

1051R / 1057R

27.08.2014

HIGH PRODUCTIVE SURFACER

DESCRIPTION

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

- a. maxi filler;
- b. sanding surfacer.

Colour: white, black.

Composition based on special hydroxy functional acrylic.

PRODUCTS

1051R	High Productive Surfacers - white
1057R	High Productive Surfacers - black
1010R	High Solids Activator Fast
125S	Standard Activator
256S	Activator Fast
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
255MS	Universal Fast Activator
1025R	High Solids Surfacers Thinner
XB383	Standard Thinner

PROPERTIES

- Easy to apply, smooth flow.
- Very easy to sand even after 1 hr air dry.
- Superb filling.
- Part of ValueShade® concept.
- Can be coated with all topcoats.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES

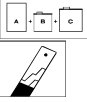







- OEM or cured repair finishes.
- E-coats.
- Sanded polyester putties.
- Wash primers.
- Epoxy primers.

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PRODUCT PREPARATION

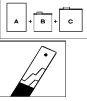
	Mixing ratio ValueShade® ValueShade® 1 ValueShade® 2 ValueShade® 3 ValueShade® 4 ValueShade® 5 ValueShade® 6 ValueShade® 7	1051R			1057R				
	Mixing ratio 1051R/1057R 1010R/125S/255MS 1025R	Maxi filler		Sanding surfacer					
		Volume	Weight	Volume	Weight				
		4	100	4	100				
		1	18	1	18				
		0.5	8	1	16				
	VOC	520 g/l			540 g/l				
	Pot life at 20°C	45 min			1hr				
	Spray viscosity at 20°C	DIN 4 FORD 4		21-23 s 22-24 s					
	Spray equipment	Compliant guns Gravity feed Suction feed Pressure feed		Fluid tip 1.4-1.8 mm - 1.1-1.4 mm	Distance 15 cm 15 cm 15 cm	Pressure According to supplier's specifications	Fluid tip 1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	Distance 15 cm 15 cm 15 cm	Pressure According to supplier's specifications
		Conventional guns Gravity feed Suction feed Pressure feed		1.4-1.8 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							
	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 µ/coat				
	Dry to sand	at 15°C at 20°C at 40°C at 60°C			2-4 hr 1 hr - 1 hr 30 min 40 min 30 min		2 hr 1 hr 30 min 25 min		
	IR drying*	Distance Half power	30 - 50 cm 10 min		* Guideline for short/medium wave IR equipment.				
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

	Mixing ratio ValueShade® ValueShade® 1 ValueShade® 2 ValueShade® 3 ValueShade® 4 ValueShade® 5 ValueShade® 6 ValueShade® 7	1051R		1057R	
	Mixing ratio	100 93 83 65 35 10 0			0 7 17 35 65 90 100
		Sanding surfacer			
		Volume 5 1 - 1.5	Weight 100 14 - 18	Volume 7 - 1 2.5	Weight 100 - 11 22
VOC		540 g/l			
Pot life at 20°C		1 hr			
Spray viscosity at 20°C		DIN 4 FORD 4	20-22 s 21-23 s	20-23 s 21-24 s 23-26 s	
Spray equipment		Compliant guns Gravity feed Suction feed Pressure feed Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip 1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm 1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	Distance 15 cm 15 cm 15 cm 20-25 cm 20-25 cm 20-25 cm	Pressure According to supplier's specifications 2-2.5 bar 2-2.5 bar 2-2.5 bar
Number of coats		1-3			
Flash time		Between coats till flat. 10 min before bake.			
DFT		40-60 µm/coat			
Dry to sand		at 15°C at 20°C at 40°C at 60°C	2 hr 1 hr 30 min 25 min		
IR drying*		Distance Half power	30 - 50 cm 10 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.
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.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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REMARKS

- Do not use activated 1051R/1057R beyond the pot life nor reduce it further to get viscosity down again.
- If 1051R/1057R 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.
- The use of high performance activators will positively influence the adhesion and stonechip performance of the complete paint system.
- 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:	6000 - 9000 cp (at 20 rpm)	
Theoretical coverage:	Maxi filler	7.6 - 8.2 m ² /l at 50 μ DFT
	Sanding surfacer	7.0 - 7.7 m ² /l at 50 μ DFT
Directive 2004/42/EC:	2004/42/IIB(c)(540)540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.	

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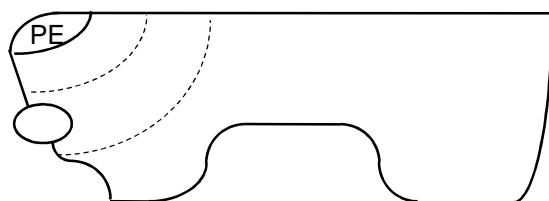
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SAFETY

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

PREPARATION METHOD FOR SPOT REPAIR

P280 P320 P360



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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