

TECHNICAL DATA SHEET

FP11 POLISHING FINISHING FILLER GREY

Grey polishing filler spray, based on high quality polyester resins. Formulated for the spray finishing of both traditional and milled models.

Ideal for finishing all INTEC millable tooling pastes.

Excellent in the application for vertical surface, it allows obtaining considerable thicknesses.

With an adequate sanding and polishing cycle it reaches an average degree of gloss that does not require further painting; if it is specifically required, it can be painted over.

SUPPORTS

Recommended: sanded laminate, MDF, polyester fillers, millable pastes.

GENERAL INSTRUCTIONS FOR USE

- Apply on well cleaned sanded surfaces; make sure that the substrate is free of dust, fibers, dirt and surface condensation.
- Dilute with acetone or MEK from 0 to 10% by volume.
- Add 1% - 2% of liquid hardener CT21 (MEKP Butanox M50 or equivalent) and mix thoroughly, bearing in mind that the amount of hardener required depends on the temperature of use and the processing times required.

- Leave the product to air out for a few minutes before applying it; the application time of the hardened product varies from 20 to 30 minutes at 23°C depending on the quantity of hardener used.
 - The recommended temperature range is between 16 and 28°C.
 - Typical application by gravity spray gun 200-300 microns each coat to a maximum thickness of 800-1000 microns in few coats with 5 - 10 minutes intervals between one and another; nozzle diameter 2,5 mm; air pressure 3,5 bar.
 - Sandable after 3-4 hours from the application at 23°C.
 - The best results are obtained when the product is sanded only once during hardening and the surface is sanded with a fine grit and finished with polishing the next day, allowing the solvents to evaporate.
 - Paintable with gelcoat or polyester paint after 4 hours: with other paints after 24 hours.
 - Typical dry sanding cycle, grits: P220-P320-P400- P600-P800-P1200.
 - The theoretical yield per m² per 1000 dry microns of thickness, is approximately 1,8 kg.
- In its original packaging, the product can be used for **6 months** if stored indoor away from direct sunlight, at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

Tests made at 23°C	Value	Unit	Method
Color	Grey	-	IMIA-01
Density	1,50 ± 0,05	Kg/l	IMIA-02
Solid content	71 ± 2	%	IMIA-03
Viscosity (Brookfield RV, 20rpm)	4500 - 6500	cP	IMIA-10
Reactivity (100g product + 1,50g CT21/MEKP 50%)	25 ± 5	min	IMIA-15

TYPICAL CHARACTERISTICS OF THE CURED PRODUCT (*)

Tests made at 23°C	Value	Unit	Method
Superficial hardness	68 ± 5	Shore D	IMIA-29
Thermo-mechanical resistance: HDT	55 ± 5	°C	IMIA-50
Gloss	70 ± 5	GU	IMIA-40

(*) Curing cycle: 24 hours at 23°C and 3 hours at 80°C

The information and data contained in this technical sheet are based on the measurements and experience gained; in good faith, they are made available to the customer who is responsible for the application verification and the definition of suitability for the intended use.

INTEC assumes no responsibility for the results obtained in the specific application made by the user.

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INTEC s.r.l. a Socio Unico

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