

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

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	2,0-3,0	See info manufacturer
HE	-	See info manufacturer
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



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

Dry times may vary based on humidity and temperature. The values mentioned on the infrared dry times will vary depending on the chosen IR system.

I.R. 10-12 min (Distance: see manufacturer info)

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

COMPONENTS



ADDITIVES



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 Surfacer and primers.

PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/II(B)(c)(540)250	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	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		
Physical Properties	Viscosity (RTS)	-
	Specific Gravity (kg/l)	1,7
	Flash Point Closed Cup	31°C (87,8°F)
	Volume % Solids	-
	Economy	-
	Gloss	Matt
	Colour	Grey

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

