



GLOBAL REFINISH
SYSTEM



February 2010

Product Information

FILLERS

GALVAPLAST 77 - A656
MULTI PURPOSE STOPPER - A722
IVIPLAST 66 - A652
P.E. STOPPER - A661
EXTRA LIGHT - A659
PINHOLE FILLER - A655
PUTTY V.B.A. BEIGE - A242

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
Pinhole Filler		A655
Putty V.B.A. Beige	- Acrylic Stopper Beige	A242
Hardener for A656, A722 A652, A661 & A659		SHA305

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.

Pinhole Filler is a very light single-component filler. It is suitable for minor filling work on rough or irregular surfaces over which a smooth, high-gloss paint finish is required. Pinhole Filler is ideal for moulded surfaces, especially plastics.

Putty V.B.A. Beige is a light single-component acrylic stopper, suitable for the quick repair of minor surface scratches or imperfections. V.B.A. Putty can be used over paintwork, primer or filler, and is ideal for the quick repair of minor preparation defects.

These products are for professional use only.

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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.

	Galvoplast 77 A656	Multi Purpose Stopper A722	Ivoplast 66 A652	P.E. Stopper A661	Extra Light A659	Pinhole Filler A655	Putty VBA Beige A242
Paintwork	Yes <i>P360</i>	Yes <i>P360</i>	No	Yes <i>P360</i>	Yes <i>P360</i>	Yes <i>scotchbrite</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>	No	Yes <i>P80-120</i>
Galvanised Steel	Yes <i>scotchbrite</i>	Yes <i>scotchbrite</i>	No	see note (1) below	see note (1) below	No	No
Aluminium	Yes <i>P120-240</i>	Yes <i>P120-240</i>	No	see note (1) below	see note (1) below	No	No
Fibreglass & GRP	Yes <i>P360</i>	Yes <i>P360</i>	No	Yes <i>P360</i>	Yes <i>P360</i>	Yes <i>scotchbrite</i>	Yes <i>P360</i>
Plastics	No	No	Yes <i>scotchbrite</i>	No	No	Yes <i>scotchbrite</i>	No
Polyester Fillers	-	-	-	-	-	No	Yes <i>P80</i>

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. DP40 Chromate-Free 2K Epoxy Surfacer - D834/D835). 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.

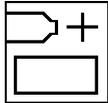
PPG make a comprehensive range of cleaning & degreasing products.

See Technical Datasheet **Deltron Cleaners RLD63V**.

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APPLICATION GUIDE						
	A656/A722	Iviplast 66 A652	P.E. Stopper A661	Extra Light A659	Pinhole Filler A655	Putty VBA Beige A242
<i>Hardener Selection:</i>	SHA305				Supplied ready-for-use from the can	
<i>Addition of Hardener:</i> 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	n/a	n/a
<i>Mixing:</i>	Thoroughly mix the hardener into the filler until the mix becomes an homogenous paste.				no mixing required	
						
<i>Potlife :</i> 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	n/a	n/a
<i>Application :</i>	Use a suitable knife or spreader				see note (2) below	see note (3) below
						

Note (2).A655 Pinhole Filler should be applied with a clean cloth, using circular movements to fill small surface defects. After wiping off surplus filler, a second layer should then be applied and left to airdry for 15min at 20°C. Any remaining excess of product should then be removed before tacking off and applying a suitable plastics primer.

Note (3).A242 Putty V.B.A. Beige is best applied in several thin layers, leaving a flash-off interval between each of 5-10min at 20°C. Application should be by use of a suitable knife or spreader. Putty V.B.A. Beige may be sanded and recoated after 30-60min-airdrying dependant upon ambient temperature and film build.

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DRYING						
	A656/A722 (Minutes)	Iviplast 66 A652 (Minutes)	P.E. Stopper A661 (Minutes)	Extra Light A659 (Minutes)	Pinhole Filler A655 (Minutes)	Putty VBA Beige A242
<i>Dry to sand at :</i>						
5 - 10°C	35-45	35-45	25-30	35-45	see above	see above
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	do not use	do not use
<i>IR short wave</i>	4-5	do not use	4-5	4-5	do not use	do not use
<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	no sanding required	P220 followed by P400

OVERCOATING						
	A656/A722 (Minutes)	Iviplast 66 A652 (Minutes)	P.E. Stopper A661 (Minutes)	Extra Light A659 (Minutes)	Pinhole Filler A655 (Minutes)	Putty VBA Beige A242 (Minutes)
<i>Overcoating time at 20°C:</i>	30	60	40	40	15	10 - 20
<i>Overcoat with:</i>	Any PPG 2K Surfacer	Suitable PPG Plastics Primer	Any PPG 2K Surfacer		Suitable PPG Plastics Primer	Any PPG Surfacer or Topcoat

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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.

With the single exception of A242 Putty V.B.A. Beige, 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.

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: www.ppgrefinish.com

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