

PS1061 / PS1064 / PS1067

27.08.2014

CROMAX® PRO SURFACER

DESCRIPTION

2-component surfacer with a composition based on special highly reactive hydroxyfunctional acrylics and polyesters.

Colour: white, medium grey, black.

PRODUCTS

PS1061	Cromax® Pro Surfacers - white
PS1064	Cromax® Pro Surfacers - medium grey
PS1067	Cromax® Pro Surfacers - black
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
XB383	Standard Thinner
XB387	HI-Temp Thinner
AZ9032	Non - Sanding Convertor

PROPERTIES

- Easy application resulting in uniform surface.
- User friendly.
- Part of ValueShade® concept.
- Excellent in mechanical and wet sanding.
- Superior topcoat hold-out.
- Can be coated with all topcoats.
- Exception! :Non-Sanding version is not suitable for use under Centari® 600 / Centari® 6000.
- 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 (SANDING VERSION)








Weight 100 14 6 - 9	Mixing ratio ValueShade® Mixing ratio	ValueShade® 1	PS1061	PS1064	PS1067
		ValueShade® 2	100	0	0
		ValueShade® 3	80	20	0
		ValueShade® 4	60	40	0
		ValueShade® 5	0	100	0
		ValueShade® 6	0	80	20
		ValueShade® 7	0	60	40
			0	0	100
		Sanding surfacer			
		PS1061/PS1064/PS1067 XK203/XK205/XK206 XB383/XB387	Volume 5 1 0.5 - 0.8	Weight 100 14 6 - 9	
	VOC	500 g/l			
	Pot life at 20°C	XK203/XK205/AR7305 XK206/AR7306	45 min - 1hr 1hr - 1hr 15min		
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	18-23 s 18-24 s 20-27 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 1.6-2.0 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		5 - 10 min between coats 5 - 10 min before bake.		
	DFT		45-65 µm/coat		
	Dry to sand		XK203	XK205	XK206
		at 15°C	5-6 hr	6-8 hr	8 hr
		at 20°C	2-3 hr	3-4 hr	4 hr
		at 40°C	30 min	30 min	40 min
		at 60°C	20 min	20 min	30 min
	IR drying*	Distance Half power Full power	80 cm 5 min 15-20 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 (NON-SANDING VERSION)

	Mixing ratio ValueShade® ValueShade® 1 ValueShade® 2 ValueShade® 3 ValueShade® 4 ValueShade® 5 ValueShade® 6 ValueShade® 7	PS1061 100 80 60 0 0 0 0	PS1064 0 20 40 100 80 60 0	PS1067 0 0 0 0 20 40 100
	Mixing ratio PS1061/PS1064/PS1067 XK205/XK206 AZ9032	Non-Sanding surfacer		
VOC		530 g/l		
	Pot life at 20°C XK205/AR7305 XK206/AR7306	1hr 15min 1hr 30min		
	Spray viscosity at 20°C DIN 4 FORD 4	16-18 s 16-18 s		
	Spray equipment	Fluid tip	Distance	Pressure
	Compliant guns Gravity feed Suction feed Pressure feed Conventional guns Gravity feed Suction feed Pressure feed	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	15 cm 15 cm 15 cm 20-25 cm 20-25 cm 20-25 cm	According to supplier's specifications 2-2.5 bar 2-2.5 bar 2-2.5 bar
	Number of coats	1		
	Flash time	30 min (till 8 hr maximum) before recoating. Exception! : Non-Sanding version is not suitable for use under Centari® 600 / Centari® 6000.		
	DFT	30-40 µm		
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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 sanding surfacer: mechanical with P220 - P280, wet with P360 - P500;
 - b. before applying non-sanding surfacer: mechanical with P220 - P320, 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 electrocoats 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.

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REMARKS

- PS106x has to be mixed thoroughly and has to remain on mixing machine until use.
- Do not use activated PS1061/PS1064/PS1067 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, 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:	Thixotropic
Theoretical coverage:	Sanding version: 5.2 – 7.8 m ² /l. at recommended DFT - ready-to-spray Non sanding version: 11.5 – 15.3 m ² /l. at recommended DFT - ready-to-spray
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.

SAFETY

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

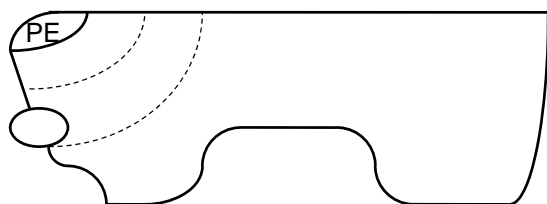
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PREPARATION METHOD FOR SPOT REPAIR

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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