FILLERS

GALVAPLAST 77	A656
GALVAPLAST SLOW	A663
IVIPLAST 66	A652
P.E. STOPPER	A661
EXTRA LIGHT	A659
PINHOLE FILLER	A655
PUTTY V.B.A. BEIGE	A242

PRODUCTS

Galvaplast 77	- Multi Purpose Polyester Filler	A656
Galvaplast Slow	- Multi Purpose Polyester Filler, Slow	A663
Iviplast 66	- Flexible Polyester Putty	A652
P.E. Stopper	- Standard Polyester Stopper	A661
Extra Light	- Light Polyester Filler	A659
Pinhole Filler		A655
Putty V.B.A. Beige	- Acrylic Stopper Beige	A242
Hardener for A656, A652, A661 & A659	- for can	A665
	- for small cartridge	A666
	- for large cartridge	A667

PRODUCT DESCRIPTION

Galvaplast 77 is a light grey, premium quality polyester bodyfiller that offers outstanding adhesion to any metal substrate - including galvanised or zinc-coated steel, stainless, aluminium and fibreglass. Its excellent sag resistance makes it particularly easy to apply to vertical surfaces. Smooth in application, fast drying and easy to sand, Galvaplast 77 is particularly versatile and easy to use.

Galvaplast Slow is a premium quality multi-purpose polyester bodyfiller with outstanding qualities of adhesion to all metal substrates. Its extended potlife makes it suitable for application to large surfaces and for use in high-temperature environments.

Iviplast 66 is a fine, flexible polyester bodyfiller that offers excellent adhesion to both rigid and deformable plastics. Like the substrates it is designed to repair, Iviplast 66 offers good resistance to light impacts and stonechips that can frequently damage lower external bodywork and trim.

P.E. Stopper is a light beige medium-textured polyester bodyfiller that is easy to apply, quick-drying and easy to sand. P.E. Stopper is suitable for general purpose use and may be applied over bare steel, fibreglass, GRP and other primed or painted surfaces.

Extra Light is a low density polyester bodyfiller that is exceptionally easily applied and worked, even over major surface imperfections. Smooth and consistent, and offering good flexibility and impact resistance, Extra Light may be used over bare steel, painted surfaces, fibreglass and GRP.

Pinhole Filler is a very light single-component filler. It is suitable for minor filling work on rough or irregular surfaces over which a smooth, high-gloss paint finish is required. Pinhole Filler is ideal for moulded surfaces, especially plastics.

Putty V.B.A. Beige is a light single-component acrylic stopper, suitable for the quick repair of minor surface scratches or imperfections. V.B.A. Putty can be used over paintwork, primer or filler, and is ideal for the quick repair of minor preparation defects.

SURFACE PREPARATION

The matrix indicates those surfaces which may be directly overcoated by each PPG Filler, and where appropriate the abrasive grade with which the surface should be dry-sanded before application.

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.

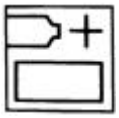
	Galvaplast 77 A656	**Galvaplast Slow A663**	**Iviplast 66 A652**	**P.E. Stopper A661**	**Extra Light A659**	**Pinhole Filler A655**	**Putty VBA Beige A242**
New hot-rolled steel	shot blasting	shot blasting	No	No	No	No	No
New cold-rolled steel	Yes *P80-P120*	Yes *P80-P120*	No	No	No	No	No
Sound Paintwork	Yes *P280-P320*	Yes *P280-P320*	Yes *P360*	Yes *P280-P320*	Yes *P280-P320*	Yes *scotchbrite*	Yes *P360*
Bare Steel & Cast Iron	Yes *P80-P120*	Yes *P80-P120*	No	Yes *P80-P120*	Yes *P80-P120*	No	Yes *P80-P120*
Zintec	Yes *scotchbrite*	Yes *scotchbrite*	No	see note (1) below	see note (1) below	No	No
Galvanised Steel	Yes *P80-P120*	Yes *P80-P120*	No	see note (1) below	see note (1) below	No	No
Stainless Steel	Yes *P80-P120*	Yes *P80-P120*	No	see note (1) below	see note (1) below	No	No
Aluminium & alloys *	Yes *P120-P150*	Yes *P120-P150*	No	see note (1) below	see note (1) below	No	No
Fibreglass & GRP	Yes *P280-P320*	Yes *P280-P320*	No	Yes *P280-P320*	Yes *P280-P320*	Yes *scotchbrite*	Yes *P360*
Plastics	No	No	Yes *scotchbrite*	No	No	Yes *scotchbrite*	No
Polyester Fillers	-	-	-	-	-	No	Yes *P80*

note (1). These fillers may not be applied directly to the metal surface, but may be used once the substrate has been painted with a suitable adhesion primer (e.g. DP40 Chromate-Free 2K Epoxy Surfacer - D834/D835).

* For painting of **anodised aluminium** it is essential to pre-prime with a suitable adhesion primer (e.g. DP40 Chromate-Free 2K Epoxy Surfacer - D834/D835). Do not use phenolic-based adhesion primers.

