

### GENERAL INFORMATION

FP141G Universal Surfacers Grey can be used for small to large repair work over multiple automotive substrates, offers outstanding sandability and is sandable within 2 hours at 20°C. 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 Sanding version.**

### MIXING RATIO



- 3 : 1 Surfacers : MS Hardener + max 5% Uni Thinner
- 7 : 2 Surfacers : HS Hardener + max 5% Uni Thinner
- 6 : 1 Surfacers : HS420 Hardener + max 15% Uni Thinner

### GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4-1,6	2/29
HE	1,4-1,6	1,6-2,0/23-29

### APPLICATION



2 - 3 coat 60-180 µm

### FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 40°C / 104°F	FORCED DRY 60°C / 140°F
Flash off	10 - 15 minutes	10 - 15 minutes	10 - 15 minutes
Dust free	-	-	-
Dry to handle	-	-	-
Dry to tape	-	-	-
Dry to sand	1.5 - 4 hours	45 - 60 minutes	20 - 30 minutes
Dry to polish	-	-	-

### SUBSTRATES



FP141G Universal Surfacers Grey should only be applied over well sanded/scuffed and degreased primed bare steel, primed aluminium. Well sanded and degreased GRP, polyester fillers and old paint systems in good condition. Well cleaned and degreased non-sanded OEM primer.

Bare metal not exceeding 10 cm<sup>2</sup> (PW170 Washprimer recommended).

On bare steel and aluminium use PW170 Washprimer for maximum durability and rust protection.

### SUBSTRATES PLASTIC



Substrate	FP141 Sanding
ABS	It has good direct to ABS adhesion, no need to use the PA65 1K Plastic Primer.
PP	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.
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.

### POTLIFE



POTLIFE (+3 SEC/ DIN CUP 4 @ 20C)	
MS hardeners	25 - 30 min
HS hardeners	20 - 25 min
HS420 hardeners	18 - 22 min

### COMPONENTS



- H34 MS Hardener Fast
- H35 MS Hardener Medium
- H36 MS Hardener Slow
- H53 HS Hardener Very Fast
- H54 HS Hardener Fast
- H55 HS Hardener Medium
- H56 HS Hardener Slow
- H23 HS420 Hardener Very Fast
- H24 HS420 Hardener Fast
- H25 HS420 Hardener Medium
- H26 HS420 Hardener Slow
- TA900 Uni Thinner Fast
- TA910 Uni Thinner Medium
- TA920 Uni Thinner Slow

### ADDITIVES



AE001 Elastic 2K

**Check TDS of AE001. Add before hardener.**

### DRY TIMES AND DISTANCE IR



	FLASH TIME	Half-bake	Full-bake
Maximum 3 coats	5 minutes	8 minutes	7 minutes

ON PLASTIC	FLASH TIME	Half-bake	Full-bake
Maximum 3 coats	5 minutes	8 minutes	9 minutes

**Follow the IR equipment recommendations for optimal distance between object and IR-lamps.**

### SURFACE PREPARATION



Pre-clean the surface with TD20 Silicone Remover. Wipe on and wipe dry. Sand surface with P180-P240 grit abrasive. Remove all sanding debris with compressed air. Sanding vacuum and clean with TD20 Silicone Remover. Wipe on and wipe dry. Final sanding before application P280-P320 feather-edge and GPR P400. 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.**

### NEXT LAYER



W00 - W999 Octobase Eco Plus System  
 F00 - F98 Octocoat HS420 System  
 B00 - B999 Octobase System  
 A00 - A98 Octocryl System

### PHYSICAL DATA

EU REGULATIONS		
<b>VOC Code</b>	2004/42/II(B)(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 - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 540 g/l VOC.	
<b>Chemical Base</b>	2K Polyurethane Primer	
<b>Physical Properties</b>	<b>Viscosity (RTS)</b>	15 - 19 Dincup 4 / 20°C
	<b>Specific Gravity (kg/l)</b>	With MS hardeners: 1,39 (Grey) With HS hardeners: 1,42 (Grey) With HS420 hardeners: 1,42 (Grey)
	<b>Flash Point Closed Cup</b>	33°C / 91,4°F
	<b>Volume % Solids</b>	With MS hardeners: 42 (Grey) With HS hardeners: 45 (Grey) With HS420 hardeners: 45 (Grey)
	<b>Economy</b>	With MS hardeners: 7 m <sup>2</sup> (Grey) With HS hardeners: 8 m <sup>2</sup> (Grey) With HS420 hardeners: 8 m <sup>2</sup> (Grey) (with 60 µm layer thickness)
	<b>Gloss</b>	Egg Gloss
	<b>Colour</b>	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

