



**SHERWIN
WILLIAMS.**

Chemical Coatings

C-D16A

POLANE® 2.8 Plus SprayFil

Beige D61H75
Catalyst V66V44

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>POLANE® 2.8 Plus SprayFil is a two package, 2.8 VOC, 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"> Complies with 2.8 VOC EPA solvent emission regulations Versatile as a filler, a primer surfacer or as a primer Excellent filling properties on castings and metal for the machine tool and general metal industry. Designed for heavy film applications Excellent filling and basecoat properties on a wide range of structural foam plastics as well as FRP and SMC Easy sanding Promotes good salt spray, humidity and chemical resistance on metal surfaces when topcoated with Polane enamels Air dry or force dry cure. Low energy cure Free of lead and chromate hazards No critical recoat time - no lifting HAPS Free 	<p>Gloss: Flat</p> <p>Volume Solids: 60 ± 2% catalyzed and reduced</p> <p>Viscosity: 10-12 seconds #4 Zahn Cup catalyzed and reduced</p> <p>Recommended film thickness: Mils Wet 3.0 - 5.0 Mils Dry 2.0 - 3.0</p> <p>Spreading Rate (no application loss) 310-497 sq.ft./gal @ 2.0-3.0 mill DFT</p> <p>Drying (77°F, 45% RH): To Touch: 20-30 minutes To Handle: 1 hour To Sand: 4 hours To Recoat: 1 hour Force Dry: 20-30 minutes at 140°F, sand or recoat</p> <p>Curing temperature must not exceed the heat distortion temperature of the plastic substrate.</p> <p>Mixing Ratio: 6 part Spray Fil D61H75 1 part Catalyst V66V44 1/3 part Reducer R7K95</p> <p>Note: Maximum total reduction is 5% by volume to maintain 2.8 VOC maximum.</p> <p>Pot Life: 2 hours</p> <p>Flash Point: 35°F, Pensky-Martens Closed Cup</p> <p>Package Life: 2 years, unopened</p> <p>Air Quality Data: Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum 2.55 lb/gal, 300 g/L catalyzed and reduced as above: 2.8 lb/gal, 336 g/L Free of lead and chromate hazards</p> <p>An Air 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.</p> <p>Aluminum (untreated): Prime with Industrial Wash Primer P60G2, or Kem Aqua® Wash Primer E61G520.</p> <p>Galvanized Steel (untreated): Prime with Industrial Wash Primer P60G2, or Kem Aqua Wash Primer E61G520.</p> <p>Plastic: Mold release must be removed from the substrate. For structural foam do not exceed 4 mils dry film. 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. Re-ground 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>Steel: 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>Cast Iron: Fill with Polane 2.8 Plus SprayFil, D61H75 and sand. For optimum holdout, apply Polane Plus Sealer, E65A71.</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>Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.</p>

APPLICATION

Typical Setups

Conventional Spray:

GunDeVilbiss MBC
Air Pressure 50 psi
Fluid Pressure 10 psi
Cap/Tip 797/E or FF

Dip, flo-coat and brushing are not recommended.

Cleanup:

Clean tools/equipment immediately after use with Reducer R7K95 or MAK. Polane reducers, MEK and MIBK may also be used but are not HAPS compliant.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- Polane Plus Spray Fil must be catalyzed at 6:1 ratio to achieve proper performance. DO NOT VARY CATALYST RATIO. The catalyst ratio has been established for optimum hardness, flexibility, gloss, and chemical solvent resistance.
- Do not spray hot. Heat shortens pot life. Do not pump catalyzed material from drums into circulating system. Friction heat developed by pumps and circulation will shorten pot life.
- Protect Polane Plus Spray Fil, Catalyst, and Reducer from moisture as water affects pot life and properties. Store indoors.
- Do not package Polane coated products in airtight plastic bags unless completely cured. Since Polane Enamels continue 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 room temperature cure, scuff sand before topcoating to insure proper intercoat adhesion.
- For high gloss finishes, an intermediate sealer coat may be required.

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.

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.