

TECHNICAL DATA SHEET

MAX

Review 003, 05/2016

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PRODUCT

POLYESTER FILLER low V.O.C. (C3111)

FEATURES

It is a 2K Polyester Filler that can be used for total or partial reconstruction of industrial vehicles and cars. MAX Polyester filler has a perfect laying, excellent adhesion to various substrates, has good rust inhibiting properties. MAX Polyester filler can be used both as a spray filler or as insulating filler. It can be applied onto polyester primers and putties, fibreglass, gel coat, primer and epoxy primers.

TECHNICAL DATA

Specific weight	1400 ± 20 g/l	(MI 001)
Solid in weight	70 ± 1 %	(MI 006)
V.O.C.	224 ± 5 g/l (FILLER+CAT.+max10%DIL.)	(ASTM D2369)
Colour	Light Grey	

STORAGE

Keep the container well closed and stored in a cool (temperature below 25°C) and ventilated environment for a maximum period of 12 months from the date of production marked on the tin. Avoid direct sun exposure.

SAFETY RULES

During the application and drying time ventilate the room. We recommend the use of appropriate PPE during application. Before operate, please read the safety data sheet.

APPLICATION












After the addition of the proper quantity of hardener it is possible to apply it by spray. It is advisable to lay from 2 to 4 coats to a final thickness of 800 micrometers, with a pressure from 3 to 5 atm, and a nozzle of 2.5 - 4 mil. The MAX polyester filler is ready to use, if necessary can be diluted with specific solvent up to 10% according to the final required results. You can start with a light coat, wait 5-10 minutes depending on the room temperature, then proceed to spray one or two full coats, waiting 5-10 minutes in between. Or you can, depending on the use, spray a single thicker coat. Do not apply on damp surfaces.

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	Mixing ratio volume / mass	100 g : 1 - 3 g	
	Nozzle diameter/ Air pressure	2.5 ÷ 4.0 mm 3.0 ÷ 5.0 bar	
	Pot life	20 - 40 min according to dilution and temperature	(MI 013; 25 °C)
	Dust free time	< 5 min	(MI 012; 25 °C)
	Dry to touch	20 min	(MI 012; 25 °C)
	Full dry	< 4 h	(MI 012; 25 °C)
	Sanding	After 3 h 1) P 360-400 (dry) 2) P 600-800 (wet)	(MI 012; 25 °C)
	Dry film thickness	400 ÷ 800 µm	
	Theoretical yield	600 - 1100 g/m ²	(MI 014)
	Number of coats	2 - 4	
	Thinner	MAX styrene	

ADDITIONAL INFORMATION

DRYING/WORKABILITY (MI 012, MI 013)

HARDENER	WORKING TIME	SANDING
1%	40 min	4 h
2%	25 min	3 h
3%	20 min	2,5 h