



July 2008

# Product Information



## FILLERS

*GALVAPLAST 77 - A656*  
*MULTI PURPOSE STOPPER - A722*  
*IVIPLAST 66 - A652*  
*P.E. STOPPER - A661*  
*EXTRA LIGHT - A659*

## PRODUCTS

Galvoplast 77	- Multi Purpose Polyester Filler	A656
Multi Purpose Stopper		A722
Iviplast 66	- Flexible Polyester Putty	A652
P.E. Stopper	- Standard Polyester Stopper	A661
Extra Light	- Light Polyester Filler	A659
Hardener for A656, A722 A652, A661 & A659	- for can	A665
	- for small cartridge	A666
	- for large cartridge	A667

## PRODUCT DESCRIPTIONS

**Galvoplast 77** is a premium quality 2 component polyester filler that offers outstanding adhesion to any metal substrate - including 'difficult' surfaces such as galvanised or zinc-coated steel, stainless, aluminium and fibreglass. Offering smooth application, fast drying and easy sanding, Galvoplast 77 is particularly versatile and easy to use.

**Multi Purpose Stopper** is a quality stopper that offers outstanding adhesion to a wide variety of metallic substrates, including galvanised or zinc coated steel, properly prepared aluminium and fibreglass. This Stopper has outstanding ease of application and sanding properties.

**Iviplast 66** is a fine, flexible 2 component polyester filler that offers excellent adhesion to both rigid and deformable plastics. Like the substrates it is designed to repair, Iviplast 66 offers good resistance to the light impacts and stonechips that frequently damage the lower external bodywork and trim areas.

**P.E. Stopper** is a conventional 2 component polyester filler that offers quick drying and easy clog-free sanding. P.E. Stopper is suitable for use over bare steel, fibreglass, GRP and other primed or painted surfaces.

**Extra Light** is a low density 2 component polyester filler that is exceptionally easily applied and worked, even over major surface imperfections. Smooth and consistent, and offering good flexibility and impact resistance, Extra Light may be used over bare steel, painted surfaces, fibreglass and GRP.

## SURFACE PREPARATION

The matrix indicates those surfaces which may be directly overcoated by each PPG Filler, and where appropriate the abrasive grade with which the surface should be dry-sanded before application.

	<b>Galvoplast 77 A656</b>	<b>Multi Purpose Stopper A722</b>	<b>Iviplast 66 A652</b>	<b>P.E. Stopper A661</b>	<b>Extra Light A659</b>
Paintwork	Yes <i>P360</i>	Yes <i>P360</i>	No	Yes <i>P360</i>	Yes <i>P360</i>
Bare Steel & Cast Iron	Yes <i>P80-120</i>	Yes <i>P80-120</i>	No	Yes <i>P80-120</i>	Yes <i>P80-120</i>
Galvanised Steel	Yes <i>scotchbrite</i>	Yes <i>scotchbrite</i>	No	see note (1) below	see note (1) below
Aluminium	Yes <i>P120-240</i>	Yes <i>P120-240</i>	No	see note (1) below	see note (1) below
Fibreglass & GRP	Yes <i>P360</i>	Yes <i>P360</i>	No	Yes <i>P360</i>	Yes <i>P360</i>
Plastics	No	No	Yes <i>scotchbrite</i>	No	No
Polyester Fillers	-		-	-	-

Note (1). These fillers may not be applied directly to the metal surface, but may be used once the substrate has been painted with a suitable adhesion primer (e.g. Epoxy Primer). Do not use phenolic-based adhesion primers.

## SUBSTRATE CLEANING



In all cases, select the appropriate PPG cleaner(s) and ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

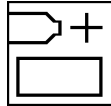
PPG make a comprehensive range of cleaning & degreasing products.


See Technical Datasheet **Deltron Cleaners RLD63V**.




# APPLICATION GUIDE

	A656/A722	Iviplast 66 A652	P.E. Stopper A661	Extra Light A659
<b>Hardener Selection:</b>	A665 for open-top cans of filler A666 for small-size cartridges of filler A667 for large-size cartridges of filler			
<b>Addition of Hardener:</b> at 5 - 10°C at 10 - 20°C at 20 - 30°C	2.5-3.0% 2.0-2.5% 1.5-2.0% by weight	2.5-3.0% 2.0-2.5% 1.5-2.0% by weight	3.0% 2.0% 1.0% by weight	2.5-3.0% 2.0-2.5% 1.5-2.0% by weight
<b>Mixing:</b>	Thoroughly mix the hardener into the filler until the mix becomes an homogenous paste.			
<b>Potlife :</b> at 5 - 10°C at 10 - 20°C at 20 - 30°C	8-12min 7-10min 5-10min	8-12min 7-10min 5-10min	8-10min 6- 9min 5- 9min	8-12min 7-10min 5-10min
<b>Application :</b>	Use a suitable knife or spreader			



<b>DRYING</b>				
	<b>A656/A722 (Minutes)</b>	<b>Iviplast 66 A652 (Minutes)</b>	<b>P.E. Stopper A661 (Minutes)</b>	<b>Extra Light A659 (Minutes)</b>
<i>Dry to sand at :</i>				
5 - 10°C	35-45	35-45	25-30	35-45
10 - 20°C	30-40	30-40	20-25	30-40
20 - 30°C	20-30	20-30	15-20	20-30
				
<i>IR medium wave</i>	5-6	do not use	5-6	5-6
<i>IR short wave</i>	4-5	do not use	4-5	4-5
<i>note :</i>	Before sanding 2-component polyester fillers (i.e. A656, A652, A661 or A659), it is useful to wipe the surface with Deltron Fast Thinner D808. This reduces surface tack and prevents excessive clogging of the sanding paper.			
<i>Dry sanding: paper grade</i>	P80 followed by P120 followed by P240	P80 followed by P120 followed by P240	P80 followed by P120 followed by P240	P80 followed by P120 followed by P240

<b>OVERCOATING</b>				
	<b>A656/A722 (Minutes)</b>	<b>Iviplast 66 A652 (Minutes)</b>	<b>P.E. Stopper A661 (Minutes)</b>	<b>Extra Light A659 (Minutes)</b>
				
<i>Overcoating time at 20°C:</i>	30	60	40	40
<i>Overcoat with:</i>	Any PPG 2K Surfacer	Suitable PPG Plastics Primer	Any PPG 2K Surfacer	



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## PERFORMANCE AND LIMITATIONS

Always follow the recommended mix ratio when adding hardener. Do not attempt to accelerate drying times by adding extra hardener, as this will cause major defects in the subsequent paint film, such as pinholing, peroxide bleaching and gloss dieback.

Do not allow water to come into contact with 2 component polyester fillers - always dry sand. Even if the filler is subsequently dried by low-bake or Infra-Red lamps, wet sanding can still cause microblistering problems.

Once hardener has been mixed into the filler, do not return it to the can. Be careful to prevent traces of hardener from the mixing stick or spreader from coming into contact with filler in the can.

It is not recommended to overcoat these products directly with topcoat colour. Always overcoat first with a suitable primer surfacer such as D839 Prima or D836 Koba Plus (refer to specific product data sheets for full details of suitability and surface preparation.).

Store product in a cool, dry environment. Do not expose to direct sunlight.

After use, ensure that partly used containers are tightly sealed.

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## 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 this product may be lower than that specified by the EU Directive code.

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## 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)

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