding in case of roller application

Pre sand with P320 - P400 In order to remove the coarser surfacer structure due to roller application. Work from the centre of the repair to the outer edge (inside out).



Remove surface contamination using an appropriate cleaner.

# Autosurfacer Rapid

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## Recoatable with

All Sikkens topcoats

## Film thickness

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

## Theoretical Coverage

**Sanding:** Ready for use mixture at 1 µm dry film thickness: m<sup>2</sup>/litre  
±354

*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/IIIB(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.

- *Product shelf life data see TDS S9.01.02*

## Akzo Nobel Coatings LTD

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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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