

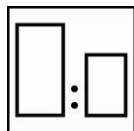
Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Description

High-build, isocyanate free, two-pack sanding filler and non sanding surfacer with extremely fast air and force drying properties. Autosurfacer Rapid has excellent application and sanding properties and provides good enamel hold-out with all Sikkens topcoats.

Sanding application



100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener



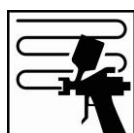
Use Sikkens measuring stick

1 Black or **12** Green

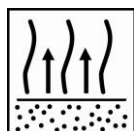


Spray gun set-up:
1.5-2.0 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap



1-3 x 1 coat



Between coats:
5-7 minutes at 20°C

Before curing:
5-7 minutes at 20°C



45 minutes at 20°C
3 coat application

20 minutes at 60°C



Final sanding step: P500
See TDS S8.06.02



Recoat with all Sikkens topcoats



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

Autosurfacer Rapid

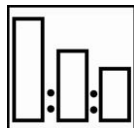
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Description

High-build, isocyanate free, two-pack sanding filler and non sanding surfacer with extremely fast air and force drying properties. Autosurfacer Rapid has excellent application and sanding properties and provides good enamel hold-out with all Sikkens topcoats.

Non sanding application

(EU VOC Directive)



- 3 Autosurfacer Rapid
- 1 Autosurfacer Rapid Hardener
- 2 Autosurfacer Rapid Non Sanding Reducer



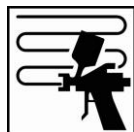
Use Sikkens measuring stick

15 Green

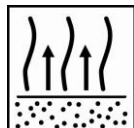


Spray gun set-up:
1.2-1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap

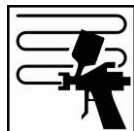


1 coat



Flash off time:
15 minutes at 20°C

Recoat within:
24 hours at 20°C



Recoatable with all Sikkens topcoats



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

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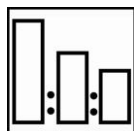
Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Description

High-build, isocyanate free, two-pack sanding primer filler and non sanding surfacer with extremely fast air and force drying properties. Autosurfacer Rapid has excellent application and sanding properties and provides good enamel hold-out with all Sikkens topcoats.

Non sanding application



100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener
40 Plus Reducers / High Performance Reducers



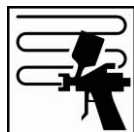
Use Sikkens measuring stick

12 Green

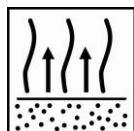


Spray gun set-up:
1.2-1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap

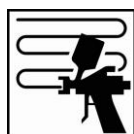


1 coat



Flash off time:
15 minutes at 20°C

Recoat within:
24 hours at 20°C



Recoatable with all Sikkens topcoats



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Description

High-build, isocyanate free, two-pack sanding filler and non sanding surfacer with extremely fast air and force drying properties. Autosurfacer Rapid has excellent application and sanding properties and provides good enamel hold-out with all Sikkens topcoats.

Suitable substrates

Existing finishes	OEM electrocoat (sanded)
Steel	Glass Reinforced Polyester laminates (GRP)
Galvanized steel	Polyester bodyfillers
Aluminium	Sikkens Polysurfacer
Washprimer 1K CF	

Autosurfacer Rapid will provide adequate adhesion if applied directly to steel. However, we advise for systems which should meet the highest standards to apply Autosurfacer Rapid over Sikkens washprimer. Allow for a minimum of 15 minutes flash-off time at 20°C after washprimer application.

Product and additives

	Autosurfacer Rapid Light Grey Autosurfacer Rapid Dark Grey	
Hardeners	Autosurfacer Rapid Hardener Autosurfacer Rapid Hardener HT:	temperature range 35°C-45°C
Reducers	Autosurfacer Rapid Non Sanding Reducer	
	Plus Reducer Fast:	spot and panel repairs, temperature range: 15°C-25°C
	Plus Reducer Medium:	spot / panel repairs and large areas, temperature range: 20°C-30°C
	Plus Reducer Slow:	larger areas and complete paint jobs, temperature range: 25°C-35°C
	Plus Reducer Extra Slow:	temperature range: above 35°C
	High Performance Reducer Fast:	spot and panel repairs, temperature range: 60°F-75°F
	High Performance Reducer Medium:	spot / panel repairs and large areas, temperature range: 70°F-85°F
	High Performance Reducer Slow:	larger areas and complete paint jobs, temperature range: 80°F-95°F
	High Performance Reducer Extra Slow:	temperature range: above 95°F
Additives	Autocryl Structure Paste (Fine): Elast-o-Activ:	See TDS 6.27, 6.29. See TDS S8.06.03c

Basic raw materials

Autosurfacer Rapid:	Special acrylic resins
Autosurfacer Rapid Hardener:	Blocked polyamines of high molecular weight
Autosurfacer Rapid Hardener HT:	Blocked polyamines of high molecular weight with slower solvents

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Surface preparation



Remove contamination using an appropriate cleaner



Final sanding step P220 - P320
See TDS S8.06.02 for sanding specifications



Remove contamination using an appropriate cleaner
Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Stir before use



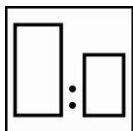
Stir Autosurfacer Rapid thoroughly before use.

Tinting

Autosurfacer Rapid can be tinted with up to 10 parts by volume of Autocryl, Autocryl Plus or Autocryl Plus LV MM toners.

