

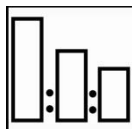
# Multi Use Filler Xcel

FOR PROFESSIONAL USE ONLY

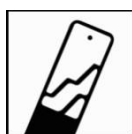
## Description

Sikkens Multi Use Filler Xcel is a two component primer/surfacer for general use in Automotive refinishing cars. By using a different mixing ratio, Sikkens Multi Use Filler Xcel can be used as a Sanding primer filler and a Non sanding (wet-on-wet) primer surfacer that provides good hold-out with Sikkens Topcoats.

## Sanding application



100 Multi Use Filler Xcel  
25 P25 / P35  
25 Plus Reducers



Use Sikkens measuring stick

**5** Orange

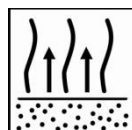


Spray gun set-up:  
1.8-2.0mm

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

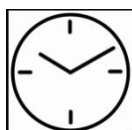


2-3 x 1 coat



Between coats:  
5-10 minutes at 20°C

Before curing:  
5-10 minutes at 20°C



Minimum dry times:

3 hours at 20°C

1.5 hours at 30°C

30 minutes at 60°C

2-3 coat application

*Note: Drying times may vary and require extending depending on the temperature, hardener and reducer.*



Final sanding step: P500

# Multi Use Filler Xcel

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Recoatable with all Sikkens topcoats



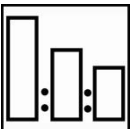
Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

## Description

Sikkens Multi Use Filler Xcel is a two component primer/surfacer for general use in Automotive refinishing cars. By using a different mixing ratio, Sikkens Multi Use Filler Xcel can be used as a Sanding primer filler and a Non sanding (wet-on-wet) primer surfacer that provides good hold-out with Sikkens Topcoats.

## Wet-on-wet (non sanding) application



100 Multi Use Filler Xcel  
50 P25 / P35 Hardeners  
30 Plus Reducers



Use Sikkens measuring stick

**1** Black



Spray gun set-up:  
1.3-1.4mm

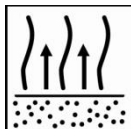
Application pressure:  
1.7-2.2 bar at the air inlet  
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1 coat

# Multi Use Filler Xcel

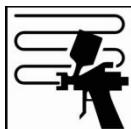
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Flash off time:  
Min: 15 minutes at 20°C  
prior to topcoat application.

Recoat within:  
24 hours at 20°C

*Note: Flash off time may vary and require extending depending on the temperature, hardener and reducer.*



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

## Suitable substrates

Existing finishes	OEM electro coat (sanded)
Steel	Polyester bodyfiller
Galvanized steel	Aluminium
Original finishes, including thermoplastic acrylics	Glass Reinforced Polyester laminates (GPR)

**Multi Use Filler Xcel will provide adequate adhesion if applied directly to steel.**

**However, we advise using Sikkens Washprimer 1K CF in the following cases:**

- When the system is required to meet high corrosion protection standards.**
- Repairs that requires an extensive metal priming such as complete panel.**
- When coating Aluminium, Zinc coated steel or Galvanised steel.**

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

## Product and additives

Multi Use Filler Xcel

**Hardeners:** P25 , P35

**Plus** Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.

**Reducers:** 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-Activ, to elasticize Multi Use Filler Excel making it suitable for plastic parts. See TDS S8.06.03

# Multi Use Filler Xcel

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## Basic raw materials

Multi Use Filler Xcel: Acrylic polyol resins  
P Hardeners Polyisocyanates  
Plus Reducers: Mixture of solvents

## Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner.



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; 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 Multi Use Filler Xcel using appropriate surface cleaner. Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

## Stir before use

# Multi Use Filler Xcel

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Stir Multi Use Filler Xcel thoroughly before mixing.

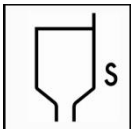
## Tinting

If necessary, Multi Use Filler Xcel can be tinted with up to 10 parts by volume with either; Autocryl Plus MM toners.

Multi Use Filler Xcel mixtures with either a topcoat MM color or grey combination must be stirred thoroughly before adding Hardener.

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

## Viscosity



Sanding  
18-24 seconds Din-cup 4 at 20°C.

Non Sanding (wet-on-wet)  
14-16 seconds Din-cup 4 at 20°C.

## Spray gun set-up / application pressure



### Spray gun

Gravity feed

Gravity feed

### Fluid tip-set-up

#### Sanding

1.8-2.0 mm

#### Wet on wet

1.3-1.5 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

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

Sanding version: 45 min to 1 hour at 20°C

Non Sanding version: 1 hour at 20°C

# Multi Use Filler Xcel

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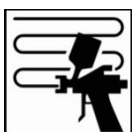
## Application

### Sanding

Apply one coat over the total sanded area. Next apply the 2<sup>nd</sup> and 3<sup>rd</sup> 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.

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.

**NOTE:** For large areas, or in temperature over 30°C, it is advisable to use P35 to avoid dry overspray.

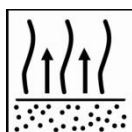
## Film thickness

By using the recommended application:

Sanding version, 2-3 coats: 50-60 µm per layer

Wet-on-wet (non sanding version), 1 coat: 25-30 µm per layer

## Flash off time wet-on-wet (non sanding/surfacer)



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.

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

For minor defects (e.g. dust) Multi Use Filler Xcel 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

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Final sanding step P500

Initial sanding steps may be executed with a coarser sanding grit; P320 - 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 topcoat using an appropriate surface cleaner.

## Recoatable with

All Sikkens topcoats

## Theoretical coverage

By using the recommended application, the theoretical material usage is:

7 m<sup>2</sup>/liter per coat at 50 µm and 9 m<sup>2</sup>/liter per coat at 30 µm.

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstance

## Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

## Product storage

Product shelf-life is determined when products are stored unopened at 5-35°C.

Avoid extreme temperature fluctuation.

Product shelf life data see TDS S9.01.02

# Multi Use Filler Xcel

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## 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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### Head Office

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