



North America

Technical Data Sheet


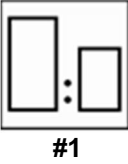


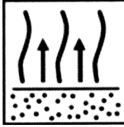
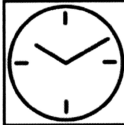
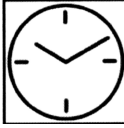
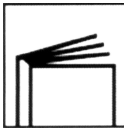
Autosurfacers 2+1 HS™

Primer / Surfacer


06.04.2015

FOR PROFESSIONAL USE ONLY**Description**

Autosurfacers 2+1 HS is a high solids two part acrylic urethane primer surfacer with exceptionally high build for collision repair refinishing work. This product provides easy wet and dry sanding after short drying times. The acrylic urethane character provides minimal or no shrinkage while maintaining enamel hold out when topcoated.

	Safety Considerations Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Material Safety Data Sheet (MSDS) for more complete safety information.	
	Mixing 2 1	Autosurfacers 2+1 HS Autosurfacers 2+1 HS Hardener
	HVLSP or Compliant Spray-Gun Set-Up: 1.9-2.2 mm	Application Air Pressure: Consult spray gun manufacturers' specifications. HVLSP – 10 psi at the air cap maximum.
	Application 1 - 3 coats	
	Flash Between Coats at 70°F (21°C) 5-10 minutes	Flash Before Force Drying at 70°F (21°C) 5-10 minutes
	Air Drying at 70°F (20°C) 3 hours	
	Force Drying at 140°F (60°C) 30 minutes	Infra-Red Flash 5 minutes Low Power for 5 minutes followed by Full Power 8-10 minutes
	Re-Coatable after sanding with: <ul style="list-style-type: none"> • Sikkens Urethane Sealers • Sikkens Basecoats • Sikkens Single Stage Topcoats 	

Read complete TDS for detailed product information.

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Suitable Substrates

- Existing finishes, degreased and sanded with #P220 to #P320 grit dry
- Premium polyester bodyfiller sanded with #P180 to #P220 grit dry
- Steel, degreased and sanded with #P80 followed by #P120 grit dry
- Fiberglass gelcoat, degreased and sanded with #P220 to #P320 grit dry
 - If the gelcoat is broken and has been sanded through, under no circumstances should Autosurfacers 2+1 be applied. Application of Polysurfacers is recommended.



Products and Additives

Product	Autosurfacers 2+1 HS Item #398181
Hardeners	Autosurfacers 2+1 HS Hardener Item #398182
Additives	Autocryl Elast-o-Actif Item #386100

Basic Raw Materials

- Autosurfacers 2+1 HS – acrylic resins
- Autosurfacers 2+1 HS Hardener – polyisocyanate resins

Substrate Preparation

	<p>Surface Cleaning – Prior to Paint Application</p> <ul style="list-style-type: none"> • Clean with Sikkens M600, AutoPrep Ultra Prep or Anti-Static surface cleaners.
	<p>Bare Metal Pre-Treatment</p> <ul style="list-style-type: none"> • Autosurfacers 2+1 HS provides adequate adhesion to small bare metal areas. For larger areas or for improved corrosion protection Color Build Plus should be applied over a metal pre-treatment such as the AutoPrep Pre-Treatment Wipes or AutoPrep pen materials.





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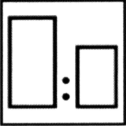
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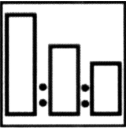
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Mixing

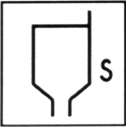
 <p>#1 Stick</p>	2	Parts by volume Autosurfacers 2+1 HS Parts by volume Autosurfacers 2+1 HS Hardener The use of accelerators is not recommended .
	1	

Mixing – Flexible Parts

If the part to be painted can be deformed by hand, increase the flexibility of Autosurfacers 2+1 as follows.

 <p>### Stick</p>	3	Parts by volume Autosurfacers 2+1 HS Parts by volume Autocryl Elast-o-Actif Mix thoroughly and complete mixing as follows:
	1	
	2	Parts by volume Autosurfacers 2+1 HS / Autocryl Elast-o-Actif Parts by volume Autosurfacers 2+1 HS Hardener
	1	


Viscosity When Mixed

	15 – 16 seconds when measured with a DIN #4 viscosity cup at 70°F (21°C)
	15 – 19 seconds when measured with a EZ Zahn #2 viscosity cup at 70°F (21°C)

Pot-Life When Mixed

Product Mix	70°F (20°C)	95°F (35°C)
Autosurfacers 2+1 HS	90 minutes	60 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	1.8-2.2mm	<10 psi at cap
	Compliant Gravity Fed	1.8-2.2mm	<10 psi at cap





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Application



Apply 1 to 3 coats

Allow a flash off time between coats of 5-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.

Film Thickness – Using Suitable Application

1 Coat will achieve a thickness of 2.2-2.5 mils (55 – 62.5µm).

Drying / Curing Time

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

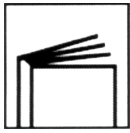
		70°F (20°C)	140°F (60°C)
	Dry to Sand	3 hours	30 minutes



Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).

- Allow 5 minutes flash off before infra-red curing.
- Cure 5 minutes on low power followed directly by 8-10 minutes full power cure.

Recoating




After sanding and degreasing, Autosurfacer 2+1 HS can be coated with Sikkens Urethane primers, Sikkens Basecoat / Clearcoat systems or Sikkens Topcoats.

Cleaning of Equipment



Clean equipment following local and federal regulations.



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Theoretical Coverage

	<p>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.</p> <ul style="list-style-type: none"> • Ready to spray at 1 mil with 100% transfer efficiency is 23.9 sq feet / liter
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VOC / Regulatory Information

	VOC of the ready to spray mixture is 4.3 lbs/gal (490 g/L)
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Product Storage

	Stock unopened or used products in approved closed containers with 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 (20°C).	
	Autosurfacers 2+1 HS	2 years
	Autosurfacers 2+1 HS Hardener	1 year

AkzoNobel Coatings Inc,

Vehicle Refinishes

Address: 1845 Maxwell Street – Troy, MI USA

Telephone: 800.618.1010

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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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