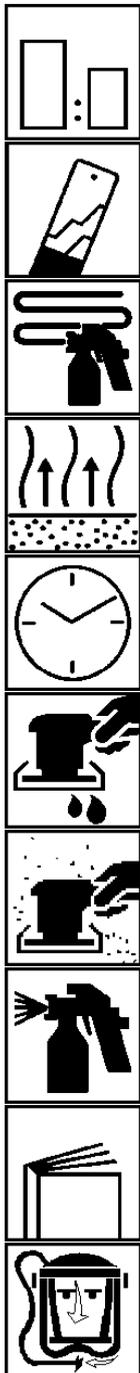


POLYSURFACER 8020



3:1
Polysurfacer 8020
Hardener 8020

4

(gravity feed)
1-3*1
2.0 mm
2-4 bar

5-10 mins.

4 hrs. 20°C.
30 mins. 60°C.

P280
P360-P400

P500-P600
P800-P1000

All Catina topcoats

2.4.6

Description:

High-build, quick-hardening two-pack primer-surfacer for car refinishing and new body work. This product provides an ideal substrate for all types of car refinishes. Universally applicable.

Product and Additives:

Polysurfacer 8020
Hardener 8020

Special additives:

3. 2 .1 Thinners
Flexi O Actif

Basic Raw Materials:

Polysurfacer 8020 : acrylic resin
Hardener 8020 : poly-isocyanate resin.

Suitable Substrates:

- Existing finishes, including thermoplastic acrylic finishes
- Primer Surfacer EP
- Polyester laminates
- Wood or plywood
- Bare steel surfaces.

Surface Preparation:

- Existing finishes: degrease and sand with P180-280 grit dry or with P280-P400 grit wet.
- Polyester laminates: Degrease and sand with P280 grit dry or scuff with Scotch Brite Red.
- Wood: Sand with P180 grit dry.
- Plywood: Degrease and sand with P180 grit dry.
- Bare steel surfaces: Degrease and abrade with P80-P180 grit dry.
- Metal substrates: In systems which should meet the highest standards (metal surfaces), Polysurfacer 8020 must always be applied over Washprimer . After application of Washprimer, allow for a flash-off time of 15 minutes at 20°C.

Tinting:

If necessary, Polysurfacer 8020 may be tinted with a maximum of 10 parts by volume of Catinacryl mixing colour (without hardener) for better opacity.

Mixing Ratio by Volume:

3 parts of Polysurfacer 8020.
1 part of Hardener 8020.

Polysurfacer 8020 can also be applied as a conventional surfacer by adding, for example, 10, 20 or 30 % 3.2.1 Thinner.

If a longer potlife is required (large objects) use Thinner 8020. Mixing ratio 3:1:1.

Potlife:

When mixed, 45 minutes at 20°C.
In combination with Thinner 8020 : 4 hours at 20°C.

Spray gun fluid tip and working pressure:

<i>Spray Gun:</i>	<i>Fluid Tip:</i>	<i>Working Pressure:</i>
Gravity feed:	2.0 mm	2-4 bar

1.5-1.8 mm can be used if 3.2.1 Thinner is added.

Suction feed:	1.8-2.2 mm	2-4 bar
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Application Process:

Spray one, two or three single wet coats, allowing for a flash-off time of 5-10 minutes between coats (depending on temperature and film thickness applied).

Film Thickness:

50-60µm for each coat.

Approx. 40µm for each coat if thinned with 30 parts by volume of 3.2.1 Thinner.

Cover rate:

Theoretical: 8 m²/l unthinned paint at 60µm.

Note: The practical cover rate depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of Equipment:

In Catina Solvent, nitrocellulose thinner or 3.2.1 Thinner.

Drying times:

	20°C	40°C	60°C
Dry to flat:	4 hrs	45 mins	30 mins.

If cured by long-wave infra-red rays:

Dry to flat:	27 mins.
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Recommended Sandpaper grades:

For mechanical and manual wet flatting:
Initial flatting with P500-P600-grit paper
Final flatting with P800-P1000-grit paper.

For mechanical dry flatting:
Initial flatting with P280-grit paper
Final flatting with P360-P400-grit paper.

For manual dry flatting:
Initial flatting with P280-grit paper
Final flatting with P360-P400-grit paper.

Recoatable with (Recoatability):

All Catina topcoats.

Packaging:

1 lt & 3 lt.

Colour:
Grey

HEALTH & SAFETY DATA concerning Polysurfacer 8020 and additives:

For professional use only.(See **Material Safety Data Sheet**).

See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.