Technical Data Sheet

P-S

Spray filler with colour change indicator

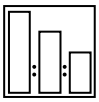
RELATED PRODUCTS

P-S	Spray filler
Cetox-20 OE	Hardener
THIN 880	Thinner for polyester spray filler

PROPERTIES

- A product designed and dedicated for renovation of classic cars
- Application of thick layers is possible
- High yield
- Perfect hiding power and flowability
- Contains an indicator of polymerisation progress and mixture homogenisation rate
- Perfect filling properties

SUBSTRATES	
Steel	Clean steel surfaces until reaching Sa $2^1/_2$ (wet blasting) or St3 (manual cleaning or using a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free from oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.
Old paint coatings	Degrease with SILICON REMOVER and dry sand with P220 – P280.
Polyester putties	Dry sand, use P240 ─ P320 for final sanding.
Aluminium	Degrease with SILICON REMOVER and mat with an abrasive needled cloth. Degrease again with SILICON REMOVER.
Epoxy primers	Degrease, dry sand P220 – P280, degrease again. **CAUTION: P-S must be applied at least after 24 hours from application of the epoxy primer**
Plastics, except PE (polyethylene) and PTFE (Teflon)	Degrease with SILICON REMOVER and mat with an abrasive needled cloth. Degrease again.
Polyester laminates	Dry sand with P280, degrease again.
CAUTION: Do not apply polyester putty directly on top wash primers or one-component acrylic and nitrocellulose products.	

MIXING RATIO			
		Volume ratio	Weight ratio
	P-S Cetox-20 OE THIN 880	100 ml 6 to 7 ml 10% max	100 g 3.7 to 4.5 g max. 10%
Caution: Thin only with the original THIN 880 thinner. The colour will begin to change gradually into white a moment after adding the Hardener.			

SPRAYING PARAMETERS:			
Component A	Hardener	THIN 880	Pneumatic spraying
P-S	Cetox-20 OE	10%	nozzle: ∅2.2 ─ 3.0mm pressure: 3 ─ 4 bar distance: 15 ─ 20 cm

APPLICATION		
	Number of layers	1 – 3 Maximum thickness 300 µm
	Single wet layer thickness	80-100 µm
	The yield of the ready to use mixture for the given range of dry layer thickness	approx. 6.0 m^2/l at 100 µm
	The actual yield depends on the surface shape, roughness and application parameters. Any deviations from white after drying result from improper blending of components.	

	Mixture life at 20°C	20 - 40 min
	Flash-off time between layers	5 min

CURING TIME			
	Time to sand For thickness of 100 µm	20℃	60℃
		2 - 3 h	30 - 40 min

IR DRYING		
	Distance	Follow the recommendations of the equipment manufacturer
	Time depending on the type and power of the lamp	10 ─20 min
CAUTION: Start IR heating after at least 10 mins from applying the last layer.		

SANDING:		
	Rough	P180 ─ P240
	Finish	P240 ─ P320

CONTENT OF VOLATILE ORGANIC COMPOUNDS (VOC)	
VOC II/B/c limit*	540 g/l
Actual VOC content	150 g/l
* For ready to use mixture acc. to EU Directive 2004/42/CE	

APPLICATION CONDITIONS
It is recommended to apply at a temperature above 10°C and a humidity of no more than 80 %.
COLOUR
Blue
EQUIPMENT CLEANING
NC solvent
STORAGE CONDITIONS
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.
SHELF LIFE

P-S	12 months/20℃
Cetox-20 OE	18 months/20℃

SAFETY
See Safety Data Sheet. For professional use only.
OTHER INFORMATION
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.