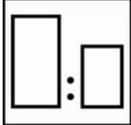


Polysurfacer

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
Use quantity indication on the hardener bottle



100 Polysurfacer
3.2 Polysurfacer Hardener
Use a weighing scale

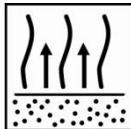


Spray gun set-up:
2.0-3.5 mm

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 S8.06.01



Recoatable with any Sikkens preparatory products
With the exception of waterborne 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



Surface cleaning, remove any surface contamination prior to sanding using appropriate surface cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Remove existing coating and sand down to the bare substrate using P120 - P220 grit as the final step.
For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Polysurfacer using appropriate surface cleaner.

Suitable substrates

Steel
Existing finishes (only in case of complete panel application)
Glass Reinforced Polyester laminates
Primer Surfacer EP, applied over a layer of maximum 25µm

Do not apply Polysurfacer over any acid containing Washprimer

Product and additives

Polysurfacer

Hardeners Polysurfacer Hardener

Basic raw materials

Polysurfacer: Polyester resins
Polysurfacer Hardener: Peroxide

Stir before use

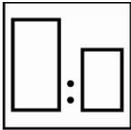


Stir the Polysurfacer thoroughly before mixing.

Polysurfacer

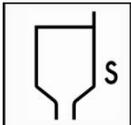
FOR PROFESSIONAL USE ONLY

Mixing



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

Viscosity



The correct spraying viscosity is reached by mixing the Polysurfacer and Polysurfacer Hardener in the specified proportions.

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.
 15 minutes at 30°C.

Application



Apply one coat over the total sanded area. Next apply the 2nd and 3rd coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.

Allow each coat to flash off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry by air support. Flash off between the coats is dependent on ambient temperature, applied layer thickness and airflow.
 For maximum build use widest fluid tip and lower application pressure.

Film thickness

By using the recommended application is approximately; 300µm (100µm per coat)

Drying time sanding



2 hours at 20°C 1 hour at 40°C 30 minutes at 60°C

Drying times relate to recommended application (3 coats) and object temperature.

Polysurfacer

FOR PROFESSIONAL USE ONLY**Sanding**

P120 - P220 (P320)

Use a guide coat between the sanding steps.

Take care to remove any coarse sanding scratches that may have been created in the Featheredge area during the sanding of the Polysurfacer.

For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of the preparatory product using an appropriate surface cleaner.

Recoatable withAll current Sikkens preparatory products with the exception of waterborne products.**Theoretical coverage**

By using the recommended application the theoretical material usage is:

± 5.5 – 6.5 m²/liter RTS mixture for Polysurfacer.

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

Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

VOC

2004/42/IIB(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 S9.02.01

Polysurfacer

FOR PROFESSIONAL USE ONLY

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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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