

Product Data Sheet

December 2008



FOR PROFESSIONAL USE ONLY

F0100V

2-Pack Polyester Stopper Range

<i>Product</i>	<i>Description</i>
P551-1050	General Purpose Stopper
P551-1052	Universal Stopper
P551-1059	Fine Stopper
P551-1070	Light General Purpose Body Filler
P275-200	Hardener
P275-300	Hardener
SHA305	Hardener

This stopper range provides the best foundation for all the **Nexa Autocolor** paint systems, combining quick and easy application with easy sanding and a pore-free finish. Modern formulations minimise the risk of adhesion failure; shrinkage or topcoat staining experienced with some other brands. Select the right product for the type of job to ensure the most efficient application and long term performance.

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Innovating Repair Solutions

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY.

Product Description

P551-1050 is a flattable general-purpose stopper, which may be used under any **Nexa Autocolor** undercoat or Fine Stopper of deep dents or shallow surface defects. (Note: like most stoppers, this is not suitable over zinc-galvanised surfaces).

P551-1052 is a high performance universal stopper, which may be used under any **Nexa Autocolor** undercoat or Fine Stopper. It has a smooth creamy application and is formulated to provide excellent adhesion to a wide variety of metal substrates, including zinc-galvanised.

P551-1059 is a fine stopper, which may be used under any **Nexa Autocolor** undercoat, to fill small dents and scratches. It gives a smooth pore-free surface and may be used on its own or as a finish to any other stopper.

P551-1070 is an easily flattable lightweight stopper, which may be used under any **Nexa Autocolor** undercoat or Fine Stopper, and is especially suitable for the filling of large surface areas. (Note: like most stoppers, this is not suitable over zinc-galvanised surfaces).





PROCESS

	The drying time and working life of the stopper will vary considerably depending on the shop temperature and amount of hardener used. The use of an electronic balance or dispenser is strongly recommended (in the table below 50g of stopper is roughly the size of a golf ball). Mix carefully to avoid forming air bubbles.		
	Stopper	Hardener	
	P551-1070 P551-1059 P551-1050/-1052	P275-300 P275-200 SHA305	
	Stopper 100 g 100 g 100 g	Hardener 2% 2% 1%	Shop temperature 5-10 °C 10-20 °C over 20 °C
	For deep filling apply in several thick layers, allowing each to dry between applications. Scuff each layer for best adhesion. Working time: 4 to 9 minutes, depending on stopper type and conditions.		
	Air-dry at 20 °C 15 to 30 Minutes (depending on conditions)		
	Dry - P80-P120		
	Finishing with P150 - P240		
	2-pack polyester stoppers can be directly recoated with any Nexa Autocolor 2K undercoat, 2-Pack Etch Primer, 2K Epoxy Primer or P551-1059 Fast finishing stopper		

GENERAL PROCESS NOTES

SUBSTRATES AND PREPARATION

2-pack Polyester stoppers should only be applied over:

- Well scuffed and degreased bare steel and aluminium
(Use **Nexa Autocolor** 2-pack Chromate Free Etch Primer or 2K Epoxy Primer for maximum durability).
- Well-flatted GRP, polyester fillers, works primer and old finishes in sound condition.

The following grades of flattening paper are recommended:
P80-P120

Note:

1. P551-1052 can also be applied to zinc-galvanised substrates
2. If the original finish is thermoplastic acrylic then strip to bare metal
3. Do not sandwich between 2 layers of lacquer-drying paint.

For maximum durability apply 2-Pack Chromate Free Etch Primer over any bare metal areas around the 2-Pack Polyester Stopper repair prior to undercoating.

OTHER POINTS TO NOTE:

1. Clean equipment immediately with cleaning products or a strong thinner.
2. The wet flattening of polyester stoppers is not recommended. If this is carried out, the area of repair must be fully dried before recoating, e.g. by using infrared or an oven.
3. In colder conditions, curing can be assisted by the warming of panels (infrared or oven) prior to application of stopper.
4. As with all polyester stoppers, the use of too much or too little hardener can cause a problem of bleaching or staining of certain topcoat colours.

VOC Information

The EU limit value for these products (product category: IIB.b) in ready to use form is max. 250g/litre of VOC. The VOC content of these products in ready to use form is max. 250g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of these products may be lower than that specified by the EU Directive code.

These products are for professional use only and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at:
http://www.ppg.com/Autocolor_MSDS

For further information please contact:

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