2K RAPID FILLER

FAST DRYING 2K SURFACER - D857
HARDENER - D858

PRODUCTS

2K Rapid Filler - Fast Drying 2K Surfacer	D857
2K Rapid Filler Hardener	D858
Deltron Thinners	D808, D866, D812, D869

PRODUCT DESCRIPTION

2K Rapid Filler is a pale green 2K surfacer with high film-build and fast air-drying properties. Suitable for use under any PPG refinish topcoat, 2K Rapid Filler may be applied as either a high-build or an isolating surfacer simply by adjusting the quantity of thinner in the mix.

When used as a high build surfacer, 2K Rapid Filler offers up to 250µ film build and is sandable after 3 hours airdry at 20°C. As an isolating primer, 2K Rapid Filler offers approx. 100µ and is sandable after only 2 hours at 20°C.

2K Rapid Filler can be applied over suitably prepared polyester fillers, over sound, fully cured original paintwork, bare steel and adhesion primers. 2K Rapid Filler may be air-dried, low baked or IR cured.

PREPARATION OF SUBSTRATE

In all cases, select the appropriate PPG cleaner(s) from the guide below, and ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Bare Steel should be lightly abraded and completely rust free before application. 2K Rapid Filler may be applied directly, but Universel Chromate-free Wash Primer (D831/D832), 2+1 High Build Wash Filler (D855/D856) or DP40 Chromate-free 2K Epoxy Surfacer (D834/D835) should be applied first where optimum adhesion and corrosion resistance is required.

Other Bare Metals should be primed with either Universel Chromate-free Wash Primer (D831/D832), 2+1 High Build Wash Filler (D855/D856) or DP40 Chromate-free 2K Epoxy Surfacer (D834/D835).

Original paintwork or Primers should be sanded using P280 grade discs (dry) or P360 grade paper (wet). Spot prime any exposed bare metal with either Universel, 2+1 or DP40 (see above).

Polyester Fillers should be dry sanded using a paper grade suited to the application of 2K Rapid Filler that will follow (see overleaf) :

Sequence P80 - P120 when using 2K Rapid Filler as a High Build Surfacer (2-4 coats).
Sequence P80 - P120 - P240 when using 2K Rapid Filler an Isolating Surfacer (1-2 coats).

GUIDE TO SELECTION OF SUBSTRATE CLEANERS

Code	*Product*	*Purpose*
D845	DX310 High-Strength Degreaser	For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work, and on any bare metal substrate.
D837	DX330 Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.
D842	DX380 Low-VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimised.

APPLICATION GUIDE

For use as a :	HIGH BUILD SURFACER	ISOLATING SURFACER
Mixing Ratio :	D857 : 3 vol D858 : 1 vol Thinner : 10% by volume	D857 : 3 vol D858 : 1 vol Thinner : 1 vol
Thinner Selection :	*Temperature* / *Thinner* Up to 18ºC — D808 Fast Thinner 18 - 25ºC — D866 2K Primer Thinner 25 - 35°C — D812 Slow Thinner Over 35°C — D869 Very Slow Thinner	
Potlife at 20°C	30 - 45min	45 - 60min
Spray Viscosity DIN4 / 20°C	45 secs	25 secs
Spraygun Setup : Gravity	1.8mm	1.6mm
Suction	Not Recommended	1.8mm
Spray Pressure :	4 bar	4 bar
Number of coats :	2 - 4	1 - 2
Flash off at 20 °C : between coats	10 min	5 min
before stoving	10 min	5 min

APPLICATION GUIDE ctd

	HIGH BUILD SURFACER	ISOLATING SURFACER
mix ratio :	3 : 1 : 10%	3 : 1 : 1
Drying times :		
dust-free at 20°C	15 min	10 min
sandable at 20°C	3 hours	2 hours
through-dry at 60°C	30 min	30 min
through-dry with IR medium	10 min	10 min
note :	* Stoving time required once metal reaches the quoted temperature. Stoving schedule should allow additional time for metal to reach this temperature.	
Total dry film build :		
minimum	150µ	75µ
maximum	250µ	100µ
Theoretical coverage †:	approx. 3m²/lt	approx. 8m²/lt
note :	† Theoretical coverage in ready-to-spray litres, giving a dry film thickness between indicated minimum and maximum values.	
Sanding :		
grade dry	P240 followed by P360	P240 followed by P360
grade wet	P600 followed by P800	P600 followed by P800
Overcoat with :	Any PPG 2K Topcoat	

PERFORMANCE AND LIMITATIONS

The use of HVLP spray equipment can give an increase in transfer efficiency of around 10% depending upon the make and model of equipment used.

When spot priming with 2K Rapid Filler, adopt the following procedure :
1. Ensure that the surface is thoroughly sanded to the panel edge or to a distance several centimetres beyond the damaged area, whichever is the smaller.
2. Apply a suitable number of coats to the damaged area, allowing the correct flash-off times. Apply the final coat of material activated and thinned at 3 : 1 : 2, covering a larger area that fully wets out the previous overspray edge.
3. During sanding, be careful to thoroughly level the repair edge.

Under no circumstances should 2K Rapid Filler be overcoated wet-on-wet. Allow the recommended drying schedule before sanding and overcoating.

Use only D858 2K Rapid Filler Hardener with D857 2K Rapid Filler. Deltron Accelerator D818 should not be used with 2K Rapid Filler.

2K Rapid Filler D857 and 2K Rapid Filler Hardener D858 are sensitive to moisture, so all equipment should be perfectly dry. Where humidity is in the range 70-80%, use of Very Slow Thinner D869 is recommended. Do not attempt to use 2K Rapid Filler at humidity levels exceeding 80%.

Part used cans of hardener must be carefully closed.

After use, clean spray equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

- For comprehensive Health, Safety and Environmental advice, please refer to relevant Material Safety Data Sheets and Product Can labels.

FLASH POINTS

Deltron Thinners D866, D869	}	21°C - 55°C
2K Rapid Filler Surfacer D857	}	
2K Rapid Filler Hardener D858	}	Below 21°C
Deltron Thinners D808, D812	}	

This product is for professional use only.

Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.

PPG Industries (UK) Ltd,
Rotton Park Street,
Ladywood,
Birmingham, B16 0AD,
England

Tel: 0121 455 9866
Telex: 339266 PPGLAD G
Fax: 0121 454 0848