

## SPRAY PUTTY

*Product intended for professional use.*

### PRODUCT RANGE:

43 121	Spray Putty Gray 1200 g	43 304	Spray Putty White 1200 g
43 305	Spray Putty Gray 15 kg	43 306	Spray Putty White 15 kg

### CHARACTERISTICS:

Polyester finishing putty intended for spray application. With its all-purpose formulation, it can be used successfully in industrial, automotive, boatbuilding applications, etc. Guarantees a very smooth and even coating even on large surfaces. It isolates the paint system layers very well from the layers under the spray putty. Designed for dry mechanical and manual processing.

### PHYSICAL AND CHEMICAL PROPERTIES:

Thixotropic paste of grey or white colour with a characteristic smell, containing styrene. Maximum volatile organic compounds content in ready-to-use product: 540 g/L.

### APPLICATIONS:

#### SUBSTRATE:

- steel,
- aluminium,
- polyester laminates,
- primer paints,
- polyester putties,
- cured varnish coatings,
- plastics (except: PP, PE, PTFE),
- wood, furniture boards.

***Do not apply directly onto reactive primers or one-component acrylic and nitrocellulose coatings. Do not use on galvanized surfaces.***

#### SUBSTRATE PREPARATION:

**Steel** – Use Polfill AUTOMOTIVE or PRO silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P120 - P180 abrasive paper. Dust off with compressed air and then degrease again.

**Aluminium** – Use Polfill AUTOMOTIVE or PRO silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P400 abrasive paper. Dust off with compressed air and then degrease again.

**Putties and laminates** – Use Polfill AUTOMOTIVE or PRO silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again.



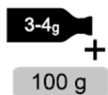
**Two-component acrylic and epoxy primers** - Apply Spray Putty only to a properly dried and cured coating. Use Polfill AUTOMOTIVE or PRO silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again.

**Cured varnish coatings** – Use Polfill AUTOMOTIVE or PRO silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again.

**Plastics** – Use Polfill AUTOMOTIVE or PRO silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again. Before applying Spray Putty, apply Polfill Primer - a primer for plastics, in order to ensure optimal adhesion to the substrate.

**Wood, furniture boards or the like** – The surface must be free from all kinds of impurities. Sand manually or mechanically with P150 - P240 abrasive paper. Dust off with compressed air.

#### PUTTY PREPARATION:



Mix thoroughly 100 parts by weight of putty with 3 - 4 parts by weight of hardener until a uniform consistency is obtained.

*The use of an incorrect amount of the hardener will affect the drying process and may cause coating defects.*

#### THINNING



If necessary, use the spray putty thinner at the ratio of up to 10% (by volume).

#### HARDENER USED:

Cyclohexanone peroxide – supplied with the putty.

#### APPLICATION:



Apply 1 - 3 layers with a spray gun with a nozzle diameter of 2 - 3 mm at the pressure recommended by the equipment manufacturer. Allow several minutes for the thinner to evaporate between consecutive layers. Suggested thickness of a single wet layer - 100 µm. The maximum dry coat thickness should not exceed 500 µm. Exceeding these values will affect drying performance and in some cases may cause unspecified paint defects. Apply the product at a temperature of at least 10°C, within 15 minutes of the preparation of the ready-to-use mixture. The evaporation time depends on the thickness of the layer applied and the ambient temperature.



## DRYING TIME:



90-110 minutes/ 20°C or 25-30 minutes/ 60°C. IR heater: 3 minutes flash-off; 6 minutes full bake. If needed, repeat the full-bake step. Do not exceed 60°C. Process after cooling down to ambient temperature.

The applied layer of Spray Putty cannot be exposed to direct contact with water and should not be exposed to high humidity.

The drying values are given for 100 µm dry layer.

**Temperatures below 20°C extend the drying process.**

## PRODUCTS THAT CAN BE APPLIED ONTO THE PUTTY:

- acrylic primers
- epoxy primers
- reactive primers

## SANDING:



Dry sanding, manually or mechanically.

Preliminary sanding with P150 - P240 abrasive paper.

Finish sanding with P240 - P320 abrasive paper.

## CLEANING THE EQUIPMENT:

POLFILL NITRO thinner.

## STORAGE:

Store in original, tightly closed containers, in a dry, cool place, away from sources of heat and ignition, at a temperature from 5 to 20°C. Do not expose to direct sunlight.

## WARRANTY PERIOD:

The warranty period is given on the product label.

## HEALTH & SAFETY RECOMMENDATIONS:

Product safety data sheet and applicable health and safety regulations for working with chemical agents.

*The information contained in this sheet has been developed based on our knowledge and practice. However, no individual product properties can be guaranteed under different conditions of use beyond our control. Therefore, we cannot accept full responsibility for the results obtained in specific conditions of use. It is necessary to test the application of the product on a small area, due to the potential differences in the product performance depending on the substrate on which it is applied. We guarantee proper quality when used in accordance with the instructions contained in this Technical Data Sheet.*