



Effective October 11, 2010

# 1052R / 1056R

## HIGH PRODUCTIVE SURFACER

### Description

2-component high solids surfacer with 2 methods of application:

- a. maxi filler;
- b. sanding surfacer.

Colour: off white, dark grey.

Composition based on special hydroxy functional acrylic.

### Products

1052R	High Productive Surfacers - off white
1056R	High Productive Surfacers - dark grey
1010R	Activator Fast
125S	Standard Activator
256S	Activator Fast
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
AR7305	High Performance Activator
1025R	High Solids Primer Thinner
XB383	Standard Thinner

### Properties

- Easy to apply, smooth flow.
- Very easy to sand even after 1 hr air dry.
- Superb filling.
- Part of ValueShade® concept.
- Can be coated with all DuPont Refinish topcoats.
- VOC compliant, conform with directive 2004/42/EC.

### Substrates

- OEM or cured repair finishes.
- E-coats
- Sanded DuPont Refinish polyester putties.
- DuPont Refinish wash primers.
- DuPont Refinish epoxy primers.

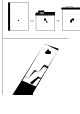










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### PRODUCT PREPARATION

	Mixing ratio	Maxi filler			Sanding surfacer			
		Volume	Weight	Volume	Weight			
	1052R/1056R 1010R or 125S 1025R	4 1 0.5	100 18 8	4 1 1	100 18 16			
	VOC	520 g/l			540 g/l			
	Pot life at 20°C	45 min			1 hr			
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	- - -	21-23 s 22-24 s 24-26 s				
	Spray equipment	<b>Conventional guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
		Gravity feed Suction feed Pressure feed	1.4-1.8 mm - 1.1-1.4 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar	1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar
		<b>Compliant guns (HVLPHTE)</b>						
		Gravity feed Suction feed Pressure feed	1.4-1.8 mm - 1.1-1.4 mm	15 cm 15 cm 15 cm	According to supplier's specifications	1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	15 cm 15 cm 15 cm	According to supplier's specifications
	Number of coats	1-3						
	Flash time	Between coats till flat. 30 min before bake.			Between coats till flat. 10 min before bake.			
	DFT	60-80 µ/coat			40-60 µ/coat			
	Dry to sand at 15°C at 20°C at 40°C at 60°C	2-4 hr 1 hr - 1 hr 30 min 40 min 30 min			2 hr 1 hr 30 min 25 min			
	IR drying*	Distance Half power	30-50 cm 10 min			* Guideline for short/medium wave IR equipment.		

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

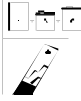









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## PRODUCT PREPARATION (con'd)

	<b>Mixing ratio</b> 1052R/1056R 256S XK203/XK205/AR7305 XB383	<b>Sanding surfacer</b>			
		Volume	Weight	Volume	Weight
		5	100	7	100
		1	14	-	-
		-	-	1	11
		1.5	18	2.5	22
<b>VOC</b>	540 g/l				
	<b>Pot life at 20°C</b>	1 hr			
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	20-22 s	20-23 s	
		<b>FORD 4</b>	21-23 s	21-24 s	
		<b>AFNOR 4</b>	23-25 s	23-26 s	
	<b>Spray equipment</b>	<b>Conventional guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
		Gravity feed	1.4-1.6 mm	20-25 cm	3-4 bar
		Suction feed	1.6-1.8 mm	20-25 cm	3-4 bar
		Pressure feed	1.0-1.2 mm	20-25 cm	3-4 bar
		<b>Compliant guns (HVLPHTE)</b>			
		Gravity feed	1.4-1.6 mm	15 cm	According to supplier's specifications
		Suction feed	1.6-1.8 mm	15 cm	
		Pressure feed	1.0-1.2 mm	15 cm	
	<b>Number of coats</b>	1-3			
	<b>Flash time</b>	Between coats till flat. 10 min before bake.			
	<b>DFT</b>	40-60 µ/coat			
	<b>Dry to sand</b>				
	at 15°C	2 hr			
	at 20°C	1 hr			
	at 40°C	30 min			
	at 60°C	25 min			
	<b>IR drying*</b>	Distance	30-50 cm	* Guideline for short/medium wave IR equipment.	
		Half power	10 min		
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## RECOMMENDED USE

### Surface preparation

#### OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
  - a. before applying maxi filler: mechanical with P80 - P120, wet with P150 - P240;
  - b. before applying sanding surfacer: mechanical with P220 - P280, wet with P360 - P500.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.  
5717S is not recommended if polyester putty is required.
- Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
- Apply 1 coat of DuPont Refinish wash primer or DuPont Refinish epoxy primer.

#### Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a DuPont Refinish preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
5. Apply 1 coat of DuPont Refinish wash primer or DuPont Refinish epoxy primer.

### Application selection

#### Maxi filler

To isolate polyester putty spots, to fill up small sand scratches or sand throughs.

#### Sanding surfacer

For spot, panel and overall repair.

### Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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### RECOMMENDED USE (con'd)

Remarks
- Do not use activated 1052R/1056R beyond the pot life nor reduce it further to get viscosity down again.
- If 1052R/1056R is applied over thermoplastic acrylic finishes, complete panel or overall car has to be treated. Spot repairing or sand throughs of the surfacer can result in spot marking or lifting when applying a basecoat.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- The use of high performance activators will positively influence the adhesion and stonechip performance of the complete paint system.
- For flexible systems, see specific TDS.
- For ValueShade® concept, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

Product data
Package viscosity: 2500-3000 cp (at 5 rpm) 900-1200 cp (at 20 rpm)
Theoretical coverage: Maxi filler 7.5 m <sup>2</sup> /l at 50 μ DFT Sanding surfacer 6.3-7 m <sup>2</sup> /l at 50 μ DFT
Directive 2004/42/EC: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
1052R	1 - 3.5	2	1.376
1056R	1 - 3.5	2	1.378
1010R	1 - 5	3	0.991
125S	0.5 - 1 - 5	3	0.959
256S	1 - 5	3	0.995
XK203	1 - 5	3	1.060
XK205	1 - 5	3	1.059
AR7305	1	2	1.083
1025R	1 - 5	4	0.871
XB383	1 - 5 - 20	4	0.847

Safety
Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.



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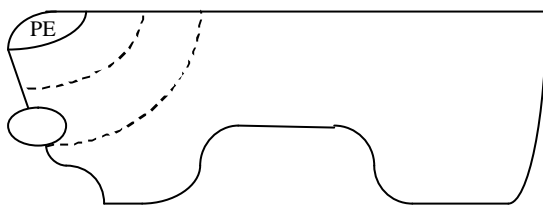
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## REPAIR SYSTEMS

### Preparation method for spot repair

P280 P320 P360



1. Sand through, end with P280.
2. Fill the spot with DuPont Refinish polyester putty and sand with P280.
3. Sand the surrounding area with P320 and finish on the OEM finish with P360.
4. Apply 1 coat of DuPont Refinish wash primer or DuPont Refinish epoxy primer over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1<sup>st</sup> coat of surfacer over the entire prepared area. Flash till completely flat.  
Apply 2<sup>nd</sup> coat of surfacer, staying inside the 1<sup>st</sup>-coat area. Flash till flat.