

1051R - 1057R

HIGH PRODUCTIVE SURFACER



PRODUCT DESCRIPTION

High Productive Surfacers White (1051R) and High Productive Surfacers Black (1057R) are highly productive surfacers that can be used as sanding surfacers and as maxi fillers for all Cromax topcoats. They provide a good performance with no edge mapping. By adding High Productive Accelerator AZ1050, the surfacers help to deliver increased productivity through air-drying.

Very productive ValueShade surfacer



Developed by Cromax®, ValueShade® delivers the optimal undercoat for every topcoat colour.

FEATURES

- 01** Combines excellent filling properties with excellent vertical stability.
- 02** Suitable for fast air dry or quick curing with minimal IR power.
- 03** Helps bodyshops focus on saving time and energy while supporting high throughput.
- 04** It has a dedicated and unique High Productive Accelerator AZ1050.
- 05** For increased productivity, use with XK203 and AZ1050 in a 5:1:2 mixing ratio.
- 06** Aids productivity with an easy dry-to-sand in 30 minutes air dry at 20°C.
- 07** As a sanding surfacer, it can be applied up to 3 coats in wet on wet application when used with AZ1050.
- 08** Part of the ValueShade concept.

TECHNICAL DATA SHEET

1051R - 1057R

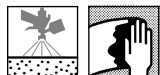


HIGH PRODUCTIVE SURFACER

Product preparation - application STANDARD SANDING VOC



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Steel, galvanised steel and soft aluminium sanded and cleaned and coated with 1K Wash Primer or Epoxy Primer. In addition, for small sand through areas, pre-treatment wipes can be used.
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
1051R	100	93	83	65	35	10	-
1057R	-	7	17	35	65	90	100
Standard							
	Volume			Weight			
1051R / 1057R	7			100			
XK203 / XK205	1			11			
XB383	2.5			21			



Pot life at 20°C: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	1.5 - 2 bar	inlet pressure
HVLP	1.6 - 1.8	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

intermediate and final flash-off: 5 min - 10 min



	XK203 / XK205
20 °C	1 hr
60 - 65 °C	25 min



Guideline for short wave IR equipment
Half power: 10 min



P500



Centari 2K Topcoat
Cromax Pro Basecoat / C600 & C6000 Basecoats + Cleacoat

VOC compliant

2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

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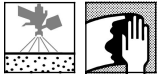


HIGH PRODUCTIVE SURFACER

Product preparation - application STANDARD SANDING HS/MS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Steel, galvanised steel and soft aluminium sanded and cleaned and coated with 1K Wash Primer or Epoxy Primer. In addition, for small sand through areas, pre-treatment wipes can be used.
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
1051R	100	93	83	65	35	10	-
1057R	-	7	17	35	65	90	100

	Hs		Ms	
	Volume	Weight	Volume	Weight
1051R / 1057R	5	100	4	100
1010R / 125S	-	-	1	17
256S	1	14	-	-
1025R	-	-	1	15
XB383	1.5	18	-	-



Pot life at 20°C: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	1.5 - 2 bar	inlet pressure
HVLP	1.6 - 1.8	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

intermediate and final flash-off: 5 min - 10 min



	1010R / 125S / 256S
20 °C	1 hr
60 - 65 °C	25 min



Guideline for short wave IR equipment
Half power: 10 min



P500



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Cromax Pro Basecoat / C600 & C6000 Basecoats + Cleacoat

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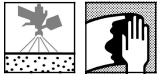


HIGH PRODUCTIVE SURFACER

Product preparation - application STANDARD MAXI MS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Steel, galvanised steel and soft aluminium sanded and cleaned and coated with 1K Wash Primer or Epoxy Primer. In addition, for small sand through areas, pre-treatment wipes can be used.
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
1051R	100	93	83	65	35	10	-
1057R	-	7	17	35	65	90	100

	Standard	
	Volume	Weight
1051R / 1057R	4	100
1010R / 125S	1	17
1025R	0.5	8
AB385 / XB387	1	15



Pot life at 20°C: 45 min



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	1.5 - 2 bar	inlet pressure
HVLP	1.6 - 1.8	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min
final flash-off: 30 min



	1010R / 125S
20 °C	1 hr - 1 hr 30 min
60 - 65 °C	30 min



Guideline for short wave IR equipment
Half power: 10 min



P500



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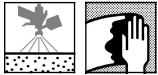


HIGH PRODUCTIVE SURFACER

Product preparation - application STANDARD ACCELERATED



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Steel, galvanised steel and soft aluminium sanded and cleaned and coated with 1K Wash Primer or Epoxy Primer. In addition, for small sand through areas, pre-treatment wipes can be used.
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
1051R	100	93	83	65	35	10	-
1057R	-	7	17	35	65	90	100
Standard							
	Volume			Weight			
1051R / 1057R	5			100			
XK203	1			15			
AZ1050	2			25			



Pot life at 20°C: 20 min



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	1.5 - 2 bar	inlet pressure
HVLP	1.6 - 1.8	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

intermediate flash-off not needed



	AZ1050
20 °C	30 min



P500



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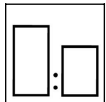
Products

1051R High Productive Surfacers - VS1
1057R High Productive Surfacers - VS7

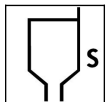
1010R High Solids Activator Fast
125S Standard Activator
256S Activator Fast
XK203 Low Emission Activator Fast
XK205 Low Emission Activator

1025R High Solids Surfacers Thinner
AB385 MS HI-Temp Thinner
AZ1050 High Productive Accelerator
XB383 Standard Thinner
XB387 HI-Temp Thinner

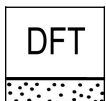
Product mix



Mixing ratios with special agents are available in the productmix table on ChromaWeb and in the specific TDS.



ISO 5: 25 - 30 s at 20°C
DIN 4: 22 - 25 s at 20°C



70 - 200 µm

Theoretical coverage

380 - 400 m²/l at 1 micron dry film thickness
Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

TECHNICAL DATA SHEET

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Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 80-120µm in 2 coats, after either air drying overnight or force drying/IR drying. With problem substrates, careful pretreatment is necessary and the Surfacers must be applied to the entire area.
- Allow additional time for preheating up to panel temperature.
- The use of 2K Wash Primer underneath the surfacer is allowed, when the surfacer is intended to be forced dried or dried overnight.
- Mix thoroughly by hand before placing the can on mixing machine.
- Surfacers have to be applied over the complete panel or overall car if the OEM paintwork is not well cured. Spot repairing or sand throughs of the surfacer can result in spot marking or lifting when applying a basecoat.
- The use of high performance activators will positively influence the adhesion and stonechip performance of the complete paint system.
- Force drying of High Productive Surfacers 105xR with AZ1050 is possible with short wave I.R. for 5 minutes at half power, or 5 minutes at 60°C-65°C oven bake.
- For Semi-Flexible systems 10% 805R Flexible Additive can be added to the base material. Activator and Thinner ratios remain equal.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

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