



Effective 14 September, 2007

P702 / P704 / P706

HIGH SOLIDS FILLER

Description

2-component Low Emission surfacer with 2 methods of application:

- a. sanding surfacer;
- b. non-sanding surfacer.

Colour: off white, medium grey, dark grey.

Composition based on a special hydroxy functional acrylic.

Products

P702	High Solids Filler - off white
P704	High Solids Filler - medium grey
P706	High Solids Filler - dark grey
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow
NSC70	Non-sanding Convertor

Properties

- Very high solids - low VOC technology: better filling, same build with fewer coats, resulting in less consumption.
- Excellent in mechanical and wet sanding.
- Superior topcoat hold-out.
- Can be coated with all Imron® Fleet Line topcoats.
- VOC compliant, conform with directive 2004/42/EC.

Substrates

- OEM or cured repair finishes.
- E-coats.
- Sanded DuPont Refinish polyester putties.
- Imron® Fleet Line wash primers.
- Imron® Fleet Line epoxy primers.












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PRODUCT PREPARATION

 Mixing ratio (1)	P702/P704/P706 ET645 ET650 ET655 ET745 ET750 ET755 NSC70	Sanding surfacer						Non-sanding surfacer						
		Fast		Standard		Slow		Volume	Weight					
		Volume	Weight	Volume	Weight	Volume	Weight							
		7	100	7	100	7	100	4	100					
		1	10	-	-	-	-	-	-					
		-	-	1	10	-	-	-	-					
		-	-	-	-	1	10	1	18					
		0.5-1	4-8	-	-	-	-	-	-					
		-	-	0.5-1	4-8	-	-	-	-					
		-	-	-	-	0.5-1	4-8	-	-					
		-	-	-	-	-	-	3	45					
	VOC	486-507 g/l						540 g/l						
 Pot life at 20°C	ET645 ET650 ET655	1 hr - 1 hr 30 min		1 hr 30 min - 2 hr		3-4 hr		2-3 hr						
 Spray viscosity at 20°C	DIN 4 FORD 4	20-25 s 22-27 s		20-25 s 22-27 s		20-25 s 22-27 s		14-16 s 14-16 s						
 Spray equipment	Conventional guns	Fluid tip			Distance		Pressure		Fluid tip		Distance		Pressure	
	Gravity feed	1.4-1.8 mm			20-25 cm		3-4 bar		1.4-1.6 mm		20-25 cm		3-4 bar	
	Suction feed	1.6-2.0 mm			20-25 cm		3-4 bar		1.6-1.8 mm		20-25 cm		3-4 bar	
	Pressure feed	1.0-1.2 mm			20-25 cm		3-4 bar		1.0-1.2 mm		20-25 cm		3-4 bar	
	Compliant guns (HVLP/HTE)													
	Gravity feed	1.4-1.6 mm			15 cm		According to supplier's specifications		1.4-1.6 mm		15 cm		According to supplier's specifications	
	Suction feed	1.6-2.0 mm			15 cm				1.6-1.8 mm		15 cm			
	Pressure feed	1.0-1.2 mm			15 cm				1.0-1.2 mm		15 cm			
 Number of coats		1-3						1						
 Flash time		Between coats till flat. 10-15 min before bake.						1 hr (till 8 hr maximum) before recoating.						
 DFT		60-80 µm/coat						30-40 µm						
 Dry to sand at 20°C at 60°C		ET645		ET650		ET655		Not applicable.						
		3-4 hr 20 min		3-4 hr 20-30 min		4-6 hr 30-40 min								
 IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min				* Guideline for short/medium wave IR equipment.		Not applicable.						

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.

(1) The different activators and thinners can be intermixed to obtain the best possible system for the ambient temperature and the size of the surface to be painted.



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RECOMMENDED USE

Surface preparation

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara® wipes.
3. Sand surface:
 - a. before applying sanding surfacer: mechanical with P220 - P280, wet with P360 - P500;
 - b. before applying non-sanding surfacer: mechanical with P220 - P320, wet with P600.
4. Remove all traces of sanding dust, blowing with clean oil-free compressed air.
5. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.
5717S is not recommended if polyester putty is required.
- Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.
- Apply 1 coat of Imron® Fleet Line wash primer or Imron® Fleet Line epoxy primer.

Bare metals (steel, galvanised steel, aluminium or surface treated aluminum)

1. Clean surface with a DuPont Refinish preparatory cleaner for bare metals. Wipe dry with clean Sontara® wipes.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing with clean oil-free compressed air.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.
5. Apply 1 coat of Imron® Fleet Line wash primer or Imron® Fleet Line epoxy primer.

Application selection

Sanding surfacer

For spot, panel and overall repair.

Non-sanding surfacer

To reduce sanding work and increase output of spray booth.

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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RECOMMENDED USE (con'd)

Remarks

- Do not use activated P702/P704/P706 beyond the pot life nor reduce it further to get viscosity down again.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For flexible systems, see specific TDS.
- For ValueShade® concept, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

Product data

Package viscosity: 2500-3000 cp
 Theoretical coverage: 6.1-7 m²/l at recommended DFT - ready-to-spray
 Directive 2004/42/EC: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Products	Packages (l)	Shelf life at 20°C (year)
P702	4	2
P704	4	2
P706	4	2
ET645	1 - 5	2
ET650	5	2
ET655	5	2
ET745	5	2
ET750	1 - 5	2
ET755	5	2
NSC70	5	2

Safety

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



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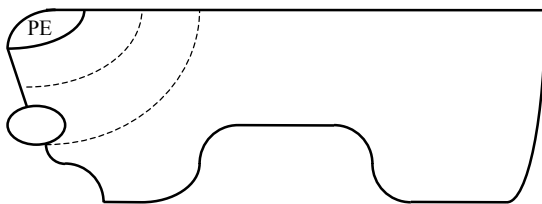
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REPAIR SYSTEMS

Preparation method for spot repair

P280 P320 P360



1. Sand through, end with P280.
2. Fill the spot with DuPont Refinish polyester putty and sand with P280.
3. Sand the surrounding area with P320 and finish on the OEM finish with P360.
4. Apply 1 coat of Imron[®] Fleet Line wash primer or Imron[®] Fleet Line epoxy primer over the polyester putty to isolate the substrate and flash till flat.
5. Apply 1st coat of surfacer over the entire prepared area. Flash till completely flat.
Apply 2nd coat of surfacer, staying inside the 1st coat area. Flash till flat.