

Always use correct Personal Protective Equipment

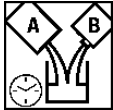
# RAPID FILLER

## Description



A rapid curing 2-pack Acrylic Urethane Primer Filler/Primer Surfacer that is free sanding with excellent filling properties and gloss hold under 2K topcoats and Acrylic Lacquers. It can be used as a primer filler or primer surfacer by adjusting the amount of RALI 400 Reducer used.

## Products



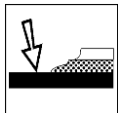
**Product Type:** Acrylic Urethane  
**Colour:** Grey  
**Pot Life:** 1 hour with RALI GP Hardener  
**Induction Time:**  
**Density:** 1.5 kg/L approx  
**Recommended DFT:** 50-70 microns  
**Theoretical Coverage:** 6.0-8.4 m<sup>2</sup>/litre @ 50-70 microns DFT.

## Properties



**VOC:** 498 g/L unthinned  
**Volume Solids:** 41.6% approximately unthinned  
**Recoat-ability:** Self Recoat: Between 20 minutes and 50 minutes  
 Topcoat: After sanding  
**Dry Time @ 20°C:** Tack free: 30 minutes RALI GP Hardener  
 Handle: 1 hour using RALI GP Hardener  
 Dry to sand: 2½ - 3 hours @ + 20°C  
**Force Dry @ 60°C:** 30 minutes after 5-10 minutes flash off. Sand when cool.

## Substrates



Rapid 2K Filler can be applied over correctly prepared:

- Aged and fully cured Automotive finishes including Acrylic
- Lacquers and clear over base systems.
- Steel
- Polyester body fillers
- Aluminium (apply first 81A Two-Pack Etch Primer-refer Data Sheet)
- Galvanised steel (apply first 81A Two-Pack Etch Primer)
- Wood and MDF Board Composites
- Glass Reinforced plastics (Fibreglass)
- Plastic Bumpers

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**Surface Preparation**



**Old Finishes & Glass-Reinforced Plastics**

Wash with C-Power diluted 20 parts clean water to 1 part C-Power. Degrease using the wipe on wipe off method using clean lint free cloths at all times with Wax & Grease Remover. Abrade with suitable grit paper; re-clean with Wax & Grease Remover. Ensure surface is completely dry and dust free before applying Rapid Filler.

Do not apply to existing finishes that are blistering, peeling, cracking, flaking or otherwise unsound.

**Steel**

Degrease thoroughly using the wipe on wipe off method using clean lint free cloths at all times with Wax & Grease Remover. Sand and eliminate all rust or corrosion (treat with Rust Kill). Wipe surface clean with Wax & Grease Remover. Dry then, within 20 minutes apply 81A Two-Pack Etch Primer (for optimum adhesion for large areas). Allow a minimum 3 hours (maximum 24 hours) flash time before applying Rapid Filler.

**Aluminium**

Degrease using the wipe on wipe off method using clean lint free cloths at all times with Wax & Grease Remover. Mechanically abrade with P280 or P320 disc. Treat with Hydrafos acid wash. Rinse with clean water, ensuring that all metal swarf and acid is removed dry. Immediately wipe surface clean with GP Thinners. Apply 81A 2-Pack Etch Primer within 20 minutes of surface preparation. Allow a minimum of a 3 hours flash time (24 hour maximum) before applying Rapid Filler.

**Galvanised Steel**

Degrease using the wipe on wipe off method using clean lint free cloths at all times with Wax & Grease Remover. Mechanically abrade to remove rust and corrosion. Treat with Hydrafos acid wash. Rinse with clean water. Immediately wipe surface clean with GP Thinners. Apply 81A 2-Pack Etch Primer within 20 minutes of surface preparation. Allow a minimum of a 3 hours flash time (24 hour maximum) before applying Rapid Filler.

**Wood & MDF Board Composites**

Clean thoroughly with Wax & Grease Remover using the wipe on wipe off method. Use clean lint free cloths at all times, and sand with fine grit paper. Remove dust and wipe clean with Wax & Grease Remover. Apply two full coats of Rapid Filler.

**Plastic Bumpers**

Clean thoroughly with Wax & Grease Remover using the wipe on wipe off method using clean lint free cloths at all times, sand with 320-grit paper. Remove dust and wipe clean with Wax & Grease Remover. Apply one full coat of Rapid Filler (adhesion problems can be encountered with some plastics, particularly if they have a 'waxy feel'. If in doubt check on a test area before proceeding).

**Directions For Use**

**Mixing Ratio:**

**As Primer Filler**

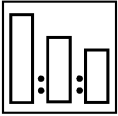
4:1:2      4 parts Rapid Filler

(Volume) 1 part General Purpose Hardener 2 parts 400 / 400 Slow Reducer.

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**Directions For Thinning:**  
**Use cont.**



**As Primer Surfacer**

4:1:4 4 parts Rapid Filler  
1 part General Purpose Hardener to 4 parts 400 or 400 Slow Reducer.  
Strain before application. Apply 2 full coats with 5-10 minutes flash-off between coats.

**Remarks:** Do not use activated primer beyond the pot-life time. Do not thin excessively to reduce to spraying viscosity after pot-life time. Excessive film thickness can cause film defects such as cracking and poor through curing. Sand primer before topcoat is applied. RALI Rapid Filler cured with RALI Extra Fast 2K Hardener can be machine dry sanded sooner.

**Note** *Lower temperatures will slow drying; addition of up to 5% by volume of RALI 62C Accelerator to mixed primer and hardener will approximately halve curing and pot life times. Reduce addition to 1-2% when drying with IR lamps. Misuse of RALI 62C Accelerator can cause loss of adhesion and poor flow-out.*

**Spray Equipment:** Compliant / Conventional Suction or Gravity Feed  
Air pressure: 275-380KPA (40-55 psi)  
Tip size: 1.5 - 1.8 mm



**Health & Safety** For detailed information refer to Safety Data Sheet (SDS). Mixed product contains less than 0.1% isocyanate monomer H.D.I. When sprayed this product may be harmful by inhalation. Do not breathe vapour or spray. Avoid contact with skin and eyes. Wear suitable protective clothing, gloves, eye and face protection, including suitable breathing protection such as an air supplied respirator or hood.



**Transport & Storage**

<b>Sizes:</b>	1L, 4L
<b>Dangerous Goods:</b>	3A
<b>UN:</b>	1263
<b>Hazchem:</b>	3[Y]E
<b>Packing Group:</b>	II
<b>Shipment name:</b>	PAINT Flammable Liquid
<b>Flash point:</b>	4°C



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