



Effective 2 June, 2009

VR-1140

VALUESURFACER VOC

Description

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

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

Colour: off white.

Composition based on an acrylic resin.

Products

VR-1140	ValueSurfacer VOC
VR-1130	ValueActivator Fast
VR-1131	ValueActivator
VR-1132	ValueActivator Slow
VR-1150	ValueThinner

Properties

- Easy to apply, smooth flow.
- Very easy to sand.
- Superb filling and excellent sagging resistance.
- Can be coated with all DuPont Refinish topcoats.
- Can be tinted with AM Centari® MasterTints® (up to max. 10 % by weight).
- VOC compliant, conform with directive 2004/42/EC.

Substrates

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

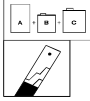










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PRODUCT PREPARATION

	Mixing ratio	VR-1140 VR-Activator VR-1150	Maxi filler			Sanding surfacer		
			Volume	Weight	Volume	Weight		
			6	100	6	100		
			1	11	1	11		
			-	-	0.7	7		
	VOC		< 540 g/l			540 g/l		
	Pot life at 20°C		30-45 min			1 hr - 1 hr 30 min		
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	35-40 s 39-44 s 41-47 s			21-23 s 22-24 s 24-26 s		
	Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure	Fluid tip	Distance	Pressure
			1.6-1.8 mm	20-25 cm	3-4 bar	1.5-1.7 mm	20-25 cm	3-4 bar
		Compliant guns (HVLP/HTE) Gravity feed Suction feed Pressure feed	1.8-2.0 mm	20-25 cm	3-4 bar	1.6-1.8 mm	20-25 cm	3-4 bar
			1.1-1.4 mm	20-25 cm	3-4 bar	1.0-1.2 mm	20-25 cm	3-4 bar
			1.6-1.9 mm	15 cm	According to supplier's specifications	1.4-1.6 mm	15 cm	According to supplier's specifications
			1.9-2.2 mm	15 cm		1.8-2.0 mm	15 cm	
			1.1-1.4 mm	15 cm		1.0-1.2 mm	15 cm	
	Number of coats	2-4						
	Flash time	Between coats till flat. 5-10 min before bake.						
	DFT	40-50 µ/coat						
	Dry to sand at 20°C at 60°C		VR-1130	VR-1131	VR-1132	VR-1130	VR-1131	VR-1132
			O.N 20-25 min	O.N 25-30 min	O.N 30-35 min	2 hr 20 min	2 hr 30 min 25 min	3 hr 30 min
	IR drying*	Distance Half power Full power	80 cm 5 min 15-20 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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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 VR-1140 beyond the pot life nor reduce it further to get viscosity down again.
- If VR-1140 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.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.
- ValueShade[®] 2 (VS2) is equal to 100 % of VR-1140.
- ValueShade[®] 3 (VS3) can be obtained by adding 1.5 g of AM5 to 100 g of VR-1140.
- ValueShade[®] 4 (VS4) can be obtained by adding 6.5 g of AM5 to 100 g of VR-1140.
- ValueShade[®] 5 (VS5) can be obtained by adding 10 g of AM5 to 100 g of VR-1140.

Product data

Package viscosity: 1400-16000 cp (at 5 rpm)
5000-7000 cp (at 20 rpm)

Theoretical coverage: Maxi filler 5.5 m²/l at 80 μ DFT
Sanding surfacer 5 m²/l at 80 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)
VR-1140	3.5	2	1.567
VR-1130	1	3	1.023
VR-1131	1	3	1.023
VR-1132	1	3	1.020
VR-1150	1	4	0.919

Safety

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



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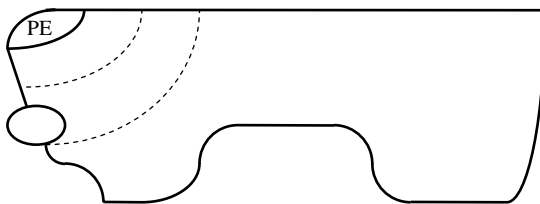
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REPAIR SYSTEMS

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 1st coat of surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of surfacer, staying inside the 1st-coat area. Flash till flat.