



# General Industrial Coatings

CC-D16B

## POLANE® 2.8 Plus SprayFil

Beige ..... D61H75 Catalyst ..... V66V47 Custom Blend Series ..... D61XX

### DESCRIPTION

**POLANE® 2.8 Plus SprayFil** is a two-component, 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.

#### Advantages:

- Formulated to meet 2.8 lb/gal VOC, less exempts when catalyzed and reduced
- 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
- Provides good salt spray, humidity, and chemical resistance on metal surfaces when topcoated with Polane® enamels
- Air dry or force dry. Low energy cure
- No critical recoat time
- Formulated to be non-HAP

\*VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at [www.PaintDocs.Com](http://www.PaintDocs.Com).

### CHARACTERISTICS

**Gloss:** Flat

**Volume Solids:** 62 ± 2 %  
Catalyzed and reduced

**Viscosity:** 10-12 secs., #5 Zahn Cup  
Catalyzed and reduced

**Recommended Film Thickness:**  
Mils Wet 3.0-5.0  
Mils Dry 2.0-3.0

**Spreading Rate** (no application loss):  
330-500 ft.<sup>2</sup>/gal. at 2.0-3.0 mils DFT

**Cure:**  
Air Dry or Force Dry 20-30 minutes at 140° F  
Sand or recoat

**Substrate Disclaimer:** Curing of coating at temperatures higher than the heat distortion parameters of the substrate may cause substrate issues.

**Drying:** 77° F, 45% RH  
To Touch 20-30 minutes  
To Handle 1 hour  
To Recoat 1 hour  
To Sand 4 hours

**Mixing Ratio** (by volume):  
SprayFil D61H75 6 parts  
Catalyst V66V47 1 part  
Reducer R6K30 0.33 parts (5% by vol.)  
Maximum total reduction is 5% by volume to maintain 2.8 VOC maximum.

**Potlife:** 2 hours

**Flash Point** (Pensky Martens Closed Cup): 81° F

**Air Quality Data:**  
Photochemically Reactive  
Volatile Organic Compounds (VOC)  
Theoretical as packaged, maximum, Less exempt solvents 2.55 lbs/gal, 306 g/L  
Catalyzed and reduced as above 2.8 lbs/gal, 336 g/L

**Package Life:** 2 years, unopened  
V66V47 12 months, unopened

### SPECIFICATIONS

**General:** All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

**Aluminum** (untreated): Prime with Industrial Wash Primer P60G2, RoHS Compliant Wash Primer, P60G10, or Kem Aqua® Wash Primer E61G522.

**Galvanized Steel** (untreated): Prime with Industrial Wash Primer P60G2, RoHS Compliant Wash Primer P60G10, or Kem Aqua Wash Primer E61G522.

**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. 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 Product Finishes Sales Representative for system recommendations.

**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.

**Testing:** The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility, and performance prior to full scale application.

## **APPLICATION**

### **Typical Setups**

**Reduction:** Reduce with R6K30. Maximum total reduction is 5% by volume to maintain 2.8 lbs/gal VOC. Using other Polane reducers (R7K74, R7K84, R7K95) will change the VOC and may affect viscosity.

### **Conventional Spray:**

Air Pressure	50-55 psi
Fluid Pressure	10-15 psi
Tip	0.055-0.070 in.

Dip, flow-coat and brushing are not recommended.

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

### **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.

## **ADDITIONAL INFORMATION**

1. Polane 2.8 Plus SprayFil 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.
2. Do not spray hot. Heat shortens pot life.
3. Do not pump catalyzed material from drums into circulating system. Friction heat developed by pumps and circulation will shorten pot life.
4. Protect Polane 2.8 Plus SprayFil, catalyst, and reducer from moisture as water affects pot life and properties. Store indoors.
5. 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.
6. If not topcoated within 7 days room temperature cure, scuff sand before topcoating to insure proper intercoat adhesion.
7. For high gloss finishes, an intermediate sealer coat may be required.
8. Compatible with GIS and Phoenix® colorants. The maximum tint load is 2 ounces colorant per gallon of paint.

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## **CAUTIONS**

### **FOR INDUSTRIAL SHOP APPLICATION ONLY**

**Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.**

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or [www.PaintDocs.Com](http://www.PaintDocs.Com).

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

### **Note:**

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