

PORE FILLER PU 228 HB

FILLER
Two component

FLEXIBLE POLYURETHANE FILLER
Very high quality and important thinness film
FAST DRY TIME

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FEATURES

PORE FILLER PU 228 HB is a new generation of two component polyurthane filler with fast dry time.

- Good spreading rate.
- Easy and fast sanding.

This new generation of resins allows to apply directly on epoxy composite if the surfaces are free of moisture and pollution.

Lacquer TOPCOAT PU 320 will be applied directly after sanding with thin grit and a serious dust removal and 3 hours after PORE FILLER PU 228 HB application.

PORE FILLER PU 228 HB offers the possibility to be able to sand 2 hours after application (80 microns wet at 20 to 25°C and 50 to 55% HR).

PORE FILLER PU 228 HB is an ideal intercoat during the end of the finishing for above the waterline before lacquer.

PORE FILLER PU 228 HB ensure a saving of time during the surface preparations.

PORE FILLER PU 228 HB gives a film which has an important thinness and can be lacqued without sanding if it has been correctly diluuted.

RECOMMENDED USES

PORE FILLER PU 228 HB :

- Guarantees to obtain quickly an exceptionnal surface quality to apply TOPCOAT PU 320.
- contributes to the finishing aspect, gloss and depth of film for the lacquer TOPCOAT PU 320.
- must never be applied on metal if it has not received anticorrosive treatment
- never apply on immersed zones.
- Easy to apply with AIRLESS or spray gun, can also be applied with brush or roller for spot finishing.
- It can be tinted with black dye 934 for red or royal blue lacquer.

PORE FILLER PU 228 HB ensures excellent performances with manual or mechanical sanding, grit 200, 300, 400, depending on sanding method.

PORE FILLER PU 228 HB is compatible with systems GP 46, WI 120, EPU 123, EP 140, EP 211, EPU 221, EP 213 & 215 HB, can be recoated by EPU 221 and laquers PU 77, PU 99, and 320

SPECIFICATION DATA

COATING TYPE: Flexible polyurethane filler

COLOR : White or Grey – Tinted with black dye MP 934

ASPECT : Semi-gloss

PRESENTATION : Two component

COMPONENT RATIO

- Weight : 100 Base / 12 Hardener
- Volume : 5 Base / 1 Hardener

INDUCTION TIME (at 23°C) : app. 10 minutes

POT LIFE (at 23°C) : 1 hour 30

THINNER : PU N° 2

DENSITY AT 23°C : 1,56 +0,05g/cm³

VOLUME SOLIDS : 52 +/-3 %

VOC : 436,66 g/l

THEORETICAL SPREADING RATE :
6,5 Sq.m/L for 80 microns

RECOMMENDED FILM THICKNESS PER COAT:
Dry : 40 to 80 microns
Wet : 85 to 170 microns

DRY TIME :
(at 23°C - 50 % HR for 100 dry microns) :
Dustfree: 30 minutes
To handle: 45 minutes
To sand : 3 hours

DRY TIME TO RECOAT :
(at 23°C - 40 to 60 % HR for 50 to 100 dry microns) :
Minimum : 3 hours
Maximum : 24 hours

MAXIMUM TEMPERATURE RESISTANCE : 120°C

SURFACE PREPARATION

All surfaces must be free of grease, dust, water marks, moisture and other foreign matter and be properly primed with a compatible epoxy primer. To insure the best appearance, the primer or undercoat should be smooth and free of any surface defects such as runs, dry spray or heavy orange peel.

PORE FILLER PU 228 HB can be applied directly on epoxy composites, if the surface has been sanded with thin grit. For some gelcoat band, depending on the quality, the bonding intercoat can be necessary. Use the systems EP 211, UNDERCOAT EP 213, 215 HB (contact our technical department).

PORE FILLER PU 228 HB must never be applied directly on the aluminium, on metal surfaces or under the waterline.

PORE FILLER PU 228 HB can also be applied on primers AEROPRIM EPU 123, EP 140, EP 211, GP 46, WI 120, and is compatible with l'INTERFACE EPU 221 and can be recoated by PU 77, PU 99, 320 S

It's possible to used COLORANT NOIR 934 (black pigment) to obtain differents colors between coats or to obtain the good base color reference : light grey for topcoat yellow, meduim grey for topcoat red, and dark grey for topcoat dark blue

MIXING AND THINNING

Before mixing the components, mix carefully the base portion first to obtain a smooth, homogeneous condition during 10 minutes. After mixing the base portion, add the hardener slowly with continued agitation. After adding the hardener, continue to mix slowly.

After 10 minutes of induction time, it's possible to diluate until 20 % of PU N°2 in volume (depends on application conditions or method).

You must check the viscosity with cup DIN or AFNOR.

Spray gun application : check the viscosity every 2 hours. Don't forget to mix after every dilution.

APPLICATIONS

APPLICATION METHOD		THINNER	TIP SIZES	PRESSURE
BRUSH	YES (spot finishing)	0%	1,4 to 2	3 to 4 BARS
ROLLER	YES (spot finishing)	0%		
SPRAY GUN	YES	0 to 20%	0,015 to 0,021 mm (30 to 60°)	100 to 200 BARS
AIRLESS SPRAY	YES	0 to 5%		

CONDITIONS FOR APPLICATION :

Optimum : 18 to 25 °C for 40 to 70 % HR

Limit : 15 to 35°C for 30 to 75 % HR

The substrate temperature must be at least 3°C above the dew point to avoid any condensation - consult the conversion table available at Map Yachting.

VISCOSITY : 18 s to 22 s Cup AFNOR n°4

PRECAUTIONS AND SHELF LIFE

See the material safety data sheet and product label for complete safety and precaution requirements

PACKAGING : KIT 1,2 or 2,4 or 6 Liters

CLASS ONU : 1263

SHELF LIFE : 12 months in original unopened cans at + 10 and + 25 °C away from humidity - 9 months in tropical climate

FLASH POINT : Base and Hardener : between 23°C and 55°C

LABEL : Base = F : Flammable Hardener = Xn : Harmful



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