

GENERAL INFORMATION

FP141G Universal Surfacers Grey can be used for small to large repair work over multiple automotive substrates. It can be applied directly on e-Coat primed parts and does not require an additional guide coat due to its glossy appearance after drying.

This TDS is about the Non-Sanding version.

MIXING RATIO



- 3 : 1 Surfacers : MS Hardener + max 10% Uni Thinner
- 7 : 2 Surfacers : HS Hardener + max 10% Uni Thinner
- 6 : 1 Surfacers : HS420 Hardener + max 25% Uni Thinner

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,3-1,4	1,8-2,0/26-29

APPLICATION



1 coat 25 - 40 µm

FLASH AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	15 minutes	Flash off	-	
Dust free	-	Dust free	-	
Dry to handle	-	Dry to handle	-	
Dry to tape	-	Dry to tape	-	
Dry to sand	-	Dry to sand	-	
Dry to polish	-	Dry to polish	-	

Overspray window 15 minutes till 48 hours

SUBSTRATES



Properly cleaned unsanded ridged OEM e-Coat panels.
Properly cleaned and sanded original OEM paint system.
Properly cleaned and sanded GRP Glass Fibre Reinforced Polyester laminates.
PW170 Washprimer. Bare metal not exceeding 10 cm² (PW170 Washprimer recommended).

SUBSTRATES PLASTIC



Substrate	FP141 Non-Sanding
ABS	It has good direct to ABS adhesion, no need to use the PA65 1K Plastic Primer.
PP	It has good direct to PP adhesion, no need to use the PA65 1K Plastic Primer.
PP/EPDM	It is possible to replace the thinner with the PA65 1K Plastic Primer. It is also possible to spray the PA65 1K Plastic Primer first.

COMPONENTS



- H35 MS Hardener Medium
- H36 MS Hardener Slow
- H55 HS Hardener Medium
- H56 HS Hardener Slow
- H25 HS420 Hardener Medium
- H26 HS420 Hardener Slow
- TA910 Uni Thinner Medium
- TA920 Uni Thinner Slow

ADDITIVES



AE001 Elastic 2K

Check TDS of AE001. Add before hardener.

POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)	
MS hardeners	40 - 45 min
HS hardeners	30 - 35 min
HS420 hardeners	37 - 45 min

SURFACE PREPARATION



Wash surface with TD80 Octobase Eco Degreaser or mild detergent and water. Rinse with water and dry the surface. Wipe surface with TD20 Silicone Remover and wipe dry with a clean cloth before the product flashes off. Final sanding if needed P400 if the complete panel will be primed. Spot repair/ local priming: final sanding with P500. Wipe surface with TD20 Silicone Remover and wipe dry with a clean cloth before the product evaporates. Plastic surface preparation refer to the PA65 1K Plastic Primer TDS for full details on the recommended preparation for plastic parts. Mask entire vehicle to eliminate unwanted overspray. After 48 hours thorough sanding with P400-500 is needed before the topcoat system can be applied.

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NEXT LAYER



W00 - W999 Octobase Eco Plus System
F00 - F98 Octocoat HS420 System

In order to obtain the best result, we recommend the use of HS420 clears.

PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/IIIB(c)(540)540	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIB/c. Primer - Surfacers/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 540 g/l VOC.	
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	14 - 17 Dincup 4 / 20°C
	Specific Gravity (kg/l)	With MS hardeners: 1,37 (Grey) With HS hardeners: 1,39 (Grey) With HS420 hardeners: 1,38 (Grey)
	Flash Point Closed Cup	33°C / 91,4°F
	Volume % Solids	With MS hardeners: 40 (Grey) With HS hardeners: 43 (Grey) With HS420 hardeners: 42 (Grey)
	Economy	With MS hardeners: 13 m ² (Grey) With HS hardeners: 14 m ² (Grey) With HS420 hardeners: 14 m ² (Grey) (with 30 µm layer thickness)
	Gloss	Egg Gloss
	Colour	Grey

PROTECTION



Use suitable respiratory protection (*we recommend the use of a fresh air supply respirator*).

For more detailed information please visit the following link for the Safety Data Sheet:

<https://sds.octoral.com>

CLEANUP



Gun Cleaner

STORAGE/SHELF LIFE



Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES

