

XF3081 - XF3084 - XF3087

ULTRA PERFORMANCE SURFACER



PRODUCT DESCRIPTION

Maintaining the high productivity and excellent performance of the PS1081/PS1084/PS1087 Ultra Performance Energy Surfer, the XF3081/ XF3084/ XF3087 Ultra Performance Surfer leads to an even more productive and streamlined preparation process. With a very impressive air-drying performance, it's ideal for all bodyshops who would like to increase productivity while also reducing complexity.

A surfer that breaks records for high throughput and low complexity.

FEATURES

- 01** Streamlined two-in-one surfer, combining sanding & non-sanding options into one product.
- 02** Simple 1:1 mixing ratio,
- 03** The high-quality appearance provides outstanding gloss hold-out after top coating.
- 04** Shows extra-fast air-drying performance. It can be sanded from as quickly as 30 minutes after air drying.
- 05** Easy to apply, in up to four coats, with very good vertical stability.
- 06** Non-sanding version has a very impressive overcoat and denibbing time with five minutes air drying.
- 07** On metal substrate, the use of PS1800 Metal Pretreatment Wipes is mandatory.
- 08** Part of the ValueShade concept: available in white (VS1), grey (VS4), and black (VS7).

TECHNICAL DATA SHEET

XF3081 - XF3084 - XF3087

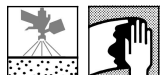


ULTRA PERFORMANCE SURFACER

Product preparation - application SANDING - Energy Surfacer Activator



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



Steel, galvanised steel and soft aluminium, sanded and cleaned, treated with PS1800 Metal Pretreatment Wipes
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
XF3081	100	80	50	-	-	-	-
XF3084	-	20	50	100	75	45	-
XF3087	-	-	-	-	25	55	100

Standard Sanding		
	Volume	Weight
XF3081 XF3084 XF3087	1	100
AR7602 AR7801*	1	55
AZ9800	0.2	10

* Below 15°C & 30% RH, when drying is too slow, use AR7801 Energy Surfacer Activator LT/LH.



Pot life at 20°C: 30 min - 1 hr

* Setting with AR7801 Energy Surfacer Activator LT/LH, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1 - 1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 4 coats

until flat after the first coat, for the subsequent coats no flash-off is required



	AR7602 / AR7801
20 °C	30 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min



Guideline for short wave IR equipment
Half power: 5 - 10 min



P500 - P600



Cromax Pro Basecoat + Clearcoat
Centari Basecoat + Clearcoat
Centari 2K Topcoat
Surfacers should be sanded and cleaned just prior the application of basecoat.

VOC compliant

2004/42/IB(c)(540) 540: 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.

TECHNICAL DATA SHEET

XF3081 - XF3084 - XF3087

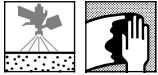


ULTRA PERFORMANCE SURFACER

Product preparation - application SANDING HIGH BUILD - Energy Surfacers Activator



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



Steel, galvanised steel and soft aluminium, sanded and cleaned, treated with PS1800 Metal Pretreatment Wipes
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
XF3081	100	80	50	-	-	-	-
XF3084	-	20	50	100	75	45	-
XF3087	-	-	-	-	25	55	100

Standard High Build		
	Volume	Weight
XF3081 XF3084 XF3087	1	100
AR7602 AR7801*	1	55
AZ9800	0.2	10

* Below 15°C & 30% RH, when drying is too slow, use AR7801 Energy Surfacers Activator LT/LH.



Pot life at 20°C: 30 min - 1 hr

* Setting with AR7801 Energy Surfacers Activator LT/LH, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1 - 1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 4 coats

First coat flashed till flat: 2 min - 5 min
with intermediate flash-off: 1 min - 2 min



Guideline for short wave IR equipment
Half power: 5 - 10 min



P500 - P600



Cromax Pro Basecoat + Clearcoat
Centari Basecoat + Clearcoat
Centari 2K Topcoat
Surfacer should be sanded and cleaned just prior the application of basecoat.

VOC compliant

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IIB(c)) in ready to use form is maximum

TECHNICAL DATA SHEET

XF3081 - XF3084 - XF3087

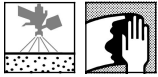


ULTRA PERFORMANCE SURFACER

Product preparation - application SANDING PLASTICS - Energy Surfacer Activator



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



Repairs to exterior common plastic car parts, sanded and cleaned.
OEM Primer for plastic, scuff sanded and cleaned.
New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in 3950S Anti-static Degreaser / final cleaning use a cloth moistened with 3950S Anti-static Degreaser.
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth.
Change cloths often, never use dirty cloths.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
XF3081	100	80	50	-	-	-	-
XF3084	-	20	50	100	75	45	-
XF3087	-	-	-	-	25	55	100
Standard Plastics							
	Volume				Weight		
XF3081 XF3084 XF3087	1				100		
AR7602	1				55		
AZ9700	0.4				20		



Pot life at 20°C: 30 min - 1 hr
* Setting with AR7801 Energy Surfacer Activator LT/LH, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 3 coats
until flat after the first coat, for the subsequent coats no flash-off is required



	AR7602
20 °C	30 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min



P500 - P600



Cromax Pro Basecoat + Elastified Clearcoat
Centari Basecoat + Elastified Clearcoat
Elastified Centari 2K Topcoat
Surfacers should be sanded and cleaned just prior the application of basecoat.

