

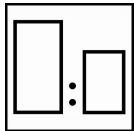
Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Description

High-build, isocyanate free, two-pack sanding primer filler and wet-on-wet 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



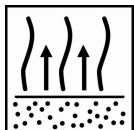
Spray gun set-up:
1.5-2.0 mm

Application pressure:

28-30 psi (1.7-2.2 bar) at the air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap



1-3 x 1 coat



Between coats:

5-7 minutes at 70°F (20°C)

Before curing:

5-7 minutes at 70°F (20°C)



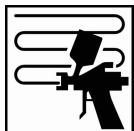
45 minutes at 70°F (20°C)

20 minutes at 140°F (60°C)

3 coat application



Final sanding step: P500
See TDS S8.06.01



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

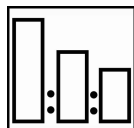
Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Description

High-build, isocyanate free, two-pack sanding primer filler and wet-on-wet 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.

Wet-on-wet (non sanding) application (EU VOC Directive)



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



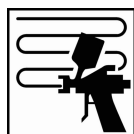
Use Sikkens measuring stick

15 Green

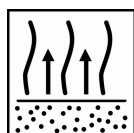


Spray gun set-up:
1.2-1.4 mm

Application pressure:
28-30 psi (1.7-2.2 bar) at the air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

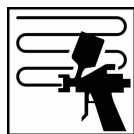


1 coat



Flash off time:
15 minutes at 70°F (20°C)

Recoat within:
24 hours at 70°F (20°C)



Recoat with all Sikkens topcoats



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

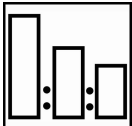
Autosurfacers Rapid

FOR PROFESSIONAL USE ONLY

Description

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

Wet-on-wet (non sanding) application



100 Autosurfacers Rapid
50 Autosurfacers Rapid Hardener
40 Plus Reducer / High Performance Reducer



Use Sikkens measuring stick

12 Green



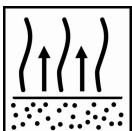
Spray gun set-up:
1.2-1.4 mm

Application pressure:

28-30 psi (1.7-2.2 bar) at the air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap



1 coat



Flash off time:
15 minutes at 70°F (20°C)

Recoat within:
24 hours at 70°F (20°C)



Recoatable with all Sikkens topcoats



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

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Description

High-build, isocyanate free, two-pack sanding primer filler and wet-on-wet 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 electro coat (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 70°F (20°C) after Washprimer application.

Autosurfacer Rapid can be applied on plastics parts which have been preceded by, 1K All Plastics Primer, 2K Plastic Primer or Primer PO.

Product and additives

Autosurfacer Rapid (Light Grey - Dark Grey)

Hardeners Autosurfacer Rapid Hardener
Autosurfacer Rapid Hardener HT; to use at temperatures of 95°F-115°F (35°C-45°C).

Reducers Plus Reducer Fast, spot / 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

Autosurfacer Rapid Non Sanding Reducer

High Performance Reducer Fast, spot / 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); additive to create different surface textures; TDS 6.27, 6.29.
Elast-o-Actif, ; to elasticize Autosurfacer Rapid making it suitable for plastic parts. See S8.06.03

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



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner. *Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.*



Sanding; final dry sanding steps; P220 - P320
Rigid OEM electro coated parts; final dry sanding steps; P220 - P320
Sikkens polyester bodyfillers and Polysurfacer; finished with; P180 - P220
Featheredge sanding for spot repair, finish outer area with P400
For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Autosurfacer Rapid using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

Stir before use



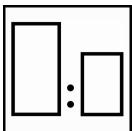
Stir Autosurfacer Rapid thoroughly before mixing.

Tinting

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

Mixing Autosurfacer Rapid Light/Dark grey

Autosurfacer Rapid Light- and Dark Grey can be mixed in different mixing ratios. In the next table Quick-Mix grey shades are visible. They can easily be mixed by volume or by weight.



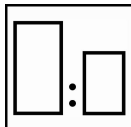
Light - Dark		
100 : 0	Light grey	
100 : 50	Medium light grey	
100 : 100	Medium grey	
50 : 100	Medium dark grey	
0 : 100	Dark grey	

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

Autosurfacer Rapid

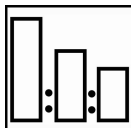
FOR PROFESSIONAL USE ONLY

Mixing



Sanding / Rolling:

100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener (HT)

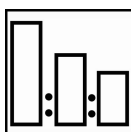


Non sanding:

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

Non sanding (EU VOC Directive):

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



Non sanding:

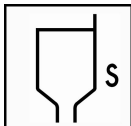
100 Autosurfacer Rapid
50 Autosurfacer Rapid Hardener (HT)
40 High Performance Reducers

Flexible parts

Once elasticized to the required level, Autosurfacer Rapid can be applied on plastic parts. All flexible plastic parts should be pre-coated with a suitable plastic primer (in the case of virgin plastic), or OEM finish.

