

1040R

UNIVERSAL 2K SURFACER GREY



PRODUCT DESCRIPTION

Universal 2K Surfacers Grey 1040R is a high-solids surfacer with excellent filling properties that helps to lower overall consumption. It is easy to apply and can be wet and dry sanded, even several days after application. Universal 2K Surfacers Grey 1040R can also be tinted to accommodate difficult topcoat colours.

Excellent maxi filler

FEATURES

- 01 Provides excellent topcoat hold-out.
- 02 Can be coated with all Cromax topcoats.
- 03 Offers easy application and smooth flow.
- 04 Dries quickly.
- 05 Suitable for use over rigid and flexible plastic parts.
- 06 Has superb filling properties.
- 07 Can be tinted up to a maximum of 10% with AM Centari MasterTints.
- 08 Very easy to sand, even days after application.

TECHNICAL DATA SHEET

1040R

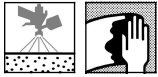


UNIVERSAL 2K SURFACER GREY

Product preparation - application STANDARD SANDING HS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer or Epoxy Primer
Old or original paintwork well sanded and cleaned
OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Standard	
	Volume	Weight
1040R	5	100
256S	1	13
1025R	2	23



Pot life at 20°C: 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8 mm	1.5 - 2 bar	inlet pressure
HVLP	1.7 - 1.9 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 2 coats

intermediate flash-off until matt
final flash-off: 10 min



	256S/1025R
20 °C	3 hr
60 - 65 °C	25 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 15 - 20 min



P400 - P600



Centari 2K Topcoats
Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

TECHNICAL DATA SHEET



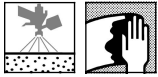
1040R

UNIVERSAL 2K SURFACER GREY

Product preparation - application STANDARD SANDING MS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer or Epoxy Primer
 Old or original paintwork well sanded and cleaned
 OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
 Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Standard	
	Volume	Weight
1040R	4	100
1010R / 125S / 255MS	1	16
1025R	2	29



Pot life at 20°C: 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8 mm	1.5 - 2 bar	inlet pressure
HVLP	1.7 - 1.9 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 2 coats

intermediate flash-off until matt
 final flash-off: 10 min



	255MS/1025R	1010R/1025R	125S/1025R	
20 °C	3 hr	3 hr	4 hr	
60 - 65 °C	25 min	25 min	30 min	



Guideline for short wave IR equipment
 Half power: 5 min
 Full power: 15 - 20 min



P400 - P600



Centari 2K Topcoats
 Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

TECHNICAL DATA SHEET

1040R

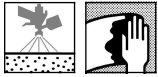


UNIVERSAL 2K SURFACER GREY

Product preparation - application STANDARD NON-SANDING



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer or Epoxy Primer
Old or original paintwork well sanded and cleaned
OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Standard	
	Volume	Weight
1040R	4	100
1010R / 125S / 255MS	1	16
1030R	3	44



Pot life at 20°C: 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4 mm	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.4 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 2 coats

intermediate flash-off until matt
final flash-off: 15 min - 8 hr



Centari 2K Topcoats
Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

TECHNICAL DATA SHEET



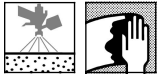
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UNIVERSAL 2K SURFACER GREY

Product preparation - application STANDARD MAXI HS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer or Epoxy Primer
 Old or original paintwork well sanded and cleaned
 OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
 Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Standard	
	Volume	Weight
1040R	5	100
256S	1	13



Pot life at 20°C: 45 min



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8 mm	1.5 - 2 bar	inlet pressure
HVLP	1.7 - 1.9 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats
 intermediate flash-off until matt
 final flash-off: 30 min



	256S
20 °C	8 hr - 12 hr
60 - 65 °C	30 min



Guideline for short wave IR equipment
 Half power: 5 min
 Full power: 15 - 20 min



P400 - P600



Centari 2K Topcoats
 Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

TECHNICAL DATA SHEET



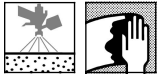
1040R

UNIVERSAL 2K SURFACER GREY

Product preparation - application STANDARD MAXI MS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Galvanised steel or soft aluminium, sanded and cleaned and coated with Wash Primer or Epoxy Primer
 Old or original paintwork well sanded and cleaned
 OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned
 Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	Standard	
	Volume	Weight
1040R	4	100
1010R / 125S / 255MS	1	16



Pot life at 20°C: 45 min



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8 mm	1.5 - 2 bar	inlet pressure
HVLP	1.7 - 1.9 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

intermediate flash-off until matt
 final flash-off: 30 min



	1010R / 255MS	125S	
20 °C	8 hr - 12 hr	10 hr - 16 hr	
60 - 65 °C	30 min	35 min	



Guideline for short wave IR equipment
 Half power: 5 min
 Full power: 15 - 20 min



P400 - P600



Centari 2K Topcoats
 Basecoat + Clearcoat

VOC compliant

This product mix is not VOC compliant.

TECHNICAL DATA SHEET

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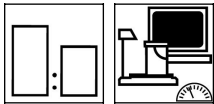


UNIVERSAL 2K SURFACER GREY

Products

- 1040R Universal 2K Surfacers Grey
- 1010R High Solids Activator
- Fast 125S Standard Activator
- 255MS Universal Activator Fast
- 256S Activator Fast
- 1025R High Solids Surfacers Thinner
- 1030R High Solids Non-Sanding Converter

Product mix



Mixing ratios with special agents are available in the productmix table on ChromaWeb and in the specific TDS.



40 - 60 μm per coat (sanding surfacer)
60 - 80 μm per coat (maxi filler)



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Close can of Activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Surfacers are tintable up to 10% with AM Centari MasterTints. Drying and sanding can be affected.
- Surfacers have to be applied over the complete panel or overall car if the OEM paintwork is not well cured. Spot repairing or sand throughs of the surfacer can result in spot marking or lifting when applying a basecoat.
- For Semi-Flexible systems 10% 805R Flexible Additive can be added to the base material. Activator and Thinner ratios remain equal.
- For Full-Flexible systems the mixing ratios are available in the productmix table on Chromaweb.

TECHNICAL DATA SHEET

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UNIVERSAL 2K SURFACER GREY

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

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

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