Mixing Autosurfacer Rapid Light / Dark grey

Autosurfacer Rapid LightGrey and Dark Grey can be mixed in different ratios.
In the next table Quick-Mix grey shades are shown.



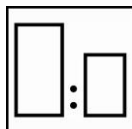
Light Grey : Dark Grey		
100 : 0	Light grey	
100 : 50	Medium light grey	
100 : 100	Medium grey	
50 : 100	Medium dark grey	
0 : 100	Dark grey	

Autosurfacer Rapid mixtures must be stirred thoroughly before adding hardener.
Stir thoroughly once more before adding additional reducer (if required).

Autosurfacer Rapid

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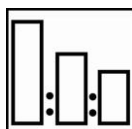
Mixing



Sanding / Rolling:

100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener (HT)

Use measuring stick 1 or 12



Non sanding:

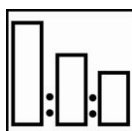
100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener (HT)
40 Plus Reducers

Use measuring stick 12

Non sanding (EU VOC Directive):

3 Autosurfacer Rapid
1 Autosurfacer Rapid Hardener (HT)
2 Autosurfacer Rapid Non-Sanding Reducer

Use measuring stick 15



Non sanding:

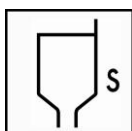
100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener (HT)
40 High Performance Reducers

Use measuring stick 12

Flexible parts

Once elasticized to the required level, Autosurfacer Rapid can be applied on plastic parts. All virgin plastic parts should be pre-coated with a suitable plastic primer.
See TDS.S8.06.3c.

Viscosity



Sanding / Rolling
21-24 seconds Din Cup 4 at 20°C

Non Sanding / with Elast-o-Actif
16-18 seconds Din Cup 4 at 20°C

Spray gun set-up / application pressure



Spray gun

Gravity feed

Gravity feed

Fluid tip-set-up

Sanding
1.5-2.0 mm

Non sanding
1.2-1.4 mm

Application pressure

1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

1.7-2.2 bar at the spray gun air inlet
HVLP max 0.6-0.7 bar at the air cap

Pot-life

Autosurfacer Rapid:
Autosurfacer Rapid with Hardener HT:
Autosurfacer Rapid non sanding:
Autosurfacer Rapid with Elast-o-Actif:

30 minutes at 20°C
30 minutes at **35°C**
60 minutes at 20°C
60 minutes at 20°C

Autosurfacer Rapid

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Application



Sanding

Spot application:

Apply one coat over the total sanded area. Flash off until completely matt and apply the 2nd and 3rd coat within each preceding coat. Flash off until completely matt after each coat.

Panel application:

Apply 2-3 coats and flash off until completely matt after each coat.

Non sanding

Apply 1 full wet coat over the total area.

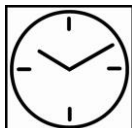
Optional application; apply one thin coat, followed by a full wet coat.

Rolling

Apply one coat over the total sanded area. Flash off until completely matt and apply the 2nd and 3rd coat within each preceding coat. Flash off until completely matt after each coat.

Use the edge of the roller to prime awkward areas (door handle). Finally, squeeze remaining paint from roller and smooth off the repair. The rolling should be executed from the outside in an inward direction. Each additional coat should be started within the preceding coat area.

Drying time sanding



45 minutes at 20°C

30 minutes at 40°C

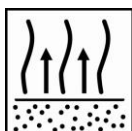
20 minutes at 60°C

Drying time Autosurfacer Rapid Hardener HT: 45 minutes at 35°C



Allow 5 minutes flash off prior to infra red curing
The panel temperature should not exceed 100°C.
For additional information, see TDS S9.01.01

Flash off time non sanding



Allow for a minimum flash off time of 15 minutes before topcoat application.
Apply topcoat within 24 hours at 20°C

Should this maximum time be exceeded, abrade the surface with P500 dry sanding paper.

Denibbing non sanding

For minor defects (e.g. dust) Autosurfacer Rapid can be denibbed with either P500 dry or P1000 wet sanding paper.

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Final sanding



Final sanding step P500

For detailed information see TDS S8.06.02



Final sanding step P1000

For detailed information see TDS S8.06.02



Sanding in case of roller application

Block sand with P360 - P400 grit to remove the coarser surfacer structure.
Work from the centre of the repair to the outer edges (inside out).



Remove contamination using an appropriate cleaner.

Recoatable with

All Sikkens topcoats

Film thickness

Sanding	per coat	40 - 50 µm
	3 coats	120 - 180 µm
Rolling application	per coat	30 - 40 µm
	3 coats	90 - 120 µm
Non sanding	1 coat	20 - 25 µm

Theoretical Coverage

Sanding:	Ready for use mixture at 1 µm dry film thickness:	m²/liter ±354
Non sanding:	Ready for use mixture at 1 µm dry film thickness:	±353

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Sikkens Solvent or solvent borne guncleaners

VOC

2004/42/IIb(c)(540)540

The EU limit value for this product (product category: IIb. c) in ready to use form is max. 540 g/liter of VOC.
The VOC content of this product in ready to use form is max. 540 g/liter.

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Product storage

Product shelf-life is determined when products are stored unopened at 20°C
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

Akzo Nobel Car Refinish bv.
Address: Rijksweg 31, PO Box 3, 2170 BA Sassenheim
Tel: +31(0)71308-6944

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com