



Effective 28 September, 2006

799R

VOC SPRAY PUTTY

Description

A 2-component finishing spray putty with a peroxide hardener.
Composition based on modified polyester polymer.

Products

799R	VOC Spray Putty
791R	Hardener

Properties

- High film build.
- Very good adhesion to bare steel and substrates as listed.
- Easy application.
- Fine homogeneous structure.
- Smooth sanding.
- VOC compliant, conform with directive 2004/42/EC.

Substrates

- Bare steel or glass fibre polyester.
- OEM finishes*.
- DuPont Refinish undercoats*.

* Not recommended for use over 1K primers, wash primers, thermoplastic undercoats or thermoplastic topcoats.



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PRODUCT PREPARATION

	Mixing ratio	799R	Volume		Weight	
		791R	100	100	5	4
	VOC	250 g/l				
	Pot life at 20°C	20 min				
	Spray viscosity at 20°C	3000 cp				
	Spray equipment		Fluid tip	Distance	Pressure	
		Conventional guns				
		Gravity feed	2.0-2.5 mm	10-20 cm	2-3 bar	
		Suction feed	-	-	-	
		Pressure feed	-	-	-	
		Compliant guns (HVLV/HTE)				
Gravity feed	2.0-2.5 mm	10-15 cm	According to supplier's specifications			
Suction feed	-	-	-			
Pressure feed	-	-	-			
	Number of coats	1-5				
	Flash time	10 min				
	DFT	Up to 500 µ				
	Dry to sand at 20°C at 60°C	2 hr 30 min				
		30 min				
	IR drying*	Flash time	10 min	* Guideline for short/medium wave IR equipment.		
		Distance	80 cm			
		Half power	5 min			
		Full power	15-20 min			
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.						



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RECOMMENDED USE

Surface preparation

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface mechanical with P80.
4. Sand to featheredge, with P150 or P180.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.

Recoatability

At any time after dry to sand.

Remarks

- Aluminums, light alloys and zinc plated steel must be prepared with a DuPont Refinish epoxy primer (no wash primer allowed).
- Do not use 799R over unsanded substrates.
- Do not apply topcoat directly over 799R to avoid absorption.
- Material has to be at room temperature (18-25°C) before use.



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RECOMMENDED USE (con'd)

Product data

Directive 2004/42/EC: The EU limit value for this product (product category: IIB(b)) in ready to use form is maximum 250 g/l of VOC. The VOC content of this product in ready to use form is maximum 250 g/l.

Products	Packages (l)	Shelf life at 20°C (year)
799R	1	1
791R	50 cc	1

Safety

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.