

NOVOL

For Classic Cars

Technical Data Sheet

P-S

Polyester Spray Filler with Mixing Indicator

PROPERTIES

- Designed and dedicated for the refinishing of classic cars
- Suitable for application in thick layers
- High yield
- Perfect hiding power and flow
- Includes the Mixing Indicator for polymerisation ratio and mixture uniformity control
- Excellent finishing of large work areas



RELATED PRODUCTS

Cetox-20 OE

Hardener

THIN 880

Spray filler thinner

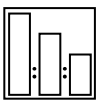
DESCRIPTION

The finish filler for spray application, complete with the Mixing Indicator for correct mixing control. The Mixing Indicator of the P-S spray filler starts working already when mixing and moving the ready mixture to the spray gun canister to enable component mixing uniformity control and consequently, uniform curing following the application on the classic car body.

A special selection fillers and resins minimises shrink and enables excellent processing ability on large work areas.

SUBSTRATES	
EPOXY PRIMER	Apply once the epoxy primer has cured for 24h at 20°C. Dry sand with a claret abrasive cloth or paper P220 - P240. Blow off all dust and degrease with the SILICONE REMOVER.
HYBRID EPOXY PRIMER – ANTI-CORROSION	It is recommended to be applied after 24h at 20°C The chemical activity life is up to 7 days at 20°C without matting. If necessary, dry sand with a red abrasive cloth or P220 - P240 grit paper. Blow off all dust and degrease with the SILICONE REMOVER.
NfCC polyester fillers/putties	Apply on the filler/putty sanded to finish with P220 - P240 grit paper. Follow by thoroughly blowing off all dust, degrease with the SILICONE REMOVER, and blow off all dust again.
HYBRID EPOXY PRIMER – ISOLATOR	Apply at least 4h at 20°C after application of the HYBRID EPOXY PRIMER – ISOLATOR. Requires no sanding for up to 12h to 20°C. After more than 12h at 20°C, sand with a red abrasive cloth. Thoroughly blow off all dust and degrease with the SILICONE REMOVER.
BODYWORK PRIMER	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER- ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Steel	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Aluminium – new parts and body panelling	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Aluminium – body parts for refinishing	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Existing coatings	Do a solvent effect test. If the old coating resists the solvent, strip it away and apply anti-corrosion protection according to the NfCC processing procedures. Degrease with the SILICONE REMOVER, dry sand with P220 - P240 grit paper, blow off all dust again and degrease again.
Old polyester laminates	Degrease with the SILICONE REMOVER, dry sand with P180 - P240 grit paper, blow off all dust again and degrease again.
The NfCC refinishing process does not permit direct application of polyester products on metallic substrates. Anti-corrosion preservation with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION is required.	

MIXING RATIO

		Volume ratio	Weight ratio
	P-S Cetox-20 OE THIN 880	100 ml 6 - 7 ml max. 10 ml	100 g 3.6 - 4.2 g max. 5.6 g





Add the hardener in strict compliance with the specified mixing ratio. Overdosing the hardener will not reduce the curing time required to achieve processability. Overdosing the hardener will negatively affect the mixture dilution and may cause the spray applied filler coat to run.

Dilute only with Novol THIN 880.


In a short time after dosing the hardener, the mixture colour will start to gradually shift to white. Any deviation from the white finish colour after drying is evidence of poor mixing of the components. Having finished dosing, seal the filler, hardener and polyester thinner containers tight.

An unsealed container will cause the filler to release the chemicals which trigger curing, with spontaneous polymerisation by atmospheric oxygen.


APPLICATION

	Spray nozzle	2.5 - 3.0 mm
	Follow the tool manufacturer's guidelines	Input pressure
	Number of layers	1 - 3 Maximum wet film thickness: 300 µm
	Single wet layer thickness	80 - 100 µm
	The actual yield depends on the surface shape, roughness and application parameters.	The yield of the ready for use mixture for the specified range of dry film thickness:
	Mixture life at 20°C	20 - 40 min
	Flash-off time between layers at 20°C	5 - 10 min

If the body pieces require finishing afterwards, it is allowed to apply the P-S spray filler twice.


	Use of the correct PPE is recommended!
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CURING TIME:

	Time to sand Thickness: 100 µm	20°C	60°C
		2 - 3 h	30 - 40 min


The curing time is specified for the body workpiece temperature and not the air temperature!

IR DRYING:

	10 - 20 min
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A short-wave IR lamp is recommended.
Follow the recommendations of the equipment manufacturer!
Start IR heating after at least 20 min after applying the last layer The bottom layers (polyester fillers/putties and epoxy primers) should be cured thoroughly by IR heating once hardened.

SANDING:

	<p>Step 1: Apply the Control Powder or CONTROL SPRAY Step 2: Rough sand with a hand sanding block or an orbital/eccentric sander and P80 - P120 grit paper Step 3: Blow off all dust and apply the Control Powder or CONTROL SPRAY Step 4: Finish sand (process the edges by hand) using an orbital/eccentric sander and P220 - P320 grit paper</p>
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Always dry sand the P-S.
Wet sanding may result in coating defects due to the hygroscopic response of the polyester resin and certain polyester filler/putty filling materials.

VOC CONTENT

VOC II/B/c limit*	540 g/l
Actual VOC	150 g/l

* For a ready for use (RFU) mixture acc. to EU Directive 2004/42/CE.

APPLICATION CONDITIONS

It is recommended to apply the product at over 10°C and a humidity of 80% or lower.
The substrate temperature during application of the filler must be at least 3°C higher than the dew point to avoid condensation and its absorption by the polyester material.

COLOUR:

Blue.

EQUIPMENT CLEANING

NC solvent.

STORAGE CONDITIONS

Store in a dry and cool room, away from sources of fire and heat.
Avoid direct exposure to sunlight.

SHELF LIFE

P-S

12 months/20°C

SAFETY

See the Safety Data Sheet. For professional use only.

OTHER INFORMATION

The effectiveness of our systems results from research in the laboratory and many years of experience. The data contained here meets the current knowledge about our products and their application potential.

We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potential for varying reactions with different materials.

We cannot be held liable for defects where the final results were affected by factors beyond our control.

This TDS supersedes all its previous issues.

Index number: 000024104



RFU	P-S	Cetox-20 OE 7%	THIN 880 10%
0.10 L	160 g	7 g	9 g
0.15 L	240 g	10 g	13 g
0.20 L	320 g	13 g	18 g
0.25 L	400 g	17 g	22 g
0.30 L	480 g	20 g	27 g
0.40 L	640 g	27 g	36 g
0.50 L	800 g	34 g	45 g
0.60 L	960 g	40 g	54 g
0.70 L	1120 g	47 g	63 g
0.80 L	1280 g	54 g	72 g
0.90 L	1440 g	60 g	81 g
1.00 L	1600 g	67 g	90 g
1.50 L	2400 g	101 g	134 g
2.00 L	3200 g	134 g	179 g