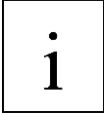


Always use correct Personal Protective Equipment

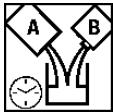
SPRAYFILLA

Description



Sprayfilla is a unique ready for use, easy sanding, one-step spray-on filler for the Automotive industry. Resene Sprayfilla provides excellent hold out of RALI topcoats.

Products



Product Type: Nitro Cellulose/Alkyd
Colour: Grey, Black, White
Pot Life:
Induction Time:
Density: 1.085 kg/L
Recommended DFT: Should not exceed 200 microns
Theoretical Coverage: 5.7-4.6 m²/L @ 40-50 microns DFT

Properties



VOC: 616 g/L
Volume Solids: 23%
Recoat-ability: Recoat: Topcoats, any time after free sanding. Can be self-recoated at any stage.

Dry Time @ 20°C: Touch Dry: approximately 5-10 minutes
 Handle: 40 minutes. @ 50 microns DFT
 Hard Dry: 4 hours @ 50-200 microns DFT
 Dry to sand: 40-60 minutes depending on the film build and ambient temperatures. For higher film builds it is recommended to leave Sprayfilla up to 4 hours.

It is essential that Sprayfilla be allowed to completely cure prior to the application of the topcoat. Premature application may result in shrinkage, sink-back and loss of gloss.

Surface Preparation



Old Finishes & Glass-Reinforced Plastics:

Wash vehicle to remove dirt and road film. All surfaces must be cleaned with Wax & Grease Remover (refer data sheet), to remove all traces of oil, grease, silicone, wax and be free of all traces of contamination.

Strong emphasis in that all surfaces to be painted should be clean dry and free from all traces of contamination and be well sanded. Do not apply to existing finishes that are blistering, peeling, cracking, flaking or otherwise unsound. These must be completely removed.

Surface

Steel

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Always use correct Personal Protective Equipment

Preparation (cont)



Degrease thoroughly with Wax & Grease Remover. Sand and eliminate all rust or corrosion (treat with Rust Kill). Wipe surface clean with Wax & Grease Remover. Dry then, within 20 minutes apply 81A Two-Pack Etch Primer (for optimum adhesion for large areas). Allow a minimum 3 hours (maximum 24 hours) flash time before applying Sprayfilla.

Aluminium

Degrease with Wax & Grease Remover. Mechanically abrade with P280 or P320 disc. Treat with Hydrafos acid wash. Rinse with clean water, ensuring that all metal swarf and acid is removed dry. Immediately wipe surface clean with GP Thinners. Apply 81A 2-Pack Etch Primer within 20 minutes of surface preparation. Allow a minimum of a 3 hours flash time (24 hour maximum) before applying an appropriate primer surfacer / filler.

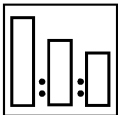
Galvanised Steel

Degrease with Wax & Grease Remover. Mechanically abrade to remove rust and corrosion. Treat with Hydrafos acid wash. Rinse with clean water. Immediately wipe surface clean with GP Thinners. Apply 81A 2-Pack Etch Primer within 20 minutes of surface preparation. Allow a minimum of a 3 hours flash time (24 hour maximum) before applying Sprayfilla.

Plastic Bumpers

Clean thoroughly with Wax & Grease Remover, sand with 320-grit paper. Remove dust and wipe clean with Wax & Grease Remover. Apply one full coat of Sprayfilla (adhesion problems can be encountered with some plastics, particularly if they have a 'waxy feel'. If in doubt check on a test area before proceeding).

Directions For Use



Mixing Ratio:

N/A

Thinning:

Sprayfilla comes ready for use and requires no thinners.

Application method:

Stir well and use straight from the can. Apply 2 to 3 coats allowing 5-10 minutes flash off between coats. Observe flash time between coats. Avoid applying heavy coats. Gradual build up is the better policy especially if more than three coats are required. A build of 150-200 microns is attainable but should not be necessary if the job has been prepared correctly. Remember a rushed job can be a botched job.

Clean up:

For clean up use RALI GP Thinner

Spray Equipment:



Compliant / Conventional Suction and Gravity feed

Tip size: 1.6 - 2.0 mm

Air pressure: 280 - 380 kPa (40-55 psi)

Do not use a Putty Gun

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Always use correct Personal Protective Equipment**Health & Safety**

For detailed information refer to Safety Data Sheet (SDS). Avoid breathing vapour. Ensure adequate ventilation. Wear protective mask if working in confined spaces. Highly flammable - keep away from sparks and naked flames. If eyes become contaminated flush with water for fifteen minutes.

Transport & Storage

Sizes:	1L, 4L, 20L
Dangerous Goods:	3A
UN:	1263
Hazchem:	3(Y)E
Packing Group:	III
Shipment name:	PAINT Flammable
Flash point:	Below 23°C

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