

## TECHNICAL DATA SHEET

### SK4 POLYESTER SPRAY FILLER GREY / SK4B POLYESTER SPRAY FILLER WHITE

Polyester spray primer for finishing the models and filling surfaces. It allows to apply high thicknesses even in a single coat of spraying in several passes.

It is a very low shrinkage product, easy to sand and polish and has excellent adhesive performance on wooden and laminate supports.

It is compatible with all paints.

#### SUPPORS

Recommended: sanded fiberglass, impregnated wood, polyester fillers, modeling pastes.

#### GENERAL INSTRUCTIONS FOR USE

Apply on well cleaned sanded surfaces; make sure that the substrate is free of dust, fibers, dirt and surface condensation.

Dilute with acetone or MEK from 0 to 10% by volume.

Add the solution thus obtained with 3% - 4% of liquid hardener CT20 (cyclohexanone peroxide) and mix carefully each time the primer is used, bearing in mind that the quantity of hardener

required depends on the temperature of use and the times of processing required.

Let the product de-aerate for a few minutes before applying it; the application time of the hardened product varies from 20 to 30 minutes at 23°C in function of the quantity of hardener used.

The recommended temperature range is between 16 and 28°C.

Typical application by airbrush 200-300 microns in 1 coat to be applied in two coats up to a maximum thickness of 800-1000 microns; nozzle diameter 2,5 mm; air pressure 3,5 bar.

Sandable after 4 hours from application at 23°C.

Paintable with gelcoat or polyester paint after 4 hours; with other paints after 24 hours.

Typical dry sanding cycle, grits: P150-P220-P320-P400-P600.

The theoretical yield per m<sup>2</sup> per 1000 dry microns of thickness, is approximately 1,8 KG.

In its original packaging, the product can be used for 6 months if stored indoor away from direct sunlight, at temperatures not exceeding 20°C.

#### TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

Tests made at 23°C	Value	Unit of measure	Method
Color	Grey / White	-	IMIA-01
Density	1,55 ± 0,05	Kg/l	IMIA-02
Solid content	76 ± 2	%	IMIA-03
Viscosity (Ford cup 8)	50 ± 5	s	IMIA-12
Reactivity (100g product + 3,50 g CT20)	25 ± 5	min	IMIA-15

#### TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (\*)

Tests made at 23°C	Value	Unit of measure	Method
Superficial hardness	65 ± 5	Shore D	IMIA-29
Thermo-mechanical resistance: HDT	60 ± 5	°C	IMIA-50
Brilliance	50 ± 5	GU	IMIA-70

(\*) on specimens hardened 24 hours at 23 °C and post hardened 3 hours at 80 °C

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