TECHNICAL DATA SHEET

FV22 – POLISHING FINISHING VINYLESTER FILLER GREY

Grey polishing primer spray, based on vinylester resins, formulated for obtaining particularly bright and highly heat resistant surfaces with a finish.
Particularly appreciated in the composite sector for the spray finishing of pre-series milled models and molds.
Ideal for finishing all SLEM millable tooling pastes.
Excellent for vertical application, it allows for considerable thicknesses.
Thanks to the nature of the vinylester polymer, at the end of an adequate sanding and polishing cycle it achieves an excellent degree of gloss, maintaining its performance even when exposed to the heat of the pack lamination of the molds.
Where 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 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
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	70 ± 5	Shore D	IMIA-29
Thermo-mechanical resistance: HDT	65 ± 5	°C	IMIA-50
Gloss	80 ± 5	GU	IMIA-40
(*) Curing cycle: 24 hours at 23°C and 3 hours at 80°C			

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