

NS2502 / NS2506

27.08.2014

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 Surfacers - off white
NS2506	Non-sanding Surfacers - dark grey
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
XB383	Standard Thinner
XB387	HI-Temp Thinner

PROPERTIES

- Provides good filling.
- No convertor required for non-sanding application.
- Superior topcoat hold-out.
- Part of ValueShade® concept.
- Only short flash time required before coating 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.

NS2502 / NS2506

27.08.2014

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PRODUCT PREPARATION

	Mixing ratio ValueShade®		NS2502		NS2506	
		ValueShade® 2	100		0	
		ValueShade® 3	95		5	
		ValueShade® 4	84		16	
		ValueShade® 5	50		50	
Mixing ratio		ValueShade® 6	0		100	
			Non-sanding surfacer			
			Standard		Large surface	
			Volume	Weight	Volume	Weight
		NS2502/NS2506	4	100	4	100
	XK203/XK2055	1	17	-	-	
	XK206	-	-	1	17	
	XB383/XB387	1.5	20	1.5	20	
	VOC	540 g/l				
	Pot life at 20°C	XK203	1 hr			
		XK205/AR7305	1 hr 30 min			
		XK206/AR7306	2 hr			
	Spray viscosity at 20°C	DIN 4	16-18 s			
		FORD 4	16-18 s			
	Spray equipment	Compliant guns	Fluid tip	Distance	Pressure	
		Gravity feed	1.3-1.5 mm	15 cm	According to supplier's specifications	
	Suction feed	1.5-1.8 mm	15 cm			
	Pressure feed	1.0-1.2 mm	15 cm			
		Conventional guns				
	Gravity feed	1.4-1.6 mm	20-25 cm	2-2.5 bar		
Suction feed	1.6-1.8 mm	20-25 cm	2-2.5 bar			
Pressure feed	1.0-1.2 mm	20-25 cm	2-2.5 bar			
	Number of coats	1-2				
	Flash time	Between coats till flat. 15 min (till 8 hr maximum) before recoating.				
	DFT	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.

NS2502 / NS2506

27.08.2014

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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. mechanical with P220 - P320;
 - b. wet with 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.

Unsanded E-coat

1. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
2. Due to the wide variety of electro coats present on the market, its quality can differ a lot.
For this reason preferably scuff sand the E-coat.

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.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

NS2502 / NS2506

27.08.2014

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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 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 15.8 m²/l at 25 µm DFT

coverage:

Directive 2004/42/IIIB(c) (540)540: The EU limit value for this product (product category: IIIB(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.

SAFETY

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

NS2502 / NS2506

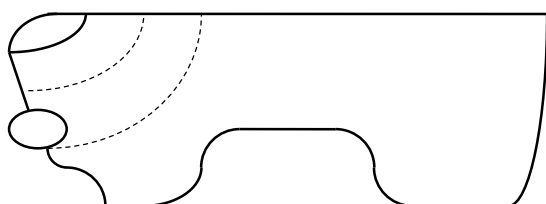
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PREPARATION METHOD FOR SPOT REPAIR

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 a coat of surfacer over the entire prepared area. Flash till completely flat.
OPTIONAL: apply a 2nd coat of surfacer, extending further into the area surrounding the spot.

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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