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PRODUCT INFORMATION SHEET

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2 PACK POLYESTER SPRAY PUTTY

Description

Motospray 2 Pack Polyester Spray Putty is a two pack spraying filler specifically designed as a high build, low shrinkage product to replace conventional primer surfacers and spray putties where deep filling is required.

Use

For the repair of rippled and hail damaged panels. Suitable for both full panel and spot repairs.

Properties

No shrinkage
Very high build
Rapid cure
Excellent sanding
Excellent surface drying
Outstanding hold out of top coats including acrylic and two pack finishes

Suitable substrates

Polyester Spray Putty may be applied over original baked enamel, aged acrylic lacquer which is in good condition, fibreglass, body filler, wood, and bare metal primed with *HiChem 2 Pack Red Primer*. Do not apply over etch primers, rust converters, or single pack enamels.

Surface preparation

Sand with 120 grit paper.
All surfaces to be coated should be clean, dry and free from contamination.
Wash thoroughly with *Prepwash* and dry off with clean lint free cloth.
For maximum long term protection and adhesion, bare metal should be coated with *HiChem 2 Pack Red Primer*.

Mixing

Stir contents before use.
Mix 10 parts by volume of *Polyester Spray Putty* with 1 part by volume of *Polyester Spray Putty Hardener*.
Mix sufficient material for 15 minutes use only and wash up equipment immediately upon completion.

Thinning

Not required. Caution: use of thinners may cause poor curing.

Pot life

30 minutes at 25°C when putty is mixed 10 to 1 by volume with *Polyester Spray Putty Hardener*.
Pot life will be shorter at higher temperatures.
Polyester Spray Putty should not be applied when the surface temperature is below 15°C or above 35°C.
Below 15°C, curing will take considerably longer or will not occur at all, resulting in poor adhesion.
Above 35°C, excessively fast cure may result in a soft film.

Application

Use a Gravity Feed Spray Putty gun. Fluid Tip 2.5 - 3.0 mm. Pressure 200 - 250 kPa (30 - 40 psi)
Apply a further 3-4 double header coats, allowing 4-5 minutes flash off between coats. The air flash between coats is necessary to allow the retarding solvents, used to prolong the pot life of the catalysed putty, to evaporate from the film, and so promote a faster cure.

To ensure a complete cure, a minimum of 2 double header coats must be applied.

Do NOT apply thin films as **thin films will not fully cure.**

Polyester Spray Putty should not be applied when humidity is high or when the surface temperature is below 15°C or above 35°C.

SPOT REPAIRS:

Apply *Polyester Spray Putty* well beyond the area to be filled, then sand back to the repair area. It is essential to remove by sanding the thin outer edge of the puttied area by feathering back to the thick central area.

Apply primer corresponding to chosen top coat along the feather edge to ensure a perfectly smooth finish.

Minimum film build

At least 250 microns must be applied.

Drying

Polyester Spray Putty is ready for dry sanding and recoating after air drying for approximately 1 hour at 25°C. Allow longer at lower temperatures.

For oven drying, first allow 30 minutes air drying before applying heat at 80°C for 15 minutes or 60°C for 30 minutes.

Sanding

Rough sand with minimum 180 grit dry rub paper and finish with 400 grit dry rub to produce a smooth surface. DO NOT WET SAND.

Topcoating

After dry sanding to a smooth finish, *Polyester Spray Putty* can be over coated with any of the following. Primer appropriate for the colour coat must be applied over the *Polyester Spray Putty* prior to application of the topcoat.

- *Motospray Acrylic Lacquer*
- *Motospray Automotive Enamel*
- *HiChem Basecoat Colour*
- *HiChem 2 Pack Colour*
- *HiChem 2 Pack Iso-Free Finish*

Clean up

Clean the spray gun and all equipment with *Superglow*, *Aclac 20* or *Acetone* immediately upon completion of the job and within 30 minutes of mixing the putty.

Shelf life

Approximately 12 months from date of manufacture. See use-by date on container. Store in a cool place.

Safety

See Material Safety Data Sheet.

Standard Packages and Product Codes

Polyester Spray Putty	Code PSP1	1 Litre
includes Polyester Spray Putty Hardener 120 mls		

The information contained in the bulletin is presented in good faith based on thorough field and laboratory testing but without warranty. It is recommended that all products be tested by the end user to ensure the suitability of the product for particular application under the user-factory conditions.