



March 2021

Product Information

A675 1K Sandable Filler

PRODUCT DESCRIPTION

A675 is a grey 1K nitrocellulose primer filler. It is fast air-drying, easy to sand and gives good film build. It has unlimited potlife, and is suitable for use under sealers and both 2K and 1K topcoat finishes.

A675 offers good adhesion to a number of suitably prepared surfaces. These include OE finishes and sound non-synthetic paintwork. A675 can also be used over bare metal or fibreglass which have been pre-primed with an appropriate PPG etch or epoxy primer.

High build, fast air-drying and easy to sand and repair, A675 is ideally suited for small repairs. It is ideal for airdry use and where airborne dirt contamination could be a frequent problem.

PREPARATION OF SUBSTRATE - SANDING



Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Original paintwork or fully cured 2K finishes should be sanded using P240-360 grit discs (dry) or P360-400 grade paper (wet).

Synthetic and 1K finishes, if sound and aged, should be overcoated with a suitable PPG isolating primer before subsequent application of A675. D834/5 DP40 Chromate-Free 2K Epoxy Surfacer - please refer to the appropriate technical data sheets.

Bare steel, aluminium, GRP or fibreglass should be primed with D831/2 Universel Chromate-Free Wash Primer or D834/5 DP40 Chromate-Free 2K Epoxy Surfacer before application of A675.

Polyester Bodyfillers should be fully cured then dry-sanded using a sequence of P80 - P120 - P240 grade paper before application of A675. Fully cured Spray-Fillers should be sanded with a sequence of P240 - P360 grade paper (dry) or P600 - P800 paper (wet) before application of A675

PREPARATION OF SUBSTRATE – DEGREASING



Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner:

Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

Please see the **Deltron Cleaners (RLD63)** Technical Data Sheet for appropriate cleaning & degreasing products.

MIXING RATIO

A675 : 1 vol

Nitro thinner: 50-100% vol

A premium quality PPG cellulose thinner may be used as an alternative.

MIXED PRODUCT DETAILS

Potlife: *Unlimited*

Spray viscosity: 19-48 secs DIN4 / 20°C

APPLICATION AND FLASH OFF



Spraygun set-up:

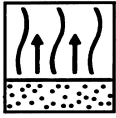
Gravity 1.5-1.8 mm

Suction 1.6-1.8 mm

Spray Pressure: See gun manufactures recommendations

Number of coats: 3-4 wet

Application and Flash Off continued



*Flash-off
between coats at 20°C:* **10 minutes**

DRYING TIMES



*Drying times:
- Dustfree at 20°C* **10 minutes**



*Before sanding and
overcoating at 20°C* **20-30 minutes**

Total dry film build:
 minimum **120μ**

 maximum **160μ**

REPAIR AND RECOATING



Sanding:
- *grade dry* P320 followed by P400-500
- *grade wet* P600 followed by P800



Overcoating: Most PPG Sealers and Topcoats may be applied over A675.
Please refer to the appropriate technical data sheet(s) for full details.

Please see 'Performance and Limitations' section of this TDS.

PERFORMANCE AND LIMITATIONS



A675 should be stirred thoroughly before thinning and before application if left to stand in the spraygun for any length of time.

A675 is not suitable for use over plastic or other flexible substrates.

Do not attempt to use A675 over surfaces where film build exceeds 160 μ .

Do not apply more than the recommended number of coats. Excessive film build, insufficient flash-off between coats or use of non-recommended thinner will have adverse effects on A675's drying time, sandability and topcoat gloss holdout.

After spot-repairing with A675, ensure that the repair surface is carefully sanded around the edges before overcoating with topcoat or sealer.

After use, clean spray equipment thoroughly with cleaning solvent or thinner.

The use of HVLP spray equipment can give an increase in transfer efficiency of around 10% depending upon the make and model of equipment used.

HEALTH AND SAFETY

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/PPG MSDS](http://www.ppg.com/PPG_MSDS)

PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 773480