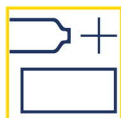


TECHNICAL INFORMATION

DYNACOAT POLYESTER SPRAY FILLER

— D3.02.07 UK & Ireland

Two-pack polyester spray filler for cars to fill surface defects or scratches.



MIXING RATIO

100 Dynacoat Polyester Spray Filler
3 - 4 Hardener
10% Dynacoat Thinner (optional)



EQUIPMENT

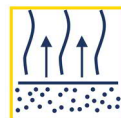
Spray gun set-up: 2.2 - 3.0 mm
Application pressure: 2.0 - 2.5 bar at the air inlet*

*See user manual spray gun



APPLICATION

1 - 3 Single coats



FLASH-OFF

5 minutes between coats



DRYING

2 hours at 20°C
30 minutes at 60°C



SANDING

P180 - P280 or P220 - P320



RECOATABLE WITH

Dynacoat Filler



PROTECTION

Use suitable respiratory protection. AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

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DYNACOAT POLYESTER SPRAY FILLER

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PRODUCT AND ADDITIVES	Dynacoat Polyester Spray Filler Hardener		
BASIC RAW MATERIALS	Polyester Spray Filler:	polyester resins	
	Hardener:	peroxide	
SUITABLE SUBSTRATES	Steel Galvanized steel 2K Epoxy Primer Polyester Putties Polyester Laminates Note: Do not apply Dynacoat Polyester Spray Filler on plastics, etching, one-component acrylic and nitrocellulose primers. Before application, degrease with a silicon remover.		
SURFACE PREPARATION	Steel: Degrease and sand with P80-P180 grit dry Galvanized steel: Degrease and abrade with P180 grit paper Polyester Putties: Sand with P180-P280 grit dry Polyester Laminates: Clean with warm water, degrease and abrade with P180-P280		
MIXING	100 3 - 4 10%	Dynacoat Polyester Spray Filler Hardener Thinner (optional)	
POTLIFE	20-30 minutes at 20°C		
SPRAY GUN FLUID TIP AND WORKING PRESSURE	Spray gun: Gravity feed:	Fluid tip: 2.2 – 3.0 mm	Pressure: 2.0 – 2.5 bar (see user manual spray gun) HVLP max 0.7 at air cap
APPLICATION	Apply 1 or several single coats, allowing for 5 minutes flash off time between coats and 10 minutes before curing at 60°C		
CLEANING OF EQUIPMENT	Use Guncleaner or a nitrocellulose thinner		
FILM THICKNESS	100 µm per coat.		
DRYING	Dry to sand	20°C 2 hrs.	60°C 30 min.



TECHNICAL INFORMATION

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THEORETICAL COVER RATE	<p>Ready for use mixture at 1µm dry film thickness ± 600 m²/litre</p> <p>Note: The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application</p>
RECOMMENDED SAND PAPER	<p>Initial: P180 Finish: P180-P280</p>
RECOATABILITY	<p>All Dynacoat Putties Dynacoat Filler 4100 Dynacoat 6100 DUO</p>
PRODUCT STORAGE	<p>Product shelf-life is determined when products are stored unopened at 20°C. Avoid extreme temperature fluctuation.</p>
SHELF LIFE	<p>12 months at 20°C</p>
VOC	<p>2004/42/IB(c)(540)380 The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/litre VOC. The VOC content of this product in ready to use form is max. 380 g/litre.</p>



TECHNICAL INFORMATION
DYNACOAT POLYESTER SPRAY FILLER
— D3.02.07 UK & Ireland

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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 fulfil 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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