



PRODUCT INFORMATION

AUTO REFINISH

A712 POLYESTER SPRAY FILLER

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

PRODUCT DESCRIPTION

A712 Polyester Spray Filler is a light grey two-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, A712 Polyester Spray Filler 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.

SUBSTRATES & PREPARATION



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



SUBSTRATE

PREPARATION

STEEL:

After degreasing with AA-6822 PROTEC® Heavy Duty Wax & Grease Remover, sand with STARTLINE® P80 - P120 grit and make completely rust free by conditioning with 971-9119 *Protec* Metal Conditioner.

FIBREGLASS:

After removing mould release agent using 978-9051 *Protec* Surface Cleaner No3 and degreasing with AA-6822, sand with *Startline* 240 - 320 dry grit.

AP-4110 *Protec* Epoxy Primer must be applied for maximum adhesion and corrosion resistance prior to application of Polyester Filler. Refer to technical data sheet for further information.

Do not apply A712 Polyester Spray Filler to acrylic lacquer finishes, freshly painted surfaces or acid etch primers.

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

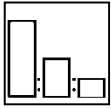
CLEANING

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover.

PRODUCT DESCRIPTION

Code	Product	Purpose
917-9119	<i>Protec</i> Metal Conditioner	A phosphoric acid based metal pre-treatment. It facilitates the removal of oil, grease and rust as well as chemically etching the metal surface to ensure optimum adhesion of primer coats.
AA-6822	<i>Protec</i> Heavy Duty Wax & Grease Remover	Suitable for removing wax, grease, tar or other contaminants before or during the painting process.
978-9051	<i>Protec</i> Surface Cleaner No3	Removes most water based contaminants prior to or while sanding. Allows water wash off.

MIXING RATIO



PRODUCT

A712
SHA307
A714

VOLUME

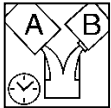
100 parts
2.5 parts
0 - 10 parts

WEIGHT

100 g
2 g
0 - 8 g

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.

POTLIFE



Catalysed material is useable for up to 1 hour at 20°C.

SPRAYGUN SETTINGS (*GRAVITY*)



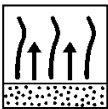
SETUP

2.0 - 2.5 mm

SPRAY PRESSURE

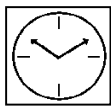
2.0 - 3.0 bar / 30 - 43.5 PSI

APPLICATION & FLASH OFF (*at 20°C*)



- NUMBER OF COATS: Up to 4 maximum.
- FLASH OFF BETWEEN COATS: 5 - 10 minutes.
- FLASH OFF BEFORE STOVING: 10 minutes.

DRYING TIME & TEMPERATURE



DUST FREE (at 20°C)

20 minutes

DRY TO SAND (at 20°C)

2 - 3 hours

DRY TO SAND (at 60°C)

30 minutes

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



I.R.:

Short wave:

10 minutes

Medium wave:

15 minutes

TOTAL DRY FILM BUILD (min - max) 150 - 300 µm (6 - 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.

OVERCOAT / RECOAT



SANDING (DRY):

Startline P120 - 180 (dry) followed by P240 - 320.

DO NOT WET SAND



Overcoat with any *Protec* 2K primer.

Please refer to 'Performance and limitations' section below.

PERFORMANCE AND LIMITATIONS

Do not apply A712 over etch primers.

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.

A712 is water-sensitive and must not be wet-sanded.

A712 must not be overcoated directly with topcoat finishes. Always apply a sealer coat of a suitable 2K Epoxy primer such as AP-4110, 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 any guarantee program.

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

For comprehensive Health, Safety and Environmental advice, please refer to relevant 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 or her 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.

**PPG Industries Australia Pty Ltd, 14 McNaughton Rd
Clayton, V.I.C. 3168 Australia**

EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254

**PPG Industries New Zealand Pty Ltd, 5 Vestey Dr, Mt Wellington
Auckland, New Zealand**

EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096

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