

2 + 1

HIGH BUILD WASH FILLER

2 + 1 FILLER BASE D855

2 + 1 REACTIVE REDUCER D856

PRODUCT DESCRIPTION		
<p>2+1 Wash Filler is a high-build chromate-free wash etch primer. The colour is grey. Mix Base D855 with acid based Reactive Reducer D856 before use. Use on new panels or aged painted surfaces to promote adhesion of subsequent paint films. Do not use as an isolator.</p>		
PREPARATION OF SUBSTRATE		
<p>Apply over bare steel, aluminium zintec and galvanised sheet, and existing aged painted finishes after first degreasing with appropriate PPG cleaner (see selection guide).</p> <p>Wet flat painted surfaces with P400 grade paper or dry flat with P320 grade paper. It is particularly important to flat thoroughly aluminium alloys and anodised aluminium. Lightly abrade and degrease other surfaces. Take care with air-dried synthetic surfaces and test a section before applying 2+1 Wash Filler.</p>		
GUIDE TO SELECTION OF SUBSTRATE CLEANER		
<i>Code</i>	<i>Product</i>	<i>Purpose</i>
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.
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.
D846	Degreasing Agent for Plastics	A fast, effective degreaser specially formulated to avoid adverse effects on plastic substrates.

APPLICATION GUIDE	
<i>Mixing Ratio</i>	D855 2 vols D856 1 vol
<i>Potlife</i>	24 hours / 20°C
<i>Spray viscosity</i>	25 secs DIN4 / 20°C
<i>Spraygun setup</i>	1.8 mm
<i>Spray pressure</i>	4 bar
<i>Number of coats</i>	2 - 3
<i>Flash off at 20°C: between coats</i>	5 minutes

APPLICATION GUIDE	
<i>Drying times:</i> <i>dust-free (20°C)</i> <i>dry to sand (20°C)</i>	5 minutes 75 - 90 minutes
<i>Total dry film build:</i> <i>minimum</i> <i>maximum</i>	40µm 50µm
<i>theoretical coverage **</i>	5 m ² / l
<i>** Theoretical coverage in m² per litre ready-to-spray, giving 40 µm dry film thickness</i>	
<i>Flatting:</i> <i>grade wet</i> <i>grade dry</i>	P600 - P800 P400
<i>Overcoat / recoat time</i>	75 - 90 minutes
<i>Overcoat with</i>	any Deltron topcoat

PERFORMANCE AND LIMITATIONS

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

HEALTH AND SAFETY

- Please refer to Material Safety Data Sheets for full Health and Safety details.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.
- Do not smoke whilst using this material.

FLASH POINTS

2 + 1 Wash Filler Base D855	}	Below 21°C
2 + 1 Reactive Reducer D856		
DX310 High-Strength Degreaser D845		
DX330 Spirit Wipe D837		
Degreasing Agent for Plastics D846		
DX380 Low-VOC Cleaner D842		No flash point - water-based

This product is for professional use only. The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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



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