
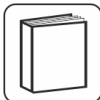

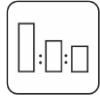







TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<h3>POLYESTER SPRAY FILLER</h3> <p>SPRAY FILLER</p>	
<p>PRODUCTS</p>	
<p>POLYESTER SPRAY FILLER – polyester spray filler. Hardener for the spray filler. Thinner for spray filler.</p>	<p>COLOUR: lightgrey</p>
<p>PRODUCT DESCRIPTION</p>	<p>GLOSS GRADE: matt</p>
<p>High quality 2K polyester spray filler dedicated for car body repairs.</p> <ul style="list-style-type: none"> • Easy application. • Good insulating properties. • Short drying time. • Isolates very well primer and top coats from polyester body filler and putties. 	<p>DENSITY: 1,55 (+/- 0,03) kg/l</p>

<p>VOLATILE ORGANIC COMPOUNDS</p>	
<p>VOC for the mixture = 437 [g/l] This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l.</p>	
<p>SURFACE PREPARATION</p>	
<p>The product has very good adhesion to various surfaces. It can be applied over:</p> <ul style="list-style-type: none"> • Bare steel and aluminum after flatting and degreasing. • Sanded glass fibre (GFK/GRP), polyester putties, acrylic and epoxy primers, existing coatings in good condition. 	<p>We recommend sandpaper with gradations: P180÷P320.</p> <p>Caution: Do not apply the putty directly on the reactive primers, 1K acrylic and nitrocellulose products.</p>

APPLICATION PROCESS									
	USE		APPLICATION PARAMETERS						
	<p>It is dedicated for filling small scratches left from application of polyester putties, in order to isolate acrylic coatings from polyester putties.</p>		<p>Number of layers: 1÷3 layers Gun parameters: Nozzle: 2.0÷3.0 mm Pressure: According to the the gun producer's recommendations. Usually 2.0÷2.5 bars. Film thickness: Do not exceed the thickness of 200µm of a wet film. Do not exceed a total dry film thickness of 600 µm.</p>						
	<p>MIXING RATIO by volume</p> <table border="0"> <tr> <td>Filler</td> <td>100 parts</td> </tr> <tr> <td>Hardener</td> <td>4.5 parts</td> </tr> <tr> <td>Thinner</td> <td>max. 10%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>	Filler	100 parts	Hardener	4.5 parts	Thinner	max. 10%		<p>EVAPORATION TIME</p> <p>Between layers: approx. 5 minutes Before baking: approx. 10 minutes</p> <p>Evaporation time depends on the temperature and the thickness of layers.</p>
Filler	100 parts								
Hardener	4.5 parts								
Thinner	max. 10%								
	<p>SPRAYING VISCOSITY</p> <p>50 (+/-5) seconds at 20°C</p> <p>Pot life: 20 (+/-3) minutes at 20°C</p>		<p>IR DRYING</p> <p>5÷7 minutes of short waves, depending on the layer thickness and the type of radiator. Do not exceed the temperature of 60°C. Use as recommended by the equipment manufacturer. Wait about 5 minutes before the IR drying process.</p>						
	<p>SANDING</p> <p>Finishing sanding (dry): P180÷P320</p>		<p>HARDENING TIME</p> <p>2-3 hours at 20°C. 25-30 minutes at 60°C. Temperature below 20°C significantly increases the hardening time.</p>						

<p>PRODUCT EFFICIENCY</p>
<p>1 liter of mixture is enough to cover 8 m² with a layer with thickness of 100 µm.</p>

FURTHER WORK

Polyester putties can be over coated with:

- 2K acrylic fillers,
- 2K epoxy fillers.

GENERAL NOTES

- Excessive amount of hardener will cause problems with bleaching of the topcoat!
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. *Close the container after use.*
2. *Protect it from overheating!*

WARRANTY PERIOD

POLYESTER SPRAY FILLER – polyester spray filler.	– 12 months from the date of production
Hardener for the spray filler.	– 18 months from the date of production

PRODUCT	ART. No.
POLYESTER SPRAY FILLER – polyester spray filler	2363 (1kg)
Hardener for the spray filler	

LIMITATION OF LIABILITY

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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