

Product Data Sheet

May 2011



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

F0100V

2-Pack Polyester Stopper Range

<i>Product</i>	<i>Description</i>
P551-1050	General Purpose Stopper
P551-1052/E1.5K + P551-1052/E2K	Universal Stopper – ONLY 1.5 and 2 Kg
P551-1057	Glassfibre Stopper
P551-1058	Aluminium Stopper
P551-1059	Fast Finishing Stopper
P551-1070	Light General Purpose Body Filler
P551-1071	Fine Stopper
P551-1077	Universal Stopper
P551-1080	Multi Purpose Low Density Stopper
P551-1085	Stopper For Plastics
P551-1089	Universal Stopper
SHA305	Hardener
SHA306	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.

Innovating Repair Solutions

THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY.

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Product Description

P551-1050 is a flappable 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/E1.5K + P551-1052/E2K 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.

P551-1057 is a glass-fibre stopper, which must be overcoated with any other 2-pack polyester stopper. It is reinforced with glass-fibre strands, making it ideal for building up wider or deep dents and bridging holes / etc, or in the repair of GRP components.

P551-1058 is an aluminium stopper, which may be used under any **Nexa Autocolor** undercoat or Fine Stopper to provide a very durable and tough repair. It gives heavier flattening dust, which means a cleaner bodyshop environment.

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 flappable 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).

P551-1071 is an easily flappable fine stopper, which may be used under any **Nexa Autocolor** undercoat for the filling of deep layers or shallow surface defects. It gives a smooth pore-free surface and may be used on its own or as a finish to any other stopper. (Note: like most stoppers, this is not suitable over zinc-galvanised surfaces).







P551-1077 is a high performance universal stopper, which may be used under any **Nexa Autocolor** undercoat. It has a smooth easy application, excellent sandability and is formulated to provide excellent adhesion to a wide variety of metal substrates, including zinc-galvanised, making it the best all-purpose product available.

P551-1080 is an easily flappable ultra lightweight stopper, which may be used under any **Nexa Autocolor** undercoat, and is especially suitable for the filling of large surface areas.

P551-1085 is a fine, flexible stopper which gives excellent adhesion to both rigid and deformable plastics. It is easy to apply and sand & is recoatable with Nexa Autocolor primers for plastics.

P551-1089 is a Universal Stopper formulated for adhesion to a range of metal substrates including zinc-galvanised. It is easy to apply and sand & can be used under any **Nexa Autocolor** undercoat.



PROCESS			
	<p>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.</p>		
	Stopper	Hardener	
	P551-1050/-1052/-1057/-1058/-1059/ -1070/-1071/-1077/-1080/-1085/-1089	SHA305	
	P551-1080	SHA306	
	Stopper 100 g	Hardener 3%	Shop temperature 5-10°C
	100 g	2%	10-20°C
	100 g	1%	over 20°C
	<p>For deep filling apply in several thick layers, allowing each to dry between applications. Scuff each layer for best adhesion.</p> <p>Working time: 3 to 12 minutes, depending on stopper type and conditions.</p>		
	<p>Air-dry at 20°C 15 to 30 Minutes (depending on conditions)</p>		
	<p>Dry - P80-P120</p>		
	<p>Finishing with P150 - P240</p>		
	<p>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</p> <p>P551-1085, Stopper for Plastics should be recoated with the correct Nexa Autocolor primers for the plastic being repaired.</p> <p>N.B. P551-1057 must be overcoated with any 2-pack Polyester Stopper prior to recoating.</p>		

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

To ensure the best adhesion when using P551-1085, Stopper for Plastics the plastic should be thoroughly cleaned with P273-1333, Detergent Cleaner for Plastics, before application of the stopper (Refer to PDS L0700V).

Note:

1. P551-1052/-1080/-1077/-1089 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

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