

## 799R

27.08.2014

### VOC SPRAY PUTTY

#### DESCRIPTION

A 2-component finishing spray putty with a peroxide hardener.  
Composition based on modified polyester polymer.

#### PRODUCTS

799R	VOC Spray Putty
791R	Spray Putty Activator

#### PROPERTIES

- High film build.
- Very good adhesion to bare steel and substrates as listed.
- Easy application.
- Fine homogeneous structure.
- Smooth sanding.
- VOC compliant, conform with directive 2004/42/EC.

#### SUBSTRATES

- Specially recommended for bare steel and glass fibre polyester.
- OEM finishes\*.
- Undercoats\*.








\* Not recommended for use over 1K primers, wash primers, thermoplastic undercoats or thermoplastic topcoats.

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### PRODUCT PREPARATION

Mixing ratio	799R 791R	Volume	Weight	
		100 5	100 4	
VOC	250 g/l			
 Pot life at 20°C	20 min			
 Spray viscosity at 20°C	3000 cp			
 Spray equipment	<b>Compliant guns</b> Gravity feed Suction feed Pressure feed  <b>Conventional guns</b> Gravity feed Suction feed Pressure feed	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
		2.0-2.5 mm - -	10-15 cm - -	According to supplier's specifications  2-3 bar - -
 Number of coats	1-5			
 Flash time	10 min			
DFT	Up to 500 µm			
 Dry to sand at 20°C at 60°C	2 hr 30 min 30 min			
 IR drying*	Flash time	10 min	* Guideline for short/medium wave IR equipment.	
	Distance	80 cm		
	Half power	5 min		
	Full power	15-20 min		
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.				

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### SURFACE PREPARATION

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface mechanical with P80.
4. Sand to featheredge, with P150 or P180.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

### RECOATABILITY

At any time after dry to sand.

### REMARKS

- Aluminiums, light alloys and zinc plated steel must be prepared with an epoxy primer (no wash primer allowed).
- Do not use 799R over unsanded substrates.
- Do not apply topcoat directly over 799R to avoid absorption.
- Material has to be at room temperature (18-25°C) before use.

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### PRODUCT DATA

Directive 2004/42/EC: 2004/42/IIB(b) (250)250: The EU limit value for this product (product category: IIB(b)) in ready to use form is maximum 250 g/l of VOC. The VOC content of this product in ready to use form is maximum 250 g/l.

### SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the paint system build-up are from Cromax<sup>®</sup>. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax<sup>®</sup>, unless explicitly indicated otherwise.

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