VOC compliant

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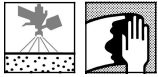


ULTRA PERFORMANCE SURFACER

Product preparation - application WET-ON-WET – Energy Surfacer Activator



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



Steel, galvanised steel and soft aluminium, sanded and cleaned, treated with PS1800 Metal Pretreatment Wipes

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.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
XF3081	100	80	50	-	-	-	-
XF3084	-	20	50	100	75	45	-
XF3087	-	-	-	-	25	55	100

	Standard		> 25°C and /or 50% RH	
	Volume	Weight	Volume	Weight
XF3081 XF3084 XF3087	1	100	1	100
AR7602	1	55	1	55
AZ9800	0.2	11		
XB387			0.2	11



at 20°C: 30 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.5 - 1.8 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	air cap pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Very early denibbing at the earliest after 5 min possible.



Cromax Pro Basecoat + Clearcoat
Centari Basecoat + Clearcoat
Centari 2K Topcoat

VOC compliant

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XF3081 - XF3084 - XF3087

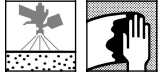


ULTRA PERFORMANCE SURFACER

Product preparation - application WET-ON-WET PLASTICS – Energy Surfacers Activator



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



Repairs to exterior common plastic car parts, sanded and cleaned.

OEM Primer for plastic, scuff sanded and cleaned.

New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in 3950S Anti-static Degreaser / final cleaning use a cloth moistened with 3950S Anti-static Degreaser.

Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth.

Change cloths often, never use dirty cloths.



	VS1	VS2	VS3	VS4	VS5	VS6	VS7
XF3081	100	80	50	-	-	-	-
XF3084	-	20	50	100	75	45	-
XF3087	-	-	-	-	25	55	100

		Standard Plastics	
		Volume	Weight
XF3081		1	100
XF3084			
XF3087			
AR7602		1	55
AZ9700		0.4	20



Pot life at 20°C: 30 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.5 - 1.8 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	air cap pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Very early denibbing at the earliest after 5 min possible.



Cromax Pro Basecoat + Elastified Clearcoat

Centari Basecoat + Elastified Clearcoat

Elastified Centari 2K Topcoat

VOC compliant

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TECHNICAL DATA SHEET

XF3081 - XF3084 - XF3087



ULTRA PERFORMANCE SURFACER

Products

XF3081 Ultra Performance Surfacers - VS1

XF3084 Ultra Performance Surfacers - VS4

XF3087 Ultra Performance Surfacers - VS7

AR7602 Performance Surfacers Activator

AR7801 Energy Surfacers Activator LT/LH

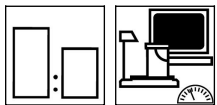
AZ9700 Ultra Performance Plastic Additive

AZ9800 Energy Surfacers Accelerator

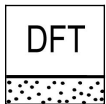
XB383 Standard Thinner

XB387 HI-Temp Thinner

Product mix



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



80 - 150 μm Sanding
120 - 250 μm Sanding High Build
80 - 150 μm Sanding Plastics
25 - 50 μm Wet-on-Wet

Theoretical coverage

380 - 385 m^2/l at 1 micron dry film thickness

Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

TECHNICAL DATA SHEET

XF3081 - XF3084 - XF3087



ULTRA PERFORMANCE SURFACER

Remarks

- Mix thoroughly by hand before placing the can on mixing machine.
- Humidity has an accelerating influence on the drying performance and potlife.
- The use of the PS1800 Metal Pretreatment Wipes is mandatory for bare metal substrates. Non-use can be detected analytically.
- Material has to be at room temperature (18-25°C) before use.
- Can also be applied with short intermediate flash-off time to isolate Putty repairs and sensitive prep work.
- Surplus material should not be returned to the original can.
- Very early sanding will be achieved with premium / flexible sanding discs.
- Sandable as of 30 min depending on the humidity / temperature and dry film thickness.
- After usage all cans must be closed immediately.
- If required, for large areas up to 5% thinner can be added to the mixed material.
- If Ultra Performance Surfer XF308X is mixed with AZ9700 Ultra Performance Plastic Additive, this mixture can also be applied to adjacent metal parts (bare metal areas need to be pre-primed with PS1800 Metal Pretreatment Wipes) although this is not the primary intention.
- For improved adhesion properties, particularly on critical plastic substrates such as e.g. PP, the use of Cromax Plastic Adhesion Promotor 800R / 800RA prior the application of XF3081 – XF3084 – XF3087 Ultra Performance Energy Surfer mixed with AZ9700 Ultra Performance Plastic Additive is recommended.
- For more detailed information, e.g. suitable plastic substrates, please refer to the Cromax Plastic Painting System Data Sheet CXPlasticSystem.

Intermediate Valueshades can also be obtained by mixing XF3081 and XF3087.

	VS1	VS2	VS3	VS4	VS5	VS6	VS7
XF3081	100	94	85	70	45	27	-
XF3087	-	6	15	30	55	73	100

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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