



General Industrial Coatings

CC-D1

POLANE® SprayFil

Black D61BB2 Catalyst.....V66V27
 Light Gray..... D61A23 Custom Blend Series D61XX
 White D61W24

DESCRIPTION

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.

Advantages:

- 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 foam 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
- No critical recoat time, no lifting
- Apply to wood, particle board, medium density fiberboard and topcoat with Polane polyurethane enamels

*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.

CHARACTERISTICS

(may vary by color)

60° Gloss: Flat

Volume Solids: 38-40 ± 2 %
Catalyzed and reduced

Viscosity: 20-25 secs., #3 Zahn Cup
Catalyzed and reduced

Recommended Film Thickness:
Mils Wet 4.0-6.0
Mils Dry 1.5-2.4

Spreading Rate (no application loss):
240-428 ft.²/gal. at 1.5-2.4 mils DFT

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

Mixing Ratio (by volume):
Polane Sprayfil 13 Parts
Catalyst V66V27 1 Part
Reducer R7K84 2 Parts

Potlife: 6-8 hours

Package Life:
Bases 3 years, unopened
V66V27 Catalyst 1 year, unopened

Flash Point (Pensky Martens Closed Cup):
75-80° F

Air Quality Data (Theoretical)

Non-photochemically reactive
 Volatile Organic Compounds (VOC)*
 Bases as packaged, maximum:
 4.24 lbs/gal, 508 g/L
 V66V27, as packaged, maximum
 3.82 lbs/gal, 458 g/L
 Catalyzed and reduced, as above
 4.60 lbs/gal, 552 g/L
 HAPS as packaged, maximum
 1.72 lbs/gal solids

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, or RoHS Compliant Wash Primer, P60G10, or Kem Aqua® Wash Primer, E61G522.

Galvanized Iron: Prime with Industrial Wash Primer, P60G2 or RoHS Compliant Wash Primer, P60G10, or Kem Aqua Wash Primer, E61G522.

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.

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 Sales Representative for system recommendations.

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.

Wood (interior only): Must be clean, dry, and finish sanded. Do not exceed 2.5 mils dry film.

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

Conventional Spray:

Air Pressure	45-55 psi
Fluid Pressure	10-15 psi
Tip	0.055-0.070 in.

HVLP Spray:

Air Pressure at the cap	8-10 psi
Fluid Pressure	5-10 psi
Tip	0.055-0.070 in.

Dip, flowcoat, and brushing are not recommended

Cleanup: Clean tools and equipment immediately after use with R7K84, Polane Reducer #84.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. **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.
2. Do not spray hot. Heat shortens the pot life.
3. Do not pump catalyzed material from drums into circulating systems. Friction heat developed by pumps and circulation will shorten pot life.
4. Protect Polane SprayFil, catalyst and reducer from moisture. Water affects the pot life and product properties.
5. 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.
6. If not topcoated within 7 days at room temperature, scuff sand before topcoating to ensure proper intercoat adhesion.
7. For high gloss finishes, an intermediate sealer such as Polane Primer Sealer, E65A4 may be required.
8. On all substrates, excess film thickness may cause splitting of the film or adhesion loss.
9. 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.
10. 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.

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

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