

Autosurfacers Rapid

Autosurfacers Rapid is a high build, two-component, isocyanate free primer surfacer that is used as a sanding primer. It provides fast air drying or baking performance. Autosurfacers Rapid can be under all Sikkens primer sealers and top coats. Autosurfacers Rapid provides excellent application and sanding properties and very good enamel-hold out in combination with all Sikkens topcoats.



Safety Considerations

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.



Surface Preparation

- Existing Finishes
 - Steel
 - Zinc Coated Steel
 - Aluminum
 - Unbroken Fiber Glass Gelcoat
 - Body Filler
- #P220 to #P320 grit sandpaper dry
 - #P80 then #P120 grit sandpaper dry
 - #P150 to #P180 grit sandpaper dry
 - #P180 sandpaper dry or a red scuff Pad
 - #P220 to #P320 grit sandpaper dry
 - #P180 to #P220 grit sandpaper dry



STICK # 1

- | | |
|------------|-----------------------------------|
| Mix | By Volume |
| 100 | Parts Autosurfacers Rapid |
| 50 | Part Autosurfacers Rapid Hardener |



Spray-Gun Set-Up

- 1.7–2.0mm HVLP Gravity

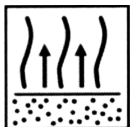
Application Air Pressure

- HVLP – 10 psi (0.68 bar) at cap maximum.
- Consult manufacturers' specifications.



Application

- 2 – 3 x 1 Coats (2 to 3 single wet coats).



Flash Between Coats at 70°F (21°C)

- 5 – 7 minutes.

Flash Before Force Drying at 70°F (21°C)

- 5 – 7 minutes.



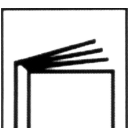
Air Drying at 70°F (21°C)

- Dry to sand in 45 minutes

Force Drying at 140°F (60°C)

- Dry to sand in 20 minutes

Dependent of film weight and air flow.



Recoating

After sanding Autosurfacers Rapid may be recoated with the following materials.

- All Sikkens primer sealers
- Sikkens Autobase Plus basecoat
- Sikkens Autowave basecoat

Read complete the complete TDS and the product Safety Data Sheet (SDS) for detailed product information.

Description

Autosurfacer Rapid is a high build, two-component, isocyanate free primer surfacer that is used as a sanding primer. It provides fast air drying or baking performance. Autosurfacer Rapid can be under all Sikkens primer sealers and top coats. Autosurfacer Rapid provides excellent application and sanding properties and very good enamel-hold out in combination with all Sikkens topcoats.

Suitable Substrates



- Steel
- Galvanized steel
- Aluminum
- Fiberglass gelcoat (Unbroken)
- Polyester body filler
- Existing finishes (Except acrylic lacquers)
- Sikkens Washprimer 1K-CF
- Sikkens Autosurfacer EPII
- Sikkens Primer PO

- Although Autosurfacer Rapid will provide adequate adhesion on bare metal, repairs that require extensive metal priming should have Sikkens Washprimer 1K-CF applied to enhance adhesion and corrosion protection.
- Do not apply Autosurfacer Rapid over the AkzoNobel AutoPrep Pretreatment Wipe material.

Products and Additives

- | | | |
|----------------|---------------------------------|----------------|
| Product | • Autosurfacer Rapid Dark Grey | – Item #391613 |
| | • Autosurfacer Rapid Light Grey | – Item #391612 |

- | | | |
|------------------|-------------------------------|----------------|
| Hardeners | • Autosurfacer Rapid Hardener | – Item #391614 |
|------------------|-------------------------------|----------------|

- | | | |
|------------------|-----------------|----------------|
| Additives | • Elast-O-Actif | – Item #386100 |
|------------------|-----------------|----------------|

- SDS and TDS for products available online at – <http://my.anaac.net/>

Basic Raw Materials

- | | | |
|----------------|-------------------------------|--------------------------|
| Product | • Autosurfacer Rapid | – Aceto-acetate modified |
| | • Autosurfacer Rapid Hardener | – Blocked polyamines |

Substrate Preparation



Pre-Cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with M600 Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant) or Anti-Static surface cleaners.



Sanding Preparation

Dry Sanding

Additional Preparation

• OEM E-Coat	#P220 to #P360	
• Polyester Bodyfiller	#P180 to #P220	
• Steel	#P80 then #P120	✓ Pre-Coat with Sikkens Washprimer 1K-CF to enhance adhesion and corrosion protection.
• Zinc Coated Steel	#P150 to #P180	
• Aluminum	#P180 or red scuff pad	
• Gel-Coat	#P220 to #P360	
• Polyolefin Plastic	#P320 to #P400	✓ Pre-Coat with Sikkens Primer PO
• Non-Polyolefin Plastic	#P320 to #P400	
• Existing Finishes	#P220 to #P360	

- Respect a maximum 100 sanding grit step difference throughout a dry sanding process.
- Respect a maximum 100 sanding grit step difference throughout a wet sanding process.



