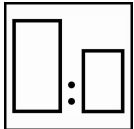


# Polysurfacer

## FOR PROFESSIONAL USE ONLY

### Description

Two-pack polyester surfacer suitable for filling surface flaws or heavy scratches in one single operation. Compared with conventional systems, this product enables to work quickly and it ensures easy sanding after a short drying time.



100 Polysurfacer  
5 Polysurfacer Hardener

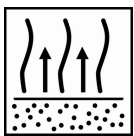


Spray gun set-up:  
2.0-3.5 mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



2-3 x 1 coat



Between coats:  
0-5 minutes at 20°C

Before curing:  
0-5- minutes at 20°C



2 hours at 20°C

30 minutes at 60°C



Final sanding step: P220 – P320  
See TDS S8.06.02



Recoat with all Sikkens solventborne preparatory products



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

# Polysurfacer

**FOR PROFESSIONAL USE ONLY**

## Description

Two-pack polyester surfacer suitable for filling surface flaws or heavy scratches in one single operation. Compared with conventional systems, this product enables to work quickly and it ensures easy sanding after a short drying time.

## Preparation process



Remove contamination using an appropriate cleaner



Final step P180 - P220

*For detailed surface preparation see TDS S8.06.02*



Remove contamination using an appropriate cleaner

## Suitable substrates

Steel  
Existing finishes (in case of complete panel application)  
Glass Reinforced Polyester laminates  
Primer Surfacer EP II (maximum 25 µm)

Do not apply Polysurfacer over washprimer

## Product and additives

Polysurfacer

**Hardeners** Polysurfacer Hardener

## Basic raw materials

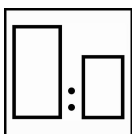
Polysurfacer: Polyester resins  
Polysurfacer Hardener: Peroxide

## Stir before use



Stir Polysurfacer thoroughly before use.

## Mixing



**100** Polysurfacer  
**5** Polysurfacer Hardener  
*Use quantity indication on the hardener bottle.*

# Polysurfacer

## FOR PROFESSIONAL USE ONLY

### Spray gun set-up / application pressure



#### Spray gun

Gravity feed

#### Fluid tip-set-up

2.0-3.5 mm

#### Application pressure

1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

*For maximum build use widest fluid tip and lower application pressure.*

### Pot-life

30 minutes at 20°C.

### Application



#### Spot application:

Apply one coat over the total sanded area. Flash off until completely matt and apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat within each preceding coat. Flash off until completely matt after each coat.

#### Panel application:

Apply 2-3 coats and flash off until completely matt after each coat.

### Film thickness

300µm

### Drying time sanding



2 hours at 20°C

1 hour at 40°C

30 minutes at 60°C

### Sanding



P120 - P220 (P320)

*Use a guide coat at each sanding step.*

*For detailed surface preparation see TDS S8.06.02*



Remove contamination using an appropriate cleaner

*Do not use a waterborne degreaser*

### Recoat with

All Sikkens solventborne preparatory products

### Material usage

By using the recommended application the theoretical material usage is 4 m<sup>2</sup>/liter.

*The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*

# Polysurfacer

**FOR PROFESSIONAL USE ONLY**

## Cleaning of equipment

Sikkens Solvent or solvent borne guncleaners

## VOC

### 2004/42/IB(b)(250)200

The EU limit value for this product (product category: IIB. c) in ready to use form is max. 250 g/liter of VOC.  
The VOC content of this product in ready to use form is max. 200 g/liter

## Product storage

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.

- Product shelf life data see TDS S9.01.02

**AkzoNobel Car Refinish bv.** [Change in local name in case of difference; i.e. Coatings LTD / Inc.](#)  
**Address:** Rijksweg 31, PO Box 3, 2170 BA Sassenheim [\(change to local address\)](#)  
**Tel:** +31(0)71308-6944 [\(Change to local phone number\)](#)

## FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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