



June 2012

Product Information

D8014 1K Rapid Primer/Filler - Grey

PRODUCT DESCRIPTION

1K RAPID PRIMER/FILLER - GREY

D8014

1K Rapid Primer/Filler - Grey is a grey 1K nitrocellulose primer surfacer. It is fast air-drying, easy to sand and gives good film build in a minimal number of coats. It has unlimited potlife, and is suitable for use under sealers and both 2K and 1K topcoat finishes.

1K Rapid Primer/Filler - Grey offers good adhesion to a number of suitably prepared surfaces. These include OE finishes and sound non-synthetic paintwork. 1K Rapid Primer/Filler - Grey can also be used over bare metal or fibreglass which have been pre-primed with an appropriate PPG etch or epoxy primer.

Good build, fast air-drying and easy to sand and repair, 1K Rapid Primer/Filler - Grey is ideally suited for small repairs. It is ideal for air dry 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.

D8014 should only be applied over:

Well scuffed and degreased bare steel. Aluminium should be etch or epoxy primed first. Use a PPG 2-pack Etch or Epoxy Primer for maximum durability over large areas.

Well-flatted GRP, polyester fillers, works primer and old finishes in sound condition.

Good preparation is vital in order to obtain the best results from this product.

The following grades of flatting paper are recommended: -

Machine dry sanding disc
Wet or dry paper

P240 - 360
P280-P320 (GRP P400)

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

D8014 1K Rapid Primer/Filler - Grey:	1 vol
D866 Deltron Primer Thinner:	1 vol

MIXED PRODUCT DETAILS

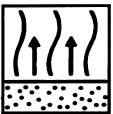
Potlife:	Unlimited
<i>Spray viscosity:</i>	22 - 24 secs DIN4 / 20°C

APPLICATION AND FLASH OFF



Spraygun set-up:

<i>Gravity</i>	1.6mm
<i>Suction</i>	1.6 - 1.8 mm
<i>Spray Pressure:</i>	See gun manufactures recommendations
<i>Number of coats:</i>	1 single followed by 1 double coat or 3 single coats



*Flash-off
between coats at 20°C:* 5 - 10 minutes

DRYING TIMES



Drying times:
- Dustfree at 20°C 10 minutes



Before sanding at 20°C 20 – 40 minutes depending upon drying conditions and film thickness

Total dry film build:
minimum 60µ

maximum 90µ

Theoretical coverage †: Approx 3m²/litre

† Theoretical coverage in thinned, ready-to-spray litres, giving a dry film thickness between indicated minimum and maximum values.

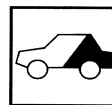
REPAIR AND RECOATING



Sanding:
- grade dry P240 followed by P360



- grade wet P600 followed by P800



Overcoating: Most PPG Sealers and Topcoats may be applied over 1K Rapid Primer/Filler - Grey. Please refer to the appropriate technical data sheet(s) for full details.

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

PERFORMANCE AND LIMITATIONS



1K Rapid Primer/Filler - Grey should be stirred thoroughly before thinning and before application if left to stand in the spraygun for any length of time.

1K Rapid Primer/Filler - Grey is not suitable for use over plastic or other flexible substrates.

Do not attempt to use 1K Rapid Primer/Filler - Grey over surfaces where film build exceeds 250µ.

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 1K Rapid Primer/Filler - Grey 's drying time, sandability and topcoat gloss holdout.

After spot-repairing with 1K Rapid Primer/Filler - Grey, 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: www.ppgrefinish.com

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