

GENERAL INFORMATION

PF131G HS Surfacers Grey is a 2K polyurethane high filling surfacer with excellent sanding properties, which can also be used as a non-sanding surfacer. It is very easy to apply and gives high durability and appearance.

This TDS is about the Sanding version.

MIXING RATIO



3 : 1 Surfacers : 2K/MS Hardener + max 10% Uni Thinner
 4 : 1 Surfacers : HS Hardener + max 15% Uni Thinner
 6 : 1 Surfacers : HS420 Hardener + max 25% Uni Thinner

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,8	2/29
HE	1,3-1,8	1,6-1,8/23-26

APPLICATION



1 - 3 coat 60-180 µm (2,4-7,2 mil)

FLASH OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	5 - 10 minutes	Flash off	5 - 10 minutes
Dust free	20 - 30 minutes	Dust free	-
Dry to handle	16 hours	Dry to handle	20 - 30 minutes
Dry to tape	16 hours	Dry to tape	20 - 30 minutes
Dry to sand	16 hours	Dry to sand	20 - 30 minutes
Dry to polish	-	Dry to polish	-

INFRARED DRYING



After full flash off and at proper distance	
Half-bake	3 min 50°C
Full-bake	10 min 65°C
See IR Manufacturer information	

SUBSTRATES



PF131G HS Surfacers Grey should only be applied over well sanded/scuffed and degreased primed bare steel and primed aluminium. Well sanded GRP, polyester fillers, OEM primer and old paint systems in good condition. (Use PW170 Washprimer for maximum durability and rust protection.)

POT LIFE AT 20°C / 68°F



20 - 30 minutes

COMPONENTS



H13 2K Hardener Very Fast
 H14 2K Hardener Fast
 H15 2K Hardener Medium
 H16 2K Hardener Slow
 H34 MS Hardener Fast
 H35 MS Hardener Medium
 H36 MS Hardener Slow
 H53 HS Hardener Very Fast
 H54 HS Hardener Fast
 H55 HS Hardener Medium
 H56 HS Hardener Slow
 H23 HS420 Hardener Very Fast
 H24 HS420 Hardener Fast
 H25 HS420 Hardener Medium
 H26 HS420 Hardener Slow
 TA900 Uni Thinner Fast
 TA910 Uni Thinner Medium
 TA920 Uni Thinner Slow

ADDITIVES



AE001 Elastic 2K

Add before hardener.

SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover wipe on and wipe dry. Sand surface with P180—P240 grit abrasive. Remove all sanding debris with compressed air, sanding vacuum and clean with TD20 Silicone Remover wipe on and wipe dry. Final sanding before application P280-P320 feather-edge and GRP P400.



Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



W00 - W999 Octobase Eco Plus System
 F00 - F98 Octocoat HS420 System
 B00 - B999 Octobase System
 A00 - A98 Octocryl System

PHYSICAL DATA

EU REGULATIONS		
VOC Code	2004/42/IB(c)(540)534	
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.	IIB/c. Primer - Surfacers/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 534 g/l VOC.	
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	20 - 22 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,41
	Flash Point Closed Cup	27,5°C / 81,5°F
	Volume % Solids	44
	Economy	7 m ² /L/60 µm 285 ft ² /Gal/2,4 mil
	Gloss	Matt
Colour	Grey	



PROTECTION

Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.octoral.com/en/octoral/choose_localization

CLEAN UP



Gun Cleaner

STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).



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