



PD-709

## 2K Rollable Surfacers LV

# SX1080

SX1080 is a premium quality, rollable spot/repair primer surfacer for today's highly productive collision repair centers. This gray, 2K-primer surfacer is a high build, fast drying product that features superior sanding characteristics and excellent topcoat gloss holdout. SX1080 can be used over sanded original finishes and/or properly prepared bare steel, galvanized and aluminum substrates. Blended to apply, SX1080 complies with a maximum VOC limit of 2.1 lbs per gallon.



### Features

- High Solids
- User Friendly
- VOC Compliant

### Advantages

- Fills Quickly
- Quick Dry Time
- Easy Mixing and Sanding

### Benefits

- Increased Productivity
- Labor Savings

### Required Products

- SX1080 2K Rollable Surfacers LV
- SX1081 2K Rollable Surfacers LV Hardener
- SXA1030 Black Guide Coat
- SX1066 Light Build Roller
- SX1067 Medium Build Roller
- SX1068 Roller Handle
- SX1069 Roller Pan

### Compatible Products

#### SX1080 may be applied over:

- Steel - Properly sanded, cleaned and either treated or primed with etch primer. Product may be applied direct to metal for small dent and crease repairs. SX1080 is not recommended for larger areas such as full panel replacements.
- Zinc Coated Steel - Properly sanded, cleaned and either treated or primed with etch primer.
- Galvanized Steel - Properly sanded, cleaned and either treated or primed with etch primer.
- Aluminum - Properly sanded, cleaned and primed with etch primer.
- Plastics - Properly sanded, cleaned and primed with compatible primer.
- Cured and sanded OEM finishes. (Excluding Lacquer)
- Cured and sanded refinish topcoat systems (Excluding Lacquer)

**A minimum film build of 1.5 mils after sanding of SX1080 is recommended for optimum performance. This build will also seal out thermoplastic surfaces, which may lift upon color application.**



# SX1080

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## Application Data

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### Surface Preparation:



Sand the bare metal areas completely with P80 – P180 grit abrasive. Sand old finishes with P280 – P320 grit dry by hand or machine or P400 grit wet.



Clean with appropriate PPG wax and grease remover.

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### Application and equipment:



Using either the SX1066 Light Build Roller or the SX1067 Medium Build Roller attached to the SX1068 Roller Handle, fully cover the roller by rolling it in the SX1080 primer. SX1069 Roller Pans are designed to be solvent resistant, and may be cleaned and re-used or disposed of properly.

- **First Coat:** Start from the center of the repair and roll the primer all the way out to the clearcoat featheredge. Using a “flicking” or lifting technique will create a feathered edge all around the repair area. This technique will ensure a thin, smooth edge and make sanding easier.
- **Second and third Coat:** When the first coat has flashed for 3 – 5 minutes, start from the center and roll another coat to 1” past the outside edge of the previous coat, using a featheredge “lifting” technique. *Note: Failure to extend these coats past the outside edge of the previous coat's featheredge will trap solvent, over build the edge, and lead to shrinkage.*
- **Optional Forth Coat:** If needed, an optional fourth coat can be applied with the same technique used to apply the previous coats.
- **Sanding:** After an appropriate air dry, oven bake or I.R. cure, the SX1080 should be wet sanded with P400 followed by P600 or dry sanded with P360 followed by P500. After sanding, a minimum film build of 1.5 mils is recommended for optimum performance.

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### Mix Ratio:



<u>SX1080</u>	<u>SX1081</u>
4 parts	1 part



Pot Life: 30 minutes at 70°F and 50% RH  
(High heat and humidity will shorten pot life)

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## Application Data

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### Drying Times:



Air Dry: Cure 2 – 3 hours @ 70°F

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Between Coats: 3 – 5 minutes @ 70°F

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Oven Bake: Flash 10 min., bake 20 – 30 min. @ 140°F

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I.R. Cure: (Med.) Cure: Flash 10 min., bake 20 min.

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Sanding: DA sand with P360 grit followed by P500, or wet sand with P400 followed by P600 grit.

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### Properties:

Product	Packaged VOC Less Exempts (lbs./US Gal.)	Volume Solids (RTS)	Sq. Ft, Coverage @ 1 mil (100% transfer efficiency)
SX1080	2.10	N/A	N/A
SX1081	1.96	N/A	N/A
Ready to roll @ 4:1	2.08	46.42	744.6

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### Health and Safety:

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Emergency Medical or Spill Control Information (412) 434-4515;  
In Canada (514) 645-1320.

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## Instant Reference

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### Application Procedure:



Using either the SX1066 Light Build Roller or the SX1066 Medium Build Roller, apply as follows:

- **First Coat:** Start from the center of the repair and roll the primer all the way out to the clearcoat featheredge. Using a “flicking” or lifting technique will create a feathered edge all around the repair area. This technique will ensure a thin, smooth edge and make sanding easier.
- **Second and third Coat:** When the first coat has flashed for 3 – 5 minutes, start from the center and roll another coat to 1” past the outside edge of the previous coat, using a featheredge “lifting” technique. *Note: Applying primer all the way to the featheredge will trap solvent, over build the edge, and lead to shrinkage.*
- **Optional Forth Coat:** If needed, an optional fourth coat can be applied with the same technique used to apply the previous coats.
- **Sanding:** After an appropriate air dry, oven bake or I.R. cure, the SX1080 should be wet sanded with P400 followed by P600 or dry sanded with P360 followed by P500. After sanding, a minimum film build of 1.5 mils is recommended for optimum performance.

### How to Mix:



**SX1080** : **SX1081**

4 parts : 1 part



Pot life @ 70°F and 50% RH: 30 minutes (High heat and humidity will shorten pot life)

### Drying Times:



Air Dry: Cure 2 – 3 hours @ 70°F

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Oven Bake: Flash 10 min., bake 20 – 30 min. @ 140°F

I.R. Cure: (Med.) Cure: Flash 10 min., bake 20 min.



Sanding: DA sand with P360 grit followed by P500, or wet sand with P400 followed by P600 grit.

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