GLOBAL REFINISH SYSTEM

October 2010

Product Information

Universal Low Density Stopper

Universal Low Density Stopper A664
Hardener for A664 SHA306

PRODUCT DESCRIPTION

A664 Universal Low Density Stopper is an ultra lightweight, 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, impact resistance and ease of sanding, Universal Low Density Stopper may be used over bare steel, painted surfaces, fibreglass and GRP.

SURFACE PREPARATION - SANDING

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.

Paintwork	Yes - *P360*
Bare Steel & Cast Iron	Yes - *P80-120*
Galvanised Steel	Yes - *P80-120*
Aluminium	Yes - *P80-120*
Fibreglass & GRP	Yes - *P360*
Plastics	No
Polyester Fillers	-

SUBSTRATE CLEANING

Before and after any sanding operation, the substrate must be thoroughly degreased. Use an appropriate substrate cleaner/degreaser.
PPG make a range of cleaning & degreasing products.
See Technical Datasheet **Deltron Cleaners RLD63V** for cleaners & degreasers.

ADDITION OF HARDENER

	Universal Low Density Stopper A664
	By weight
At 5 - 10°C	2.5 - 3.0%
At 10 - 20°C	2.0 - 2.5%
At 20 - 30°C	1.5 - 2.0%

MIXING

Thoroughly mix the hardener into the filler until the mix becomes an homogenous paste.

POTLIFE

at 5 - 10°C	8-12 minutes
at 10 - 20°C	7-10 minutes
at 20 - 30°C	5-10 minutes

APPLICATION

Use a suitable Putty knife or spreader

DRYING:

Dry to sand at:

5 - 10°C	35-45 minutes
10 - 20°C	30-40 minutes
20 - 30°C	20-30 minutes
IR medium wave	5 - 6 minutes
IR short wave	4 - 5 minutes
Dry sanding Paper Grade:	P80 followed by P120 followed by P240

OVERCOATING

Overcoating time at 20°C:	30min
IR medium wave	5 - 6 minutes
IR short wave	4 - 5 minutes
Overcoat with:	Any PPG 2K Surfacer

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 2K primer surfacer (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.

VOC INFORMATION

The EU limit value for this product (product category: IIB.b) in ready to use form is max. 250g/litre of VOC. The VOC content of this product 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.

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**

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