

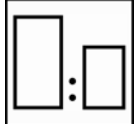
Autosurfacers Rapid

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



Use Sikkens measuring stick
No. 1 Black

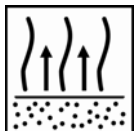


Spray gun set-up:
1.5-2.0 mm

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
3 coat application

20 minutes at 60°C



Final sanding step: P500
See TDS S8.06.01



Recoat with all Sikkens topcoats



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



Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Read complete TDS for detailed product information



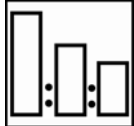
Autosurfacers Rapid

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.

Wet-on-wet (non sanding) application



- 3 Autosurfacers Rapid
- 1 Autosurfacers Rapid Hardener
- 2 Autosurfacers Rapid Non Sanding Reducer



Use Sikkens measuring stick
No. 15 Green

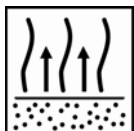


Spray gun set-up:
1.2-1.4 mm

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



1 coat



Flash off time:
15 minutes at 20°C

Recoat within:
24 hours at 20°C



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



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.

Suitable substrates

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

Autosurfacers Rapid will provide adequate adhesion if applied directly to steel, however, we advise for systems which should meet the highest standards to apply Autosurfacers Rapid over Sikkens Washprimer. 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; Plastoflex Primer or 2K Plastic Primer.

Product and additives

Autosurfacers Rapid (Light Grey - Dark Grey)

Hardeners

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

Reducers

Autosurfacers Rapid Non Sanding Reducer; wet-on-wet/surfacers application.

Additives

Autocryl Structure Paste (Fine); additive to create different surface textures; TDS 6.27, 6.29.
Elast-o-Actif; to elasticize Autosurfacers Rapid making it suitable for plastic parts. See 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.

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; P180 - P220
Featheredge sanding for spot repair, finish outer area with P400
For detailed surface preparation see TDS S8.06.02



Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY



Surface cleaning, remove any surface contamination prior to the application of Autosurfacer Rapid using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

Stir before use



Stir Autosurfacer Rapid thoroughly before mixing.

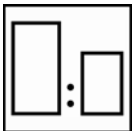
Tinting

If necessary, Autosurfacer Rapid can be tinted with up to 10 parts by volume with either; Autocryl LV 420 or 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.

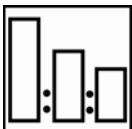


Light - Dark		
100 : 0	Light grey	
100 : 10	Medium light grey	
5 : 1	Medium grey	
100 : 50	Medium dark grey	
0 : 100	Dark grey	

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

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

Mixing



Sanding (rolling):

100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener

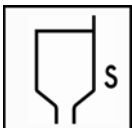
Non sanding (wet-on-wet):

3 Autosurfacer Rapid
1 Autosurfacer Rapid Hardener
2 Autosurfacer Rapid Non Sanding Reducer

Flexible parts

Once elasticized to the required level, Autosurfacer 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.S8.06.3.

Viscosity



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

Non Sanding / with Elast-o-Activ
16-18 seconds Din-cup 4 at 20°C.

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Spray gun set-up / application pressure



Spray gun	Fluid tip-set-up	Application pressure
Gravity feed	<u>Sanding</u> 1.5-2.0 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap
	<u>Wet on wet</u> 1.2-1.4 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap
Gravity feed		

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

Pot-life

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

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 Autosurfacer Rapid Hardener HT; 45 minutes at 35°C.

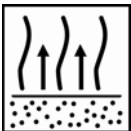
Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY



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

For minor defects (e.g. dust) Autosurfacer 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

By using the recommended application;		
Sanding	Per coat	40 - 60 µm
	3 coats	120 - 180 µm
Rolling application	Per coat	30 - 40 µm
	3 coats	90 -120 µm
Wet-on-wet (non sanding)	1 coat	20 - 25 µm

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY**Material usage**

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

- ± 5 m²/liter RTS mixture for Autosurfacer Rapid sanding.
- ± 10 m²/liter RTS mixture for Autosurfacer 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**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*

AkzoNobel Car Refinish bv.

Address: Rijksweg 31, PO Box 3, 2170 BA Sassenheim

Tel: +31(0)71308-6944

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.

Coating brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

Head Office



Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

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

