

## GENERAL INFORMATION

PF345B Rapid Surfacers Black can be used for small to medium repair work over multiple automotive substrates. The sanding surfacer can be applied directly on e-Coat primed parts and does not require an additional guide coat due to its glossy appearance after drying.

## MIXING RATIO



1 : 1 Surfacers : Thinner + 25% Hardener on volume

**Please note: The surfacer and thinner can be pre-mixed. The hardener needs to be added to the spray mixture just before application, due to the limited pot life.**

## GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	1,5 / 22
HE	1,3-1,4	1,8 / 26

## APPLICATION



2 - 3 coats, maximum around 100-120 µm

## FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F	FORCED DRY 60°C / 140°F
Flash off	2 minutes	Flash off -
Dust free	15 - 20 minutes	Dust free -
Dry to handle	15 - 20 minutes	Dry to handle -
Dry to tape	20 - 40 minutes	Dry to tape -
Dry to sand	20 - 40 minutes	Dry to sand -
Dry to polish	-	Dry to polish -



**High film builds and low temperatures can increase dry times. Drying times may be slightly longer with temperatures below 20°C and low humidity.**

## SUBSTRATES



PF345B Rapid Surfacers Black should only be applied over well sanded/scuffed and degreased primed bare steel and primed aluminium.

Well sanded GRP, polyester fillers, OEM primer and old paint systems in good condition.

Use PW170 Washprimer recommended for maximum durability and rust protection.

## SUBSTRATES PLASTIC



Substrate	PF345G Rapid Surfacers
ABS	It has good direct to ABS adhesion, no need to use the PA65 1K Plastic Primer.
PP/EPDM	Spray the PA65 1K Plastic Primer

## COMPONENTS



TH345 Rapid Surfacers Thinner  
H345 Rapid Surfacers Hardener

## ADDITIVES



## POTLIFE



15 minutes

## SURFACE PREPARATION



Preclean 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 with P600 and P800 before application of Basecoat.

**Mask entire vehicle to eliminate unwanted overspray.**

## NEXT LAYER



W00 - W999 Octabase Eco Plus System  
B00 - B999 Octabase System

## INFRARED DRYING



After full flash off and at proper distance	
Half-bake	2 min 60°C
Full-bake	1 min 70°C
<b>See IR Manufacturer information</b>	



## PHYSICAL DATA

EU REGULATIONS PF345B Rapid Surfacers Black		
VOC Code	2004/42/IIIB(c)(540)463	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIIB/c. Primer - Surfacers/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 463 g/l VOC.	
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	12 - 14 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,19
	Flash Point Closed Cup	28°C / 82,4°F
	Volume % Solids	46,3
	Economy	185 ft <sup>2</sup> /Gal @ 4 mil
	Gloss	18,5 m <sup>2</sup> /L/100 μm
	Colour	Egg Gloss
	Black	

## PROTECTION



Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).

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

[SDS Octoral](#)

## CLEANUP



Gun Cleaner

## STORAGE/SHELF LIFE



The up-to-date shelf life overview can be found by clicking on the following link:

[Shelf life overview Octoral](#)

## NOTES

