GLOBAL REFINISH SYSTEM

November 2014

Product Information

P.E. SPRAY
POLYESTER SPRAY FILLER – A712

Hardener SHA307
Thinner A714

PRODUCT DESCRIPTION

P.E. Spray is a light grey 2-component polyester spray filler. It is designed for the repair of large surfaces with extensive defects and irregularities - where use of conventional knifing stoppers would be inconvenient and time-consuming.

Quick drying, easy to apply and with high film build, P.E. Spray may be used over a variety of substrate materials. Once sanded, it may be overcoated with any primer or surfacer before application of topcoat.

PREPARATION OF SUBSTRATE

In all cases, select the appropriate PPG cleaner(s) from the guide below, and ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Bare Steel (including *Shotblast Steel*) should be abraded with P80-P120 grit discs and be completely rust free before application. D845 DX310 High Strength Degreaser is recommended for cleaning bare steel. P.E. Spray may be applied directly, although corrosion resistance is optimised if an Epoxy Primer is applied first.

Other Bare Metals (e.g. Aluminium and Galvanised Steel) and *Fibreglass* must be pre-primed (see above).

Original Paintwork should be sanded using P280 grade paper (dry) or P360 grade paper (wet). Spot prime any exposed bare metal with DP40 (see above).

Polyester Fillers should be dry sanded with P80-P120 grit discs in order to prevent adhesion problems.

GUIDE TO SELECTION OF SUBSTRATE CLEANERS

Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

Please see **DELTRON® Cleaners (RLD63V)** Technical Data Sheet for appropriate substrate cleaning and degreasing products.

MIXING RATIOS

	By Weight
A712	100
SHA307	2
A714	2

MIXED PRODUCT DETAILS

Potlife at 20°C: 20 minutes

APPLICATION AND FLASH OFF

Spraygun set-up:

Gravity	2.0 - 2.5mm
Suction	Not Recommended
Spray pressure	2 - 3 bar
Number of coats:	3 – 4, (4 maximum)
Flash off:	
between coats	5 - 10 minutes
before stoving	10 minutes

DRYING TIMES

IR drying times:	
Short-wave	10 minutes
Medium Wave	15 minutes

Dry sandable at 60°C	30 minutes
Dust free at 20°C	20 minutes
Dry sandable at 20°C (200 microns)	2-3 hours

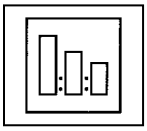
Total dry film build:	
Minimum	150µ
Maximum	600µ
Theoretical coverage:	2-3m²/lt

Sanding:	
Grade dry	P180 followed by P320
Grade wet	**Do not wet sand**

Overcoat with: Any PPG 2K Primer -
Please refer to 'Performance and Limitations' section overleaf

Global at a Glance A712

POLYESTER SPRAY FILLER A712

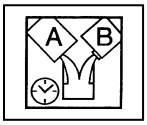


Mixing by volume

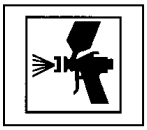
100 A712 : 2.5 SHA307 : 2 A714

Mixing by weight

100g A712 : 2g SHA307 : 2g A714

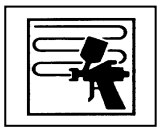


Pot Life at 20°C - 20 minutes



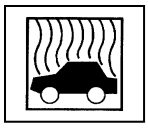
Spraygun and Sizes

Gravity Gun with 2.0 - 2.5 mm Fluid Tip



Number of Coats

2 minimum, 4 maximum



Drying Times

Dust Free	20 minutes
Through dry at 20°C	2 - 3 hours (200 microns film build)
Through dry at 60°C	30 minutes

Dry Film Thickness: 150 - 600 microns

PERFORMANCE AND LIMITATIONS

Do not apply P.E. Spray over phenolic-based primers (e.g. Universel, 2+1).

All cans of A712 should be thoroughly hand-stirred before use.

Avoid stirring unactivated A712 with mixing sticks contaminated with residues of material containing SHA307 hardener.

Mix only the quantity of product required for immediate use. Do not return activated material to the original container. Carefully re-seal part-used containers of A712 and SHA307.

P.E. Spray is water-sensitive and must not be wet-sanded.

P.E. Spray must **not** be overcoated directly with topcoat finishes. Always apply a sealer coat of a suitable 2K primer or surfacer before application of topcoat.

Immediately after use, thoroughly clean all spray and mixing equipment with cleaning solvent or thinner.

The use of HVLP spray equipment can give an increase in transfer efficiency of around 10% depending upon the make and model of equipment used.

VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC.
The VOC content of this product in ready to use form is max. 250g/litre.
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

HEALTH AND SAFETY

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: **www.ppgrefinish.com**

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