



Technical data sheet

2024-15

9900 M9 Surfacer, grey

Universal high build HS acrylic primer filler suitable for spot repair or larger surfaces. Possibility to choose among two different hardener types to achieve fast on normal drying speeds.

- improved filling power
- fast drying, easy to sand - saves time, effort, and sanding paper
- smooth surface: superb topcoat appearance
- direct to metal application, adhesion on Zinc-plated and Aluminium substrates
- possible to apply on plastic parts (in combination with 7015 Adhesion Promoter)
- VOC compliant
- hardener (vol. 5:1; standard overnight drying): 9220, 9230, 9250 or 9270
- hardener (vol. 3:1; 60-minute drying at 20°C/68 °F): 3950

Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner. Before application of the primer filler on bare steel/metal, sand the surface. Bare Steel should be lightly abraded and completely rust free before application. The primer can be applied directly, but a 2K Epoxy primer or Etch primer is recommended where optimum adhesion and corrosion resistance is required. It is recommended to use appropriate primer (epoxy, etch, etc.) to optimize adhesion and corrosion protection on aluminium and galvanized steel surfaces.

- New parts/panels sand with grit P360/dry or P800/wet.
- Old coatings sand with grit P280 - P320/dry or P800/wet.
- GRP or Fiberglass sand with grit P320/dry.
- Polyester Fillers sand with grit P120-P320/dry.
- Zn and Alu: Scuffing pad + matting paste

Before applying water-based basecoat clean with an appropriate water-based antsilicone cleaner as also suggested by the producer of water basecoat.

Mixing ratio - FAST FILLER (sandable in 1h from application)

9900 M9 Surfacer, grey


3 : 1		By volume	By weight
	9900 M9 Surfacer, grey	3	1000
3950 Hardener	1	220	
7030/7050 Maxx Thinner	10 - 20 %	60 - 120	

Application on plastic

3 : 1		By volume	By weight
	9900 M9 Surfacer, grey	3	1000
3950 Hardener	1	220	
7035 4Plastic Adhesion additive	10 %	60	
7030/7050 Maxx Thinner	10 % ⁽¹⁾	60	

⁽¹⁾ Add thinner to adjust the spraying viscosity if needed.

Spray gun setup

		
	Nozzle	1,4 - 1,8 mm
	Pressure (upper cup)	1,5 - 2 bar
Pressure (suction cup)	Verify manufacturer's info	

Application

9900 M9 Surfacer, grey



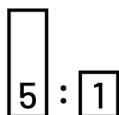
Total dry film build	60 - 120 µm
Number of coats	1 - 2
Flash-off	3 - 5 min (until matt)

Drying



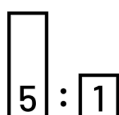
Dry film thickness	60 - 120 µm	120 - 180 µm
Dry to sand [20 °C]:	60 min	90 min
Dry to sand [60 °C]:	5 - 7 min	In case of high-build application (>180 µm), drying times are prolonged and overnight drying is recommended.
IR shortwave:	3 - 5 min	
Potlife [20 °C/68 °F]:	20 - 40 min	

Mixing ratio - NORMAL FILLER (sandable 24h from application)



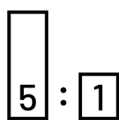
For small and medium size surfaces/high build	By volume	By weight
9900 M9 Surfacer, grey	5	1000
9220/9230/9250/9270 Hardener		140
7030/7050 Maxx Thinner	10 - 20 %	60 - 120

9900 M9 Surfacer, grey



For large surfaces/ for high temperatures	By volume	By weight
9900 M9 Surfacer, grey	5	1000
9270 Hardener	1	140
7070 Maxx Thinner	20 - 25 %	120 - 150

Application on plastic



	By volume	By weight
9900 M9 Surfacer, grey	5	1000
9220/9230/9250/9270 Hardener		130
7035 4Plastic Adhesion additive	10 %	60
7030/7050 Maxx Thinner	10 % ⁽¹⁾	60

⁽¹⁾ Add thinner to adjust the spraying viscosity if needed.

Spray gun setup



Nozzle	1,4 - 1,8 mm
Pressure (upper cup)	1,5 - 2 bar
Pressure (suction cup)	Verify manufacturer's info

Application

9900 M9 Surfacer, grey



	Thickness 60 – 120 µm	Thickness 240 – 350 µm
Total dry film build	60 – 180 µm	240 – 350 µm
Number of coats	1 – 2	3 – 5
Flash-off	3 – 5 min (until matt)	10 – 20 min

Drying



Dry film thickness	Normal thickness	dickere Anwendung
Dry to sand [20 °C]:	6 – 8 h	> 12h
Dry to sand [60 °C]:	25 – 30 min	40 min
IR shortwave:	20 – 25 min	30 min
Potlife [20 °C/68 °F]:	30 – 50 min	30 – 50 min

Complementary products

- 9220/9230/9250/9270 HS Hardener
- 3950 Trdilec
- 7050 Maxx Thinner Standard, 7070 Maxx Thinner Slow, 7030 Maxx Thinner Fast
- 7035 4Plastic Adhesion additive (Plastic primer additive)

Packaging

Product number	Description	Volume/Weight	Packaging
9900-A-1	White	1L	6
9900-A-3,5	White	3,5 L	2
9900-B-1	Dark Grey	1L	6
9900-B-3,5	Dark Grey	3,5 L	2
9900-C-1	Light Grey	1L	6
9900-C-3,5	Light Grey	3,5 L	2

Volatile organic compounds



Technical data sheet

2024-15

9900 M9 Surfacer, grey

The VOC value for this product is 540 g/L
The product category is VOC 2004/42/IIIB (c)(540)

Testing of material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) has to be done at least 15 days after the application.

Application on plastic parts

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60°C. Degrease the surface with Silco antislilicone degreaser. Sand/matt with matting paste. Clean again with Silco antislilicone degreaser. Allow parts to dry completely. ATTENTION: Sanded material must be removed completely! After this preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Additionally, use of Antistatic Degreasing Wipe (art.no. 2215) is recommended. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts (application and adhesion).

Shelf life

Min. 24 months from the production date under normal storage conditions and unopened can.

Mixing ratio by weight [5:1] [9220/9230/9250/9270]



Technical data sheet

2024-15

9900 M9 Surfacer, grey

Volume of RFU paint required	Weight primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
(ml)	(g)	(g)	(g)
100	109	123	136
250	271	307	339
330	358	405	447
500	543	614	678
750	814	920	1017
1000	1086	1227	1356

Mixing ratio by weight [3:1] [3950]

Volume of RFU paint required	Weight primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
(ml)	(g)	(g)	(g)
100	91	111	122
250	228	278	305
330	301	366	402
500	456	555	609
750	684	833	914
1000	912	1110	1218

Additional information



Technical data sheet

2024-15

9900 M9 Surfacer, grey

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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