

GENERAL INFORMATION

This high filling two-component polyester spray filler can be applied using a gravity feed spray gun. Suited for all-round bodywork, it's the perfect option for large repair surfaces. The excellent adhesive properties mean this filler is easy to apply and sand while drying quickly.

MIXING RATIO



Add 3 - 5 percent Hardener and 2 - 5% Uni Thinner

COMPONENTS



ADDITIVES

GUN SETUP

		NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
	HVLP	1,3 - 1,5	2/29
	HE	1,3 - 1,5	1,6 - 1,8 / 23 - 26
	Pressure tank	-	-
	Airless / Airmix	-	3,5 - 4,5

APPLICATION



1 - 3 coat 100 - 300 µm (3,9 - 11,7 mil)

FLASH-OFF AND DRY TIMES

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	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F		
<u>↑/↑/ </u>	Flash off	-	Flash off	-	
	Dust free	-	Dust free	-	
	Dry to handle	-	Dry to handle	-	
\sim	Dry to tape	-	Dry to tape	-	
	Dry to sand	3 - 5 hours	Dry to sand	30 minutes	
<u> </u>	Dry to polish	-	Dry to polish		

Dry times may vary based on humidity and temperature.

SUBSTRATES



Sanded bare steel, fully cured coatings / epoxyprimer and polyester bodyfillers.

Do not use on aluminium, galvanized steel, washprimer and thermoplastic acrylics (TPA).

POT LIFE



15 - 30 minutes

SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover wipe on and wipe dry. Sand surface with P80-P120 grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with TD20 Silicone Remover wipe on and wipe dry.

Block sand P80-P120.

Sanding P80-P180 orbit 5-7. Final sanding P180-P240 feather-edge.

NEXT LAYER



All Octoral 2K Surfacers and primers.

PHYSICAL DATA

EU REGULATIONS PA80 Polyester Spray Filler					
VOC Code		2004/42/IIB(c)(540)250			
Product sub category (accor 2004/42/EC) and max VOC o 11890-1/2) of the ready to u	ontent (ISO	IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 250 g/l VOC.			
Chemical Base					
	Viscosity (RTS)	-			
	Specific Gravity (kg/l)	1,7			
	Flash Point Closed Cup	31°C (87,8°F)			
Physical Properties	Volume % Solids	-			
	Economy	-			
	Gloss	Matt			
	Colour	Grey			

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PROTECTION



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator). For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.octoral.com

CLEANUP



Gun Cleaner

STORAGE / SHELF LIFE



Minimum 1 year; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES



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