



DELTRON[®]



Product Information

P.E. Spray

*Polyester Spray Filler A712
Hardener for Polyester Spray Filler SHA307
Thinner for Polyester Spray Filler A714*

Product Description

P.E. Spray is a light grey 2-component polyester spray filler. It is designed for the repair of large surfaces with extensive defects and irregularities— where use of conventional knifing stoppers would be inconvenient and time-consuming.

Quick drying, easy to apply and with high film build, P.E. Spray may be used over a variety of substrate materials. Once sanded, it may be overcoated with any refinish primer or surfacer before application of topcoat.

When mixed with SHA307 Hardener, P.E. Spray's ready-for-use VOC content is below 540 g/L.

Preparation of Substrate

In all cases, select the appropriate PPG cleaner(s) from the guide below, and ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Steel after degreasing with Prepsol, should be abraded with P80 – P120 grit discs and be completely rust free by conditioning with SX520 Metal Conditioner or Deoxidine 624.

Fibreglass (GRP) after removing mould release agent using BodyKleen, degreasing with D837 Spirit Wipe or Prepsol and sanding with 240-320 dry.

An Epoxy Primer such as DP616, VCP150 or 410-48248 must be applied for maximum adhesion and corrosion resistance prior to application of P.E. Filler. Refer to data sheet for application details.

Do not apply P.E. Stopper to acrylic lacquer finishes, freshly painted surfaces and acid etch primers such as DP612, 2K CF Etch or F3963.

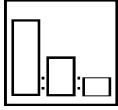
Please note: Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.

Guide to Selection of Substrate Cleaners

Code	Product	Purpose
D845	High-Strength Degreaser	For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work, and on any bare metal substrate.
D837	Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.

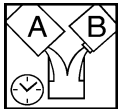
Application Guide

Mixing Ratio



	Volume	Weight
A712	100 parts	100 grams
SHA307	2.5 parts	2.0 grams
A714	5-10 parts	4-8 grams

Potlife



1 hour at 20°C/68°F

Spraygun Setup



Gravity

2.0 –2.5 mm

Suction

not recommended

Spray Pressure

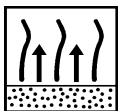
2-3 bar / 30 - 43.5 PSI

Number of Coats



up to 4 maximum

Flash Off at 20°C/68°F



Between coats

5 - 10 minutes

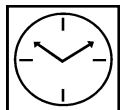
Before stoving

10 minutes

WARNING: Using significantly more than the indicated amount of hardener and / or using a hardener other than that specified in this data sheet, can lead to an excessive increase in temperature during mixing. Potentially, if the temperature rise is very high, the product could auto-ignite. This warning applies to this and any other peroxide catalysed polyester filler and is not given because this filler presents more danger than other products of this type.

Application Guide

Drying Times



Dust-free (at 20°C/68°F)	20 minutes
Dry to sand (20°C/68°F)	2–3 hours
Dry to sand (60°C/140°F)*	30 minutes

* Stoving time required once metal reaches the quoted temperature. Stoving schedule should allow additional time for metal to reach this temperature.



IR drying times:	
short wave	10 minutes
medium-wave	15 minutes

Note: Quoted bake time is once the metal temperature reaches quoted temperature. Bake time schedule should allow additional time for metal to reach the necessary temperature

Technical Data

Total Dry Film Build

Minimum	150 µm/6 mil
Maximum	300 µm/12 mil

Theoretical Coverage* Over 2 –3 m²/L or 82 – 122 sq. ft./gal

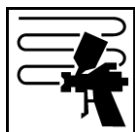
* Theoretical coverage in m²/L or sq. ft./gal. ready-to-spray, giving a dry film thickness between indicated minimum and maximum values.

Sanding



Grade wet	<u>Do not wet sand</u>
Grade dry	P120-180 followed by P240-320

Overcoat with



Any PPG 2K primer*.

*Please refer to 'Performance and limitations' section overleaf.

Performance and Limitations

Do not apply P.E. Spray over phenolic-based primers (e.g. *DP612, 2K CF Etch or F3963*).

All cans of A712 should be mechanically shaken or thoroughly hand-stirred before use.

Avoid stirring unactivated A712 with mixing sticks contaminated with residues of material containing SHA307 hardener.

Mix only the quantity of product required for immediate use. Do not return activated material to the original container. Carefully re-seal part-used containers of A712 and SHA307.

P.E. Spray is water-sensitive and must not be wet-sanded.

P.E. Spray must not be overcoated directly with topcoat finishes. Always apply a sealer coat of a suitable 2K Epoxy primer such as DP616 EpoxyTHANE, followed by 2K primer filler or surfacer before application of topcoat.

Immediately after use, thoroughly clean all spray and mixing equipment with cleaning solvent or thinner.

The use of HVLP spray equipment can give an increase in transfer efficiency of around 10% depending upon the make and model of equipment used.

Due to the vast variables associated with Spray polyesters A712 is not part of the PPG lifetime paint guarantee programme

Health and Safety

For comprehensive Health, Safety and Environmental advice, please refer to relevant Material Safety Data Sheets and Product Can labels.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.



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