See TDS.S8.06.3c.

Viscosity



Sanding / Rolling
21-24 seconds Din-cup 4 at 70°F (20°C).

Non Sanding / with Elast-o-Actif
16-18 seconds Din-cup 4 at 70°F (20°C).

Spray gun set-up / application pressure



Spray gun

Fluid tip-set-up

Application pressure

Gravity feed

Sanding
1.5-2.0 mm

28-30 psi (1.7-2.2 bar) at the spray gun air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

Gravity feed

Wet on wet
1.2-1.4 mm

28-30 psi (1.7-2.2 bar) at the spray gun air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

For maximum build use a larger fluid tip and lower the application pressure.

Pot-life

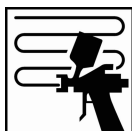
Autosurfacer Rapid:
Autosurfacer Rapid with Hardener HT:
Autosurfacer Rapid non sanding/wet-on-wet:
Autosurfacer Rapid with Elast-o-Actif:

30 minutes at 70°F (20°C).
30 minutes at **95°F (35°C)**.
60 minutes at 70°F (20°C).
60 minutes at 70°F (20°C).

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Application



Sanding

Apply one coat over the total sanded area. Next apply the 2nd and 3rd coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.

Allow each coat to flash-off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry by air support

Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow. For maximum build use a larger fluid tip and lower the application pressure.

Wet-on-wet (non sanding/sealer)

Apply 1 full wet coat over the total area.

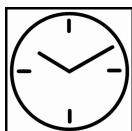
Optional application; apply one thin coat, followed by a full wet coat.

Rolling

Apply one light coat over the total sanded area. Next apply the 2nd and 3rd coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build. 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.

Allow each coat to flash-off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry with air support. Flash-off between the coats is dependent on ambient temperature, applied layer thickness.

Drying time sanding



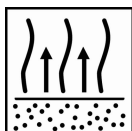
45 minutes at 70°C (20°C). 30 minutes at 100°F (40°C). 20 minutes at 140°F (60°C).

Drying times relate to recommended application (3 coats) and object temperature.
Drying time Autosurfacer Rapid Hardener HT; 45 minutes at 95°C (35°C).



Allow 5 minutes flash off prior to infra red curing
The panel must not reach a temperature above 212°F (100°C) while curing.
For additional infra red drying information; see TDS S9.01.01

Flash off time wet-on-wet (non sanding/surfacer)



Allow for a minimum flash off time of 15 minutes at 70°C (20°C) prior to topcoat application.
Apply topcoat within 24 hours at 70°C (20°C).

Should this maximum time be exceeded, abrade the surface with P500 dry or P1000 wet sanding paper.

Denibbing wet-on-wet (non sanding/surfacer)

For minor defects (e.g. dust) Autosurfacer Rapid can be denibbed with either P500 dry or P1000 wet sanding paper. After a drying time of longer than 24 hours thorough sanding is necessary!

Autosurfacer Rapid

FOR PROFESSIONAL USE ONLY

Final sanding



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Sanding in case of roller application

Pre sand by block with a coarser sanding grit; free-cut P360 - P400 In order to remove the coarser surfacer structure due to roller application. Sanding is best executed working from the centre of the repair to the outer edge (inside out).



Surface cleaning; remove any surface contamination prior to the application of the topcoat using an appropriate surface cleaner.

Recoatable with

All Sikkens topcoats

Film thickness

Sanding	per coat	1.5 - 2.4 mils	40 - 50 µm
	3 coats	6.6 - 7.5 mils	120 - 180 µm
Rolling application	per coat	1.1 - 1.5 mils	30 - 40 µm
	3 coats	3.5 - 4.7 mils	90 - 120 µm
Wet-on-wet	1 coat	0.7 - 1.0 mils	20 - 25 µm

Theoretical Coverage

	sq.ft/liter	m ² /liter
Sanding: Ready for use mixture at 1 µm dry film thickness:	±3810	±354
Wet-on-wet: Ready for use mixture at 1 µm dry film thickness:	±3800	±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 Solvents or solvent borne guncleaners

VOC

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.

Product storage

Product shelf-life is determined when products are stored unopened at 70°F (20°C). Avoid extreme temperature fluctuation.

- Product shelf life data see TDS S9.01.02

Autosurfacers Rapid

FOR PROFESSIONAL USE ONLY

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

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 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.

Coating brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

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