



Technical Data Sheet
P-S ALUMINIUM
Polyester spray filler with aluminium powder



RELATED PRODUCTS






P-S Aluminium
5 mmCetox-20 OE
THIN 880

Polyester spray filler with aluminium powder
Hardener
Thinner for polyester spray filler

PROPERTIES

- A product designed and dedicated for renovation of classic cars
- Application of thick layers is possible
 - High yield
 - Good hiding power
 - Perfect filling properties
- The aluminium powder increases resistance to high temperatures and guarantees excellent adhesion

SUBSTRATES			
Steel	Clean steel surfaces until reaching Sa 2 ^{1/2} (wet blasting) or St3 (manual cleaning or using a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free from oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.		
Old paint coatings	Degrease with SILICON REMOVER and dry sand with P220 – P280.		
Polyester putties	Dry sand, use P240 – P320 for final sanding.		
Aluminium	Degrease with SILICON REMOVER and mat with an abrasive needled cloth. Degrease again with SILICON REMOVER.		
Epoxy primers	Dry sand with P220 – P280 and degrease with SILICON REMOVER. CAUTION: P-S ALUMINIUM must be applied at least after 24 hours from application of the epoxy primer		
Plastics, except PE (polyethylene) and PTFE (Teflon)	Degrease with SILICON REMOVER and mat with an abrasive needled cloth. Degrease again.		
Polyester laminates	Dry sand with P280, degrease again.		
CAUTION: Do not apply polyester putty directly on top wash primers or one-component acrylic and nitrocellulose products.			
MIXING RATIO			
	P-S Aluminium Cetox-20 OE THIN 880	Volume ratio	Weight ratio
		100 ml	100 g
		6 to 7 ml max. 10 ml	3.7 to 4.5 g max. 6 g
Caution: Thin only with the original THIN 880 thinner.			
SPRAYING PARAMETERS:			
Component A	Hardener	Thinner	Pneumatic spraying
P-S Aluminium	Cetox-20 OE	THIN 880	nozzle: Ø2.2 – 3.0mm pressure: 2– 3 bar distance: 15 – 20 cm
APPLICATION			
	Number of layers	1 – 3 Maximum thickness 350 µm	
	Single dry layer thickness	80-100 µm	
	The yield of the ready to use mixture for the given range of dry layer thickness	approx. 6.0 m ² /l at 100 µm	
	The actual yield depends on the surface shape, roughness and application parameters.		

	Mixture life at 20°C	20 – 30 min	
	Flash-off time between layers	5 min	
CURING TIME			
	Time to sand	20°C	60°C
	For thickness of 100 µm	2 h	30 min
IR DRYING			
	Distance	Follow the recommendations of the equipment manufacturer	
	Time depending on the type and power of the lamp	10 – 20 min	
CAUTION: Start IR heating after at least 10 mins from applying the last coat.			
SANDING:			
	Rough	P180 – P240	
	Finish	P240 – P320	
CONTENT OF VOLATILE ORGANIC COMPOUNDS			
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 at a temperature above 15°C and a humidity of no more than 80 %.			
COLOUR			
Steel grey			
EQUIPMENT CLEANING			
NC solvent			
STORAGE CONDITIONS			
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.			
SHELF LIFE			
P-S Aluminium		12 months/20°C	
Cetox-20 OE		18 months/20°C	
SAFETY			
See Safety Data Sheet.			



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15.04.2020

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 trial/test application of the product due to the potential variation of product performance between substrate materials. We may not be held liable for defects if final results were affected by factors beyond our control.