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PRODUCT DATA SHEET

Rev. 1

T.D.S.

AUTOMELSURFACER 640

DESCRIPTION

Automelsurfacer 640 is high build, quick drying, two-pack acrylic urethane primer-surfacer with good filling, leveling and enamel-hold-out properties. It can be used in both sanding and non-sanding systems for car refinishing.

PERFORMANCE FEATURES

- Sanding and non-sanding quality
- Good Intercoat Adhesion
- Good enamel-hold-out
- Corrosion resistant
- Excellent recoatability

PHYSICAL PROPERTIES

Colour	:	Yellowish grey
Density, lb/gal	:	11.5 – 12.5
Flash Point, °C	:	35
Viscosity, cP	:	1000 - 1300

COVERAGE RATE

Approximately 20m²/L

SUITABLE SUBSTRATE

- Existing finishes
- Edgechem polyester fillers
- Wash primers and etching primers
- Aluminum
- Steel surfaces

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The suggestions recommendations and technical data in this document are based on information we believe to be valid. However, they are offered without guarantee as application and methods of use of our products are beyond our control. We recommend that users evaluate our materials before adopting them for commercial uses. Suggestions for use of our products should not be understood as recommendations that may be used in violation of any patent.

AUTOMELSURFACER 640**SURFACE PREPARATION**

- Existing Finishes - Degrease and dry sand with P220-P320-grit sandpaper or wet sand with P400 – grit sandpaper.
- Polyester Filler - Degrease and dry sand with P320-grit sandpaper.
- Steel Surfaces - Degrease and dry sand with P220-grit sandpaper.
- Aluminum Surfaces - Degrease and abrade with etch primer.

APPLICATION

Spray 2-3 single wet coats allowing 5-10 minutes for flash-off between coats, depending on temperature and film thickness.

Tinting

Tintable with up to 10 parts by volume of Automel Enamel solid colours before adding hardener.

Mixing Ratio by Volume

	<u>SANDING</u>	<u>NON-SANDING</u>
Automelsurfacer 640	4	4
640 Hardener	1	1
Urethane Reducer		1.5

SPRAY GUN FLUID TIP AND WORKING PRESSURE**SANDING VERSION**

<u>Spray Gun:</u>	<u>Fluid Tip:</u>	<u>Working Pressure:</u>
Gravity feed	1.6-1.8 mm	3-4 bar
Siphon feed	1.8-2.0 mm	3-4 bar
HVLP Gravity feed	1.7-2.0 mm	max 0.7 bar at air-cap
HVLP Siphon feed	2.0-2.4 mm	max 0.7 bar at air-cap

AUTOMELSURFACER 640**NON-SANDING VERSION**

<u>Spray Gun:</u>	<u>Fluid Tip:</u>	<u>Working Pressure:</u>
Gravity feed	1.2-1.5 mm	3-4 bar
Siphon feed	1.4-1.6 mm	3-4 bar
HVLP Gravity feed	1.3-1.6 mm	max 0.7 bar at air-cap
HVLP Siphon feed	1.6-1.8 mm	max 0.7 bar at air-cap

Pot life:

2 hours depending on the temperature.

Drying Time

Dry to sand (Sanding Version): 2.5 – 3 hours.

The Non-sanding Version may be recoated without sanding after 30 minutes but within 1hour. Should this maximum time be exceeded, Automelsurfacer 640 must be sanded.

Recoatable with all Edgechem refinishing topcoats.

SHELF LIFE

2 years

CLEAN UP

Clean up with Edgechem Lacquer Thinner or Urethane Reducer.