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.
D846	DX103 Degreasing Agent for Plastics	A fast, effective degreaser specially formulated to avoid static build up and adverse effects on plastic substrates.



APPLICATION GUIDE

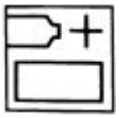
	Galvaplast 77 A656	Galvaplast Slow A663	Iviplast 66 A652	P.E. Stopper A661	Extra Light A659	Pinhole Filler A655	Putty VBA Beige A242
Hardener Selection :	A665 for open-top cans of filler A666 for small-size cartridges of filler A667 for large-size cartridges of filler					Supplied ready-for-use from the can	
Addition of Hardener : *at 5 - 10°C* *at 10 - 20°C* *at 20 - 30°C*	2.5-3.0% 2.0-2.5% 1.5-2.0% by weight	2% by weight	2.5-3.0% 2.0-2.5% 1.5-2.0% by weight	2.5-3.0% 2.0-2.5% 1.5-2.0% by weight	2.5-3.0% 2.0-2.5% 1.5-2.0% by weight	n/a	n/a
Mixing :	Thoroughly mix the brightly coloured hardener into the filler until the mix becomes an homogenous paste.					no mixing required	
Potlife : *at 5 - 10°C* *at 10 - 20°C* *at 20 - 30°C*	8-12min 7-10min 5-10min	15-18min	8-12min 7-10min 5-10min	8-10min 6- 9min 5- 9min	8-12min 7-10min 5-10min	n/a	n/a
Application :	Use a suitable knife or spreader. Apply one or more coats as necessary, allowing 5-10min /20°C betwen coats.					see note (2) below	see note (3) below

note (2). A655 Pinhole Filler should be applied with a clean cloth, using circular movements to fill small surface defects. After wiping off surplus filler, a second layer should then be applied and left to airdry for 15min at 20°C. Any remaining excess of product should then be removed before tacking off and applying a suitable plastics primer.

note (3). A242 Putty V.B.A. Beige is best applied in several thin layers, leaving a flash-off interval between each of 5-10min at 20°C. Application should be by use of a suitable knife or spreader. Putty V.B.A. Beige may be sanded and recoated after 30-60min airdrying dependent upon ambient temperature and film build.

Dry to sand :	Galvaplast 77 A656	Galvaplast Slow A663	Iviplast 66 A652	P.E. Stopper A661	Extra Light A659	Pinhole Filler A655	Putty VBA Beige A242
5 - 10°C	25-35min	1hr min.	35-45min	25-30min	35-45min	see above	see above
10 - 20°C	20-30min	45-60min	30-40min	20-25min	30-40min		
20 - 30°C	15-20min	30-40min	20-30min	15-20min	20-30min		
IR medium wave	5-6min	5-6min	do not use	5-6min	5-6min	do not use	do not use
IR short wave	4-5min	4-5min	do not use	4-5min	4-5min	do not use	do not use
note :	Before sanding 2-component polyester fillers (i.e. A656, A663, A652, A661 or A659), it is useful to wipe the surface with Deltron Fast Thinner D808. This reduces surface tack and prevents excessive clogging of the sanding paper.						
Dry sanding paper grade	P80 followed by P120 followed by P240	P80 followed by P120 followed by P240	P80 followed by P120 followed by P240	P80 followed by P120 followed by P240	P80 followed by P120 followed by P240	no sanding required	P220 followed by P400
Overcoating at 20°C :	30min	60min	40min	25min	40min	15min	10-15min

Overcoat with :	Any PPG 2K Surfacer	Any PPG 2K Surfacer	Suitable PPG Plastics Primer	Any PPG 2K Surfacer	Any PPG 2K Surfacer	Suitable PPG Plastics Primer	Any PPG Surfacer or Topcoat



PERFORMANCE AND LIMITATIONS

Always follow the recommended mix ratio when adding hardener. Do not attempt to accelerate drying times by adding extra hardener, as this will cause major defects in the subsequent paint film, such as pinholing, peroxide bleaching and gloss dieback.

Do not allow water to come into contact with 2 component polyester fillers - always dry sand. Even if the filler is subsequently dried by low-bake or Infra-Red lamps, wet sanding can still cause microblistering problems.

Once hardener has been mixed into the filler, do not return it to the can. Be careful to prevent traces of hardener from the mixing stick or spreader from coming into contact with filler in the can.

With the single exception of A242 Putty V.B.A. Beige, it is not recommended to overcoat these products directly with topcoat colour. Always overcoat first with a suitable primer surfacer such as D839 Prima or D836 Koba Plus (refer to specific product data sheets for full details of suitability and surface preparation.).

These products are not recommended for direct application to anodised aluminium - an epoxy or non-phenolic etch primer should be applied first.

Store product in a cool, dry environment. Do not expose to direct sunlight.

After use, ensure that partly used containers are tightly sealed.

HEALTH AND SAFETY

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

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.

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