








Technical data sheet

SPRAY

Spray filler

PROPERTIES		
SPRAY spray filler – finishing filler applied by pneumatic spraying. Allows achieving a high fill ratio with a smooth surface, even on very large areas. The time to sand is approx. 2 hours at 20°C (and can be reduced by heating at a maximum of 60°C). The product is intended for machine sanding and manual sanding with fine abrasive papers.		
RELATED PRODUCTS		
CETOX 20 OE	Hardener	
THIN 880	Thinner for polyester Spray Filler	
SUBSTRATES		
Old paint coatings	degrease, dry sand with P220 – P280, degrease again.	
Polyester putties	Dry sand with P240, degrease again.	
Epoxy primers	Mat and degrease. If NOVOL epoxy primers are used, apply the filler after a minimum of 4 hours from applying the epoxy primer.	
Steel surfaces	degrease, dry sand with P80 – P120, degrease again.	
Aluminium surfaces	Degrease with the PLUS 780 degreaser, mat with a needled cloth, degrease again.	
Plastics, except for PE, PP and PTFE	Degrease with the PLUS 780 degreaser, mat with a needled cloth, degrease again.	
Two-component acrylic fillers	degrease, dry sand with P220 – P280, degrease again.	
Note: Do not apply the spray filler directly on top wash primers or one-component acrylic and cellulose nitrate products.		
MIXING RATIO		
	SPRAY CETOX-20OE THIN 880	Volume ratio
		100 ml
		6 to 7 ml
		10% max
Add the thinner in the amount calculated for the mixture of SPRAY with CETOX 20 OE.		

10/06/2015

CONTENT OF VOLATILE ORGANIC COMPOUNDS (VOC)				
VOC II/B/c limit*		540 g/l		
Actual VOC content		150 g/l		
* For ready to use mixture acc. to EU Directive 2004/42/CE				
APPLICATION CONDITIONS				
It is recommended to apply the primer at a temperature above 10°C and a humidity of no more than 80 %.				
APPLICATION				
	Conventional gravity fed spray gun	Nozzle	Pressure	Distance
	CAUTION: Instructions of the equipment manufacturer must be followed.	2.2 – 3.0 mm	3 – 4 bar	15 – 20 cm
	Number of layers	1 – 3		
	Single wet layer thickness	Approx. 100 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	6.0 m²/l at 100 µm		
	Maximum total layer thickness	Approx. 300 µm		
	Mixture life at 20°C	20 – 30 minutes		
	Flash off time between layers	2 – 5 minutes		
DRYING TIMES				
	20°C	90 – 120 minutes		
	60°C	30 min		
CAUTION: The curing times apply to the temperatures of the individual elements.				
SANDING				
	rough	finish		
	P180 – P240	P240 – P320		
COLOUR				
Grey				

COATABILITY	
Most commercial acrylic primers, epoxy primers, paint and varnishes	
EQUIPMENT CLEANING	
THIN 880 spray filler thinner or NC solvent.	
STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
SPRAY	12 months/20°C
CETOX-20OE	18 months/20°C
THIN 880	24 months/20°C
SAFETY	
See Safety Data Sheet.	
NOTES	
Intended for professional use only. The SPRAY filler must be used with the CETOX-20 OE hardeners and the THIN 880 thinner only. Using other systems (hardener, thinner) may result in insufficient curing of the filler and flaws in coating.	
OTHER INFORMATION	
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.	