Surface Cleaning – Prior to Paint Application

- Clean with M600 Surface Cleaner, AutoPrep Ultra-Prep (VOC compliant) or Anti-Static surface cleaners.

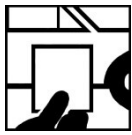
Product Agitation



Stirring

- Because Autosurfacer Rapid is a high solids paint it needs to be agitated before use.
- Stir or shake vigorously before each use.

Mixing Color Formulas and Products



Formulas

- Autosurfacer Rapid Light Grey and Dark Grey can be intermixed before adding hardener to make a variety of grey shades. These combinations can be mixed easily either by volume with a Sikkens mixing stick or by weight.

Light Grey : Dark Grey



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

Mixing

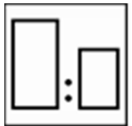


BY VOLUME
STICK #1

100
50

Standard Mix

Parts Autosurfacer Rapid
Parts Autosurfacer Rapid Hardener



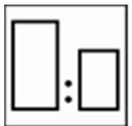
BY VOLUME
STICK #9

3
1

Flexed Mix (Flexible or Soft Parts)

Parts Autosurfacer Rapid Primer
Parts Elast-O-Actif

-STIR TOGETHER THEN-

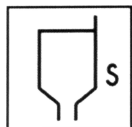


BY VOLUME
STICK #1

100
50

Parts Mixture of Autosurfacer Rapid Primer and Elast-O-Actif
Parts Autosurfacer Rapid Hardener

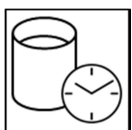
Viscosity – Ready to Spray



21-24
Seconds

Measured with a DIN #4 viscosity cup at 70°F (21°C).

Pot-Life When Mixed



Product Mix

70°F (21°C)

- Autosurfacer Rapid – 30 minutes

Spray Gun Set-Up

Consult spray gun manufactures instructions for specific spray gun pressure specifications.



Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Fed	1.7 – 2.0mm	<10 psi (0.68 bar) at cap.

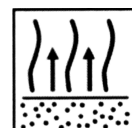
Application



Overall Application

- Apply two to three single wet coats depending on build required.
- Allow a flash off time between coats of 5 to 7 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

Flash Drying



Flash Before Force Drying at 70°F (21°C)

- 5-7 minutes.
 - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

Drying / Curing Time

Drying times are stated a recommended application method, film thickness and object temperature.



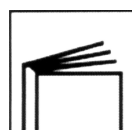
	Autosurfacers Rapid	Autosurfacers Rapid - Flexed
• Drying at 70°F (20°C)	Dry to Sand – 45 minutes	Dry to Sand – 6+ Hours
• Drying at 100°F (38°C)	Dry to Sand – 30 minutes	–
• Drying at 140°F (60°C)	Dry to Sand – 20 minutes	Dry to Sand – 20 minutes

Drying / Curing – IR



	Low Power Flash	Full Power Curing
• Autosurfacers Rapid	5 minutes	10 minutes

Recoating



After the stated dry time and sanding Autosurfacers Rapid may be recoated with the following materials.

- All Sikkens primer sealers
- Sikkens Autobase Plus basecoat
- Sikkens Autowave basecoat

Cleaning of Equipment



- Clean equipment and dispose of waste following local and federal regulations. In compliant localities, use a VOC compliant high quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

Film Thickness – Using Suitable Application



- 1 Coat will achieve a thickness of 1.8 mils (45μm) dry.

Theoretical Coverage



- With the recommended application the theoretical material usage is ±562 feet²/gallon (14 meters²/liter) at a 1 mil thickness (24.5 μm).
- Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.

VOC / Regulatory Information



Product	VOC Lbs./ Ga.	VOC Gr./Lt.
• Autosurfacer Rapid (Ready to Spray)	– 4.61	– 552
• Autosurfacer Rapid with Elast-O-Actif (RTS)	– 4.77	– 571
<ul style="list-style-type: none"> • Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist. 		

Product Storage



- Store unopened, or products in use with approved closed containers and proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).
- Autosurfacer Rapid – 2 Years
- Autosurfacer Rapid Hardener – 2 Years



North America

Autosurfacer Rapid

Technical Data Sheet

Primers

07/19/18

FOR PROFESSIONAL USE ONLY

AkzoNobel Inc., North America

Address: 1845 Maxwell Street – Troy, MI USA

Telephone: 800.618.1010

FOR PROFESSIONAL USE ONLY

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 Safety 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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