

AUTOWAVE® FILLER

DESCRIPTION: A single component waterborne primer surfacer that offers medium filling with excellent sanding. Autowave Filler is perfect for small repairs, and meets VOC regulations that require primer surfacer with a VOC of less than 2.1 lbs. per gallon.


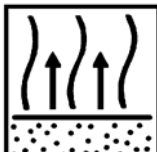




PRODUCT & ADDITIVES:

PRODUCT: Autowave Filler

ADDITIVE: Autowave Flex, a special additive for Autowave Filler, to increase the flexibility of Autowave Filler when applied to plastic parts.

BASIC RAW MATERIAL: Acrylic resin

APPLICATION:

- | | | | | | |
|----|---|--|----|--|--|
| 1. |  | Contains acrylic latex resins and butoxyethanol. | 4. |  | 10–15 minutes at 70°F (20°C) |
| 2. |  | Ready to spray | 5. |  | 2.5 hours at 70°F (20°C)
1 hour at 140°F (60°C)
(15 minutes, infrared) |
| 3. |  | 2–3 x 1
HVLP Siphon 1.8–2.2 mm
HVLP Gravity 1.4–1.7 mm
Max 10 psi (air cap) | 6. |  | Keep from freezing |

SUITABLE SUBSTRATES:

Autowave Filler can be applied directly over the following surfaces:

- Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry or #P500 to #P600 grit wet.
- Steel, degreased and sanded with #P80 then #P120 grit dry.
- Aluminum, degreased and sanded with #P150 to #P180 grit dry.
- Any premium polyester body filler, final sanded with #P180 to #P220 grit dry.
- Washprimer EM CF, after one coat application. Allow the etching primer to dry for a minimum of 15 minutes at 70°F (20°C). Recoat before 4 hours.
- Washprimer 1K CF, after one coat application. Allow the etching primer to dry for a minimum of 15 minutes at 70°F (20°C). Recoat before 24 hours.

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NOTE: Although Autowave Filler will provide adequate adhesion and protection if applied directly over bare steel or aluminum, for larger areas of aluminum and bare steel, we recommend first applying **two** coats of Washprimer EM CF (for application in rule 1151 areas) or **one** coat of Washprimer 1K CF before the application of Autowave Filler.

MIXING RATIO: No mixing is required. Stir product only, do not shake.

SPRAYING VISCOSITY: 23–28 sec. ZAHN cup #2 (20–25 sec. DIN cup #4) at 70°F (20°C).

POT LIFE: 3 months after mixing at 70°F (20°C).

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure
HVLP Siphon	0.071"–0.087" (1.8–2.2 mm)	max 10 psi (air cap)
HVLP Gravity	0.055"–0.067" (1.4–1.7 mm)	max 10 psi (air cap)

APPLICATION: Apply 2–3 single coats. Allow adequate (10–15 minutes) flash off between coats, or until coat goes dull. Flash-off and drying times will vary with relative humidity. (See section "Drying Times" below.)

NOTE: This is a water-based product. Before using, the application equipment should be fitted with a stainless steel tip and be thoroughly cleaned and rinsed with clean water two or more times.

FILM THICKNESS: Approximately 1.2 mil per single coat.

CLEANING OF EQUIPMENT: After application, do not allow product to dry in application equipment. Clean equipment with water, final rinse with Sikkens Gun Cleaning Solvent LV.

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DRYING TIMES:

At 50% Relative Humidity

	60°F (15°C)	70°F (20°C)	80°F (27°C)	140°F (60°C)
To Sand	4 hours	2-1/2 hours	2 hours	45 minutes

At 75% Relative Humidity

	60°F (15°C)	70°F (20°C)	80°F (27°C)	140°F (60°C)
To Sand	5 hours	3-1/2 hours	2-1/2 hours	1 hour

INFRARED DRYING:

15 minutes using short or medium wave length infrared.

SANDING:

Pre-sand with #P500 grit paper wet, final sanding with #P600 to #P800 grit wet or pre-sand with #P320 grit dry, moving in stages to #P500 to #P600 grit dry. When sanded wet, allow 30 minutes at 70°F (20°C) drying time before topcoat application.

SUITABLE TOPCOATS:

Autowave Filler can be recoated with Autocoat LV, or Autobase® Plus.

COVER RATE:

Approximately 100 sq. ft. of unmixed paint per single coat.

STOCK KEEPING:

COLOR: White

CONTAINER SIZE:

Autowave Filler: 1 gallon (3.785 lt)

SHELF LIFE:

One year when stored unopened and kept free from frost.

SAFETY ASPECTS:

READY TO SPRAY VOC:

Autowave Filler: 1.6 lb/gal 190 g/liter

NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an organic vapor respirator or air supplied respirator when exposed to vapors or spray mist.