



**SHERWIN
WILLIAMS.**

Chemical Coatings

CC-D1

POLANE[®] SprayFil

Light Gray D61A23
 White D61W24
 Black D61BB2
 Catalyst V66V27

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>POLANE[®] SprayFil is a two package polyurethane filler designed to fill and/or hide profile and surface imperfections on metal, castings, structural foam plastics, and wood. It also promotes adhesion of topcoats to the substrate.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Versatile as a filler, primer surfacer, or as a primer • Excellent filling properties on castings and metal for the machine tool and general metal industry • Excellent filling and basecoat properties on a wide range of structural foamed plastics as well as FRP and SMC • Designed for thick applications • Easy sanding • Promotes excellent salt spray, humidity, and chemical resistance on metal surfaces when topcoated with Polane enamels • Air dry or force dry • Free of lead and chromate hazards • No critical recoat time, no lifting • Apply to wood, particle board, and medium density fiberboard and topcoat with high gloss or low gloss texture coatings for interior office and furniture applications. Polane polyurethane enamels and Sher-Wood[®] Pigmented Conversion Varnish are recommended topcoats for wood 	<p>Gloss: Flat</p> <p>Volume Solids: 38±2% catalyzed and reduced may vary by color</p> <p>Viscosity: 20-25 seconds #3 Zahn Cup catalyzed and reduced</p> <p>Recommended film thickness: Mils Wet 4.0 - 6.0 Mils Dry 1.5 - 2.4</p> <p>Spreading Rate (no application loss) 240-428 sq ft/gal @ 1.5-2.4 mils DFT</p> <p>Drying (77°F, 50% RH): To Touch: 15 minutes To Handle: 1 hour To Recoat: 1 hour To Sand: 4 hours Force Dry: 20-30 minutes at 140°F</p> <p>Curing temperature must not exceed the heat distortion temperature of the plastic substrate.</p> <p>Flash Point: 75-80°F Pensky-Martens Closed Cup</p> <p>Mixing Ratio: 13 parts SprayFil 1 part Catalyst V66V27 2 part Reducer R7K84</p> <p>Pot Life: 6-8 hours</p> <p>Package Life: 3 years, unopened</p> <p>Air Quality Data: Non-photochemically reactive Volatile Organic Compounds (VOC) SprayFil, as packaged, maximum 4.24 lb/gal, 508 g/L V66V27, as packaged, maximum 3.82 lb/gal, 458 g/L catalyzed and reduced as above 4.6 lb/gal, 552 g/L HAPS as packaged maximum 1.72 lbs/gal solids</p> <p>An Environmental Quality Data Sheet is available from your local Sherwin-Williams facility.</p>	<p>General: Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties. Consult Metal Preparation Brochure CC-T1 for additional details. When used as a filler, additional coats may be applied after flash off between coats.</p> <p>Aluminum: Prime with Industrial Wash Primer, P60G2 or Kem Aqua Wash Primer, E61G520.</p> <p>Galvanized Iron: Prime with Industrial Wash Primer, P60G2 or Kem Aqua Wash Primer, E61G520.</p> <p>Machine tool castings: Apply a light coat to highlight the defects. Then apply multiple coats until the desired filling is achieved. Up to 15 mils dry film can be applied in multiple steps.</p> <p>Plastic: Mold release must be removed from the substrate. Due to the diverse nature of plastic substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production. Reground and recycled plastics along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion. Please consult your Sherwin-Williams Chemical Coatings Sales Representative for system recommendations.</p> <p>Polystyrene and Polycarbonate: When coating these plastics, use Polane Catalyst V66VB10 and MEK, R6K10 instead of V66V27 and reducer R7K84, at the same mixing ratios. This faster evaporating system has much less effect on the plastics. Do not exceed 4.0 mils dry film.</p> <p>Steel or Iron: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.</p> <p>Wood (interior only): Must be clean, dry, and finish sanded. Do not exceed 2.5 mils dry film.</p> <p>Testing: Due to the wide variety of substrates, surface preparation methods, and application methods and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.</p>

APPLICATION

Typical Set up

Conventional Spray:

Air Pressure40-50 psi
Fluid Pressure 5-10 psi

HVLP:

Atomizing Air Pressure at the cap
.....8-10 psi
Fluid Pressure 5-10 psi
Tip055

Dip, flocoat, and brushing are not recommended

Cleanup:

Clean tools/equipment immediately after use with Polane Reducer #84, R7K84.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- **Do not vary catalyst ratio.** Polane SprayFil must be catalyzed at 13:1 ratio to achieve optimum performance, hardness, flexibility, gloss, and chemical and solvent resistance.
- Do not spray hot. Heat shortens the pot life.
- Do not pump catalyzed material from drums into circulating systems. Friction heat developed by pumps and circulation will shorten pot life.
- Protect Polane SprayFil, Catalyst and Reducer from moisture. Water affects the pot life and product properties.
- Do not package Polane coated products in airtight plastic bags unless completely cured. Since Polane continues to cure for several weeks, the buildup of organic solvents and reaction by-products could cause improper cure and adhesion failure in use.
- If not topcoated within 7 days at room temperature, scuff sand before topcoating to ensure proper intercoat adhesion.
- For high gloss finishes, an intermediate sealer such as Polane Primer-Sealer, E65A4 may be required.
- On all substrates, excess film thickness may cause splitting of the film or adhesion loss.
- For wood, the total dry film thickness of the system—SprayFil and the topcoats—must not exceed 5 mils to ensure optimum performance, thicker films may cause cracking.

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams company cannot make any warranties as to the end result.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION

Thoroughly review product label and Material Safety Data Sheet (MSDS) for safety and cautions prior to using this product.

A Material Safety Data Sheet is available from your local Sherwin-Williams facility.

Please direct any questions or comments to your local Sherwin-Williams facility.