

Product Data Sheet

August 2006 (Updated in August 2019)

**INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY**

T0650V

Fastbuild™

<i>Product</i>	<i>Description</i>	
<i>P540-401</i>	<i>Fastbuild</i>	<i>- off white</i>
<i>P540-402</i>		<i>- grey</i>
<i>P540-403</i>		<i>- red</i>
<i>P540-404</i>		<i>- black</i>
<i>P850-1335</i>		<i>Fastbuild Thinner</i>
<i>P850-1391</i>		<i>Slow Thinner</i>
<i>P210-788</i>		<i>Fastbuild Activator</i>

Product Description

Fastbuild has excellent anti-corrosive properties making it an ideal primer for new steel chassis. It is also a highly versatile primer, which can be applied over many of the surfaces found in commercial vehicle painting, including small areas of bare aluminium and old paintwork. This flexibility makes it a suitable primer for general refurbishment work. It can be used under **Nexa Autocolor** Commercial Transport 1-pack and 2-pack Topcoats (and as a 1-pack and 2-pack Undercoat).












Standard and Fast Process

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





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	Airless Spray	Air Assisted Airless (Air Mix)	Isocyanate hardened Fastbuild Conventional Cold Spray
	No thinning required	Usually no thinning required	Fastbuild 3 parts Fastbuild Activator 1 part
			Pot Life at 20°C : 4 hours Clean gun immediately after use
	Ready for use	Ready for use 5 to 10% of P850-1335 or P850-1391 thinner might be added	36-43 secs DIN4 (50-60 secs BSB4)
			1.6 -1.8 mm 3.7-5.3 bar (55-80 psi)
	Airless : 0.28-0.38 mm (11-15 thou) 40-60° angle Paint pressure: 100-200 bar (1500-3000 psi)	Air Assisted Airless : 0.28-0.38 mm (11-15 thou) 40-60° angle Paint Pressure : 80-120 bar (1300-1700 psi) Air cap pressure : up to 3 bar (50 psi)	
	1-2 coats 50-75 microns	1-2 coats 50-75 microns	2 coats 50-60 microns A minimum of 2 coats is required over large areas of bare steel to obtain good corrosion resistance.
	For optimum protection of steel the primer dry film thickness should be a minimum of 50 microns (2 thou). On blast cleaned steel this should be 50 microns (2 thou) as measured above the blast cleaned peaks. Additional coats may be necessary depending on application equipment used, spraying technique, substrate profile and chosen thinning ratio.		
	10-20 mins between coats, depending on film thickness and drying conditions		
	Air dry (20°C) Recoat : Minimum of 2 hours - Overnight for optimum appearance Handleable : Approx. 2 hours Hard dry : Overnight		
	Flattening is not recommended unless it is necessary to remove dirt or runs and should be denibbed lightly when hard dry (minimum overnight dry)		



HVLP and Conventional Application				
	Cold spray Chassis Mode		Hot Spray 60-80°C	General Purpose Primer/Undercoat
	Fastbuild Thinner	6 parts 1 part	Fastbuild up to 8 parts Thinner 1 part as required The paint to be applied should be heated in an approved apparatus	Fastbuild 5 parts P850-1391 Slow Thinner 1 part
	Extra thinner may be added for improved flow			
	36-43 secs DIN4 (50-60 secs BSB4) at 20°C			36-43 secs DIN4 (50-60 secs BSB4) at 20°C
	1.8 mm 3.7 -5.3 bar (55-80 psi)		1.8-2.2 mm 3.7-5.3 bar (55-80 psi)	1.6 - 1.8 mm 3.7-4.3 bar (55-65 psi)
	1.0-1.4 mm Air cap pressure : 0.675 bar (10 psi) maximum			
	2 coats 50-60 microns		1-2 coats 50-60 microns	2 coats 50-60 microns
	For optimum protection of steel the primer dry film thickness should be a minimum of 50 microns (2 thou). On blast cleaned steel this should be 50 microns (2 thou) as measured above the blast cleaned peaks. Additional coats may be necessary depending on application equipment used, spraying technique, substrate profile and chosen thinning ratio.			
	Air Dry (20°C) : Recoat : Minimum of 2 hours - Overnight for optimum appearance Handleable : Approx. 2 hours Hard dry : Overnight			



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General Process Notes

SUBSTRATES AND PREPARATION

SUBSTRATES	PREPARATION	NOTES
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P80-P180 dry sanding machine discs or P120-P220 wet and dry paper, then clean with P850-1378	Surface must be free from oil/grease, millscale and rust.
Sound Factory Finishes Sound Works Primer Sound old finishes (1- & 2-pack) Sound electrocoat Small areas of aluminium	Flat thoroughly using P240-P320 dry sanding machine discs or P400 wet and dry paper, then clean with P850-1378.	
GRP "Glasonite"	Clean with P273-901. Flat thoroughly using P240-P280 dry sanding machine discs or P320-P400 wet and dry paper, then clean with P850-1378.	Take care not to break through the gel coat when flattening GRP.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS.

RECOAT

Drying times will depend on film thickness and drying conditions. In common with other primers longer drying times before recoat will improve final appearance. May be recoated with **Nexa Autocolor** Commercial Transport 1-pack and 2-pack (not Epoxy) undercoats (e.g. Repaint Undercoat P595-line) or directly topcoated with **Nexa Autocolor** Commercial Transport 1-pack and 2-pack topcoats. See appropriate PDS for further details.

Fastbuild must **NOT** be recoated directly with a basecoat/clear system, e.g. Turbo Plus™ Multistripe, P492-line or P497-line **unless** it has been activated.

To enhance the final appearance of EHS Hi-Gloss 383™ it is recommended that Repaint Undercoat (P595-line) is applied before topcoating.

Vehicles primed with Fastbuild left under cover for up to 6 weeks can be overcoated without flattening. Steam clean or wash using P273-901, dry and thoroughly degrease before overcoating. Primer left longer than 6 weeks should be flattened before applying other materials.



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APPLICATION EQUIPMENT INFORMATION

HVLP

The most suitable HVLP gun for the application of Commercial Transport products is a pressure feed system.

Air cap pressure : 0.675 bar (10 psi) maximum

Paint pressure : 0.3-1.0 bar (5-15 psi)

If long fluid lines are used, the paint pressure will need to be increased.

Hot Spray

May be applied hot via airless and air assisted airless (air mix) application.

DRYING

The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperatures below 20°C and excessive film thickness will extend the drying times.

THINNER ADDITION

Thinning ratios are for your guidance and should be adjusted when necessary to meet individual requirements.

HARDENER ADDITION

2-pack topcoats may be applied directly over Fastbuild. Where build is not so important Fastbuild can be isocyanate hardened by adding Activator P210-788. This will give superior through dry, appearance; stone chip resistance and can be used as a sealer for old synthetics. (NB. Cannot be used as a bleeding inhibitor sealer).

Do **NOT** use Thinner P850-1335 with Isocyanate hardened Fastbuild.

Isocyanate cured Fastbuild may be recoated with EHS Hi-Gloss 383.

CORROSION PROTECTION

For maximum corrosion protection the dry film thickness should not fall below 50 microns (2 thou) as measured above the blast cleaned peaks.

HOLDING PRIMER

When used as a holding primer over steel, Fastbuild will protect vehicles or components for up to 1 year. A dry film thickness of 75-100 microns (3-4 thou) is recommended for this purpose.

COVERAGE

Approximately 4m² per litre of ready for use paint at a dry film thickness of 50 microns (2 thou).



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VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC.

The VOC content of this product in ready to use form is max. 540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product 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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