

# 2K RAPID FILLER

FAST DRYING 2K SURFACER - D857  
HARDENER - D858

## PRODUCTS

2K Rapid Filler - Fast Drying 2K Surfacers	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 250 $\mu$  film build and is sandable after 3 hours air-dry at 20°C. As an isolating primer, 2K Rapid Filler offers approx. 100 $\mu$  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 Surfacers (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 Surfacers (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 Surfacers (2-4 coats).

Sequence P80 - P120 - P240 when using 2K Rapid Filler as an Isolating Surfacers (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.



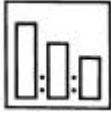


APPLICATION GUIDE

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 18°C	D808 Fast Thinner
18 - 25°C	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 :

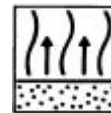
4 bar

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

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.



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

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