

Product Data Sheet

August 2006

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY



T0650V

Fastbuild™		
Product	Description	
P540-400	Fastbuild	- green
P540-401		- off white
P540-402		- grey
P540-403		- red
P540-404		- black
P540-411		- beige

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).



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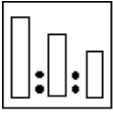



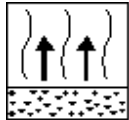




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Standard and Fast Process

	Airless Spray	Air Assisted Airless (Air Mix)
	No thinning required	No thinning required
	Ready for use	
	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 : 50-70 bar (800-1000 psi) Air cap pressure : up to 1.6 bar (25 psi)
	1-2 coats 50-75 microns (2-3 thou)	
	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)	



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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 flatting 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 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, **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 flatting. Steam clean or wash using P273-901, dry and thoroughly degrease before overcoating. Primer left longer than 6 weeks should be flatted before applying other materials.

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APPLICATION EQUIPMENT INFORMATION**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.

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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