











## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<h1>POLYESTER SPRAY FILLER</h1> <h2>SPRAY FILLER</h2>		
<h3>PRODUCTS</h3>		
POLYESTER SPRAY FILLER – polyester spray filler. Hardener for the spray filler. Thinner for spray filler.		
<h3>PRODUCT DESCRIPTION</h3>		
High quality 2K polyester spray filler dedicated for car body repairs. <ul style="list-style-type: none"><li>• Easy application.</li><li>• Good insulating properties.</li><li>• Good vertical stability.</li><li>• Isolates very well primer and top coats from polyester body filler and putties.</li></ul>		
		<b>COLOUR:</b> light grey
		<b>GLOSS GRADE:</b> matt
		<b>DENSITY:</b> 1,63 (+/- 0,03) kg/l

<b>VOLATILE ORGANIC COMPOUNDS</b>	
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.	
<b>SURFACE PREPARATION</b>	
The product has very good adhesion to various surfaces. It can be applied over: <ul style="list-style-type: none"> <li>• Bare steel and aluminum after flatting and degreasing.</li> <li>• Sanded glass fibre (GFK/GRP), polyester putties, acrylic and epoxy primers, existing coatings in good condition.</li> </ul>	We recommend sandpaper with gradations: P80÷P240.  <b>Caution:</b> Do not apply the putty directly on the reactive primers, 1K acrylic and nitrocellulose products.

APPLICATION PROCESS			
	USE		NUMBER OF LAYERS
	It is dedicated for filling small scratches left from application of polyester putties, in order to isolate acrylic coatings from polyester putties.		1÷3 layers <b>Gun parameters:</b> Nozzle: 1.8÷3.0 mm Pressure: According to the gun producer's recommendations. Usually 2.0÷2.5 bars. <b>Film thickness:</b> Do not exceed the thickness of 200µm of a wet film. Do not exceed a total dry film thickness of 600 µm.
	MIXING RATIO by volume		EVAPORATION TIME
	Filler 100 parts Hardener 6 parts Thinner 35% Stir thoroughly until achieving homogenous mixture.		Between layers: approx. 5÷10 minutes Before baking: approx. 10 minutes  Evaporation time depends on the temperature and the thickness of layers.
	SPRAYING VISCOSITY		IR DRYING
	approx. 50 seconds at 20°C  <b>Pot life:</b> approx. 20 minutes at 20°C		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.
	SANDING		HARDENING TIME
	Finishing sanding (dry): P180÷P320		2-3 hours at 20°C. 25-30 minutes at 60°C. Temperature below 20°C significantly increases the hardening time.
	Caution: Stir well before using!		

**PRODUCT EFFICIENCY**

1 liter of mixture is enough to cover 8 m<sup>2</sup> with a layer with thickness of 100 µm.

**FURTHER WORK**

Polyester putties can be over coated with:

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

**GENERAL NOTES**

- Minimum application temperature is +10°C.
- 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	2357 (1,2kg)
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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