# PA80
## POLYESTER SPRAY FILLER

## 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 | 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

| 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.**

## 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

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## ADDITIVES

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## 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 (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

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valspar **AUTOMOTIVE**