



Effective 14 July, 2010

# NS2502 / NS2506

## NON-SANDING SURFACER

### Description

2-component Low Emission non-sanding surfacer.  
Colour: off white, dark grey.  
Composition based on a special hydroxy functional acrylic.

### Products

NS2502	Non-sanding Surfacer - off white
NS2506	Non-sanding Surfacer - dark grey
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
XB383	Standard Thinner
XB387	High Temperature Thinner

### Properties

- Provides good filling.
- No convertor required for non-sanding application.
- Superior topcoat hold-out.
- Part of ValueShade<sup>®</sup> concept.
- Only short flash time required before coating with all DuPont Refinish topcoats.
- VOC compliant, conform with directive 2004/42/EC.

### Substrates

- OEM or cured repair finishes.
- E-coats.
- Sanded DuPont Refinish polyester putties.
- DuPont Refinish wash primers.
- DuPont Refinish epoxy primers.









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### PRODUCT PREPARATION

	<b>Mixing ratio</b>	<b>Non-sanding surfacer</b>			
		<b>Standard</b>		<b>Large surface</b>	
		Volume	Weight	Volume	Weight
	NS2502/NS2506 XK203/XK205 XK206 XB383/XB387	4 1 - 1.5	100 17 - 20	4 - 1 1.5	100 - 17 20
	<b>VOC</b>	540 g/l			
	<b>Pot life at 20°C</b>	XK203 XK205 XK206	1 hr 1 hr 30 min 2 hr		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	16-18 s 16-18 s		
	<b>Spray equipment</b>	<b>Conventional guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
		Gravity feed Suction feed Pressure feed	1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar
		<b>Compliant guns (HVLPH/TE)</b>			
		Gravity feed Suction feed Pressure feed	1.3-1.5 mm 1.5-1.8 mm 1.0-1.2 mm	15 cm 15 cm 15 cm	According to supplier's specifications
	<b>Number of coats</b>	1-2			
	<b>Flash time</b>	Between coats till flat. 15 min (till 8 hr maximum) before recoating.			
	<b>DFT</b>	20-30 µm/coat			
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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## NON-SANDING SURFACER

### RECOMMENDED USE

#### Surface preparation

##### OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara®®® cloths.
3. Sand surface:
  - a. mechanical with P220 - P320;
  - b. wet with P600.
4. Remove all traces of sanding dust by blowing with clean oil-free compressed air.
5. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara®® cloths.

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 DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara®® cloths.
- Apply 1 coat of DuPont Refinish wash primer or DuPont Refinish epoxy primer.

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

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

#### Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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## NON-SANDING SURFACER

### RECOMMENDED USE (con'd)

#### Remarks

- Do not use activated NS2502/NS2506 beyond the pot life nor reduce it further to get viscosity down again.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, flash times, spray pressure and DFT to guarantee good topcoat hold-outs.
- 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 ValueShade® concept, 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: 1300-1700 cp (at 20 rpm)  
 Theoretical coverage: 15.8 m<sup>2</sup>/l at 25 μm DFT  
 Directive 2004/42/EC: 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.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
NS2502	3.5	2	1.619
NS2506	3.5	2	1.563
XK203	1 - 5	2	1.060
XK205	1 - 5	2	1.059
XK206	1 - 5	2	1.078
XB383	1 - 5 - 20	2	0.847
XB387	1 - 5	2	0.867

#### Safety

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



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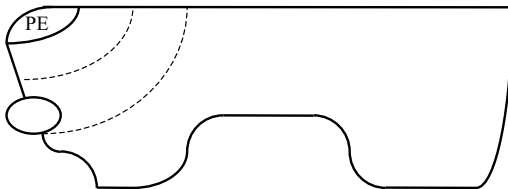
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## NON-SANDING SURFACER

### REPAIR SYSTEMS

#### Preparation method for spot repair

P280 P320 P360



1. Sand through, end with P280.
2. Fill the spot with DuPont Refinish 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 DuPont Refinish wash primer or DuPont Refinish epoxy primer over the polyester putty to isolate the substrate and flash till flat.
5. Apply a coat of surfacer over the entire prepared area. Flash till completely flat.  
OPTIONAL: apply a 2<sup>nd</sup> coat of surfacer, extending further into the area surrounding the spot.