

1040R

27.08.2014

UNIVERSAL 2K SURFACER GREY

DESCRIPTION

2-component high solids surfacer with 3 methods of application:

- a. maxi filler;
- b. high solids sanding surfacer;
- c. high solids non-sanding surfacer.

Colour: light grey.

Composition based on functional acrylic copolymer.

PRODUCTS

1040R	Universal 2K Surfacer Grey
1010R	High Solids Activator Fast
123S	Fast Activator
125S	Standard Activator
126S	Slow Activator
256S	Activator Fast
255MS	
1025R	High Solids Surfacer Thinner
1030R	High Solids Non-sanding Convertor

PROPERTIES

- Easy to apply, smooth flow.
- Very easy to sand, many days after application.
- Superb filling.
- Can be tinted up to 10 % maximum with AM Centari® MasterTints®.
- Can be coated with all solvent based topcoats.

SUBSTRATES

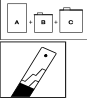







- OEM or cured repair finishes.
- Sanded polyester putties.
- Wash primers.
- Epoxy primers.

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PRODUCT PREPARATION

 Mixing ratio		Maxi filler		Sanding surfacer			Non-sanding surfacer			
		Volume	Weight	Volume	Weight	Volume	Weight			
	1040R 1010R/125S/255MS 1025R 1030R	4 1 - -	100 16 - -	4 1 2 -	100 16 28 -	4 1 - 3	100 16 - 44			
VOC		530 g/l		628 g/l			626 g/l			
 Pot life at 20°C	With 1010R With 125S	45 min 1 hr		1 hr 30 min 2 hr r			2 hr 3 hr			
 Spray viscosity at 20°C	DIN 4 FORD 4	-		16-18 s 16-18 s			15-16 s 15-16 s			
 Spray equipment		Fluid tip	Distance	Pressure	Fluid tip	Distance	Pressure	Fluid tip	Distance	Pressure
	Compliant guns	(mm)	(cm)		(mm)	(cm)		(mm)	(cm)	
	Gravity feed	1.6-2.0	15	According to supplier's specifications	1.4-1.6	15	According to supplier's specifications	1.4-1.6	15	According to supplier's specifications
	Suction feed	-	15		1.6-1.8	15		1.6-1.8	15	
Pressure feed	1.1-1.4	15	1.0-1.2		15	1.0-1.2		15		
Conventional guns	(mm)	(cm)	(bar)	(mm)	(cm)	(bar)	(mm)	(cm)	(bar)	
Gravity feed	1.8-2.0	20-25	2-2.5	1.4-1.6	20-25	2-2.5	1.4-1.6	20-25	2-2.5	
Suction feed	-	20-25	2-2.5	1.6-1.8	20-25	2-2.5	1.6-1.8	20-25	2-2.5	
Pressure feed	1.1-1.4	20-25	2-2.5	1.0-1.2	20-25	2-2.5	1.0-1.2	20-25	2-2.5	
 Number of coats		1-3			1-2			1 minimum		
 Flash time		Between coats till flat. 30 min before bake.			Between coats till flat. 10 min before bake.			15 min (till 8 hr maximum) before recoating.		
DFT		60-80 µm/coat			40-60 µm/coat			30-40 µm		
 Dry to sand at 15°C at 20°C at 40°C at 60°C		1010R/123S	125S/126S	1010R/123S	125S/126S	Not applicable.				
		12-16 hr	16-24 hr	4-6 hr	5-8 hr					
		8-12 hr	10-16 hr	3 hr	4 hr					
		40 min	45 min	30 min	35 min					
		30 min	35 min	25 min	30 min					
 IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min			* Guideline for short/medium wave IR equipment.			Not applicable.		

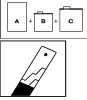







This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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PRODUCT PREPARATION (CON'D)

	Mixing ratio	Maxi filler			Sanding surfacer		
		Volume	Weight	Volume	Weight		
	1040R 256S 1025R 1030R	5 1 - -	100 13 - -	5 1 2 -	100 13 23 -		
	VOC	493 g/l			587 g/l		
	Pot life at 20°C	45 min			1 hr 30 min		
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4			16-18 s 16-18 s 18-20 s		
	Spray equipment	Fluid tip	Distance	Pressure	Fluid tip	Distance	Pressure
		Compliant guns Gravity feed Suction feed Pressure feed	1.6-2.0 mm - 1.1-1.4 mm	15 cm 15 cm 15 cm	According to supplier's specifications	1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	15 cm 15 cm 15 cm
	Conventional guns Gravity feed Suction feed Pressure feed	1.8-2.0 mm - 1.1-1.4 mm	20-25 cm 20-25 cm 20-25 cm	2-2.5 bar 2-2.5 bar 2-2.5 bar	1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	20-25 cm 20-25 cm 20-25 cm	2-2.5 bar 2-2.5 bar 2-2.5 bar
	Number of coats	1-3			1-2		
	Flash time	Between coats till flat. 30 min before bake.			Between coats till flat. 10 min before bake.		
	DFT	60-80 µm/coat			40-60 µm/coat		
	Dry to sand	at 15°C: 12-16 hr at 20°C: 8-12 hr at 40°C: 40 min at 60°C: 30 min			4-6 hr 3 hr 30 min 25 min		
	IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min		* Guideline for short/medium wave IR equipment.		
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SURFACE PREPARATION

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
 - a. before applying maxi filler: mechanical with P80 - P120, wet with P150 - P240;
 - b. before applying sanding surfacer: mechanical with P220 - P280, wet with P360 - P500;
 - c. before applying non-sanding surfacer: mechanical with P220 - P320, wet with P360 - P600.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.
5717S is not recommended if polyester putty is required.
- Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
- Apply 1 coat of wash primer or epoxy primer.

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
5. Apply 1 coat of wash primer or epoxy primer.

APPLICATION SELECTION

Maxi filler

To isolate polyester putty spots, to fill up small sand scratches or sand throughs.

Sanding surfacer

For spot, panel and overall repair.

Non-sanding surfacer

To reduce sanding work and increase output of spray booth.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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REMARKS

- Do not use activated 1040R beyond the pot life nor reduce it further to get viscosity down again.
- If 1040R is applied over thermoplastic acrylic finishes, complete panel or overall car has to be treated. Spot repairing or sand throughs of the surfacer can result in spot marking or lifting when applying a basecoat.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity:	3500-4500 cp
Theoretical coverage:	Maxi filler 5.5-7.3 m ² /l at recommended DFT - ready-to-spray
	Sanding surfacer 5.2-7.8 m ² /l at recommended DFT - ready-to-spray
	Non-sanding surfacer 7.8-10.3 m ² /l at recommended DFT - ready-to-spray

SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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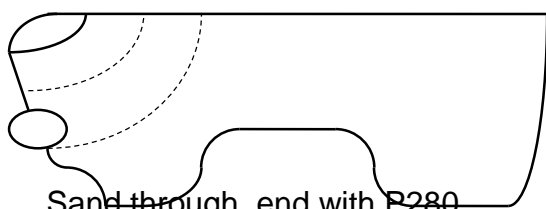
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PREPARATION METHOD FOR SPOT REPAIR

P280 P320 P360

PE



1. Sand through, end with P280.
2. Fill the spot with polyester putty and sand with P280.
3. Sand the surrounding area with P320 and finish on the OEM finish with P360.
4. Apply 1 coat of wash primer or epoxy primer over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1st coat of surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of surfacer, staying inside the 1st-coat area. Flash till flat.

All other products referred to in the paint system build-up are from Cromax[®]. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax[®], unless explicitly indicated otherwise.

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