

PORE FILLER PU 228 HB

Technical sheet no. 21

Editing September 2022

TYPE OF PRODUCT :

POLYURETHANE FEXIBLE UNDERCOAT

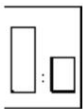
PROPERTIES :



Information
Products

PORE FILLER PU 228 HB is a new-generation, two-component, fast-drying polyurethane primer with high covering power and very easy and fast sanding. The new generation resins, used for its formulation, allow an implementation directly on the epoxy composite, correctly prepared, and devoid of any trace of pollution, avoiding an epoxy undercoat. The implementation of finishing lacquers can be done immediately after very fine grain sanding and careful dusting. The PORE FILLER PU 228 HB undercoat offers the possibility of being able to sand 8 hours after the implementation of approximately 80µm wet at a temperature of 20 to 25°C and 50/55% RH make it the ideal interface, at the end cycle of painting the dead works, or non-submerged parts, before the implementation of lacquers and finishes. Thanks to its qualities, it ensures considerable time savings in the preparation of surfaces to be lacquered. The PORE FILLER PU 228 HB primer offers a very fine film.

COMPONENTS:



Hardeners

Thinners

Pore Filler PU 228

PU n°2 and PU n°4 thinners

DILUTIONS:

- BRUSHES AND ROLLS from 3% to 10% •
- PNEUMATIC GUN from 5% to 20%

SPECIFICATIONS :



Standards and
Qualifications

MAP YACHTING *Paint Systems* SPEC

For the latest missing updates, please check with us at sales@map-yachting.com

The information contained in this edition is based on our current knowledge and experience. Given the many factors that can affect the transformation and application of our products, this information does not in any way release any user from his obligations to carry out his own checks and tests. Nor do they constitute a guarantee of certain characteristics of the products or of their adaptation to a specific need. Any description, photo, data etc. Is mentioned for information only. The most recent version cancels and replaces all previous versions. The most recent document is available on our website www.map-yachting.com, or directly from your distributor. The recipient of our products is required to ensure that all industrial property rights and all laws and regulations in force are respected.

Surface Preparation



All surfaces to be covered must be free of dirt, pollution due to grease, water vapour, (refer to the dew point table) dust or mould. In order to ensure a perfect finish, and to obtain an excellent quality of surface tension, the interfaces or undercoats must be perfectly smooth, and free of drips or orange peel and sanded with very high quality abrasives to the FEPA standard.

The PORE FILLER PU228HB and PU225HB systems make it possible to obtain a perfect surface, after sanding, devoid of porosity, an essential condition for obtaining a perfect finish as well as excellent gloss retention over time.

PORE FILLER PU228HB can also be used on primers, EP 211, IM409, GREENFIL80, MIXFILL 100, SPRAYABLE FILLER 500, AEROFILLER 525.01, systems EP 215 HB, EP 215 HB+, EPU 221, it accepts finishes, PU 77, PU 99, BASECOAT F16 and TOPCOAT PU320-PU380.

Manual



Mixing ratio

Volume (ml): 5 Base / 1 Hardener

Weight (gr): 100 (gr) Base / 12 (gr) Hardener

Allow products to acclimate to ambient site temperature before use. Base should be mixed thoroughly for at least 5 minutes using a clean disperser mounted on an explosion-proof stirrer. Then add the part of hardener by pouring it slowly and continuing to mix until a liquid with a smooth and homogeneous unctuous appearance is obtained. Since the two components are of different viscosity, the edges of the mixing container should be carefully scraped with a spatula. Mixing containers should have flat bottoms and perfectly smooth edges.



Duration dying

10 minutes at 20°C



Viscosity initial of application (at 23°C)

18s to 22s AFNOR Cup n°4



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Shelf life of the mixture at 20°C

1 Hours 30 mins



Remark

Dry film weight for a thickness of 100µm: 240g/m²



Dry film thickness

80 – 160µm

Applications & Recommendations



Conditions

Hardeners : Pore Filler PU228 HB

Place: 15°C– 25°C

Hygrometry : 30 - 65%



Note

The quality of application of all coatings will be influenced by the spray equipment chosen and by the temperature, humidity and airflow of the paint application area. When first applying the product, it is recommended that test panels be prepared to identify the best equipment settings to use to optimize the performance and appearance of the coating. PORE FILLER PU228HB can be applied under conditions outside the limits indicated. Care should be taken to ensure a satisfactory result. Please contact your MAP YACHTING Paint Systems technician to determine proper application techniques and choice of thinners when environmental conditions are outside the recommended range.



Remark

The quality of the coating may be degraded by humidity during its crosslinking phase.

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Materiel

Pressure pot
 Pistol : AZ1/ IWATA WS200SP / WS200FT / W200G2P
 Nozzle + Needle: 1.4mm to 1.8mm
 Paint flow: 170 - 280 ml/min
 Air cap: G2P / WS-200SP-01 / WS-200FT-01 / WS-200FT-02
 Gun pressure: 2.5 – 3.0 Bars
 Pressure Product: 1 Bar
 Gravity gun
 Pistol : AZ3 /IWATA WS400 / W400 / W400WB / W400 BELLARIA
 Nozzle + Needle: 1.5 mm to 1.8mm
 Paint flow: 140 - 250 ml/min
 Air cap: LV2 / BA4-1 / WB1 / WBX
 Gun pressure: 1.8 – 2.5 Bars

Airless
 Nozzle : 0,013 - 0,017 mm
 Pressure : 100 - 200 Bars

Electrostatic
 Nozzle : 1.4 – 1.8 mm
 Pressure : 3.5 - 5 Bars



Name of lying down




Apply in 2 coats a wet film from 80µm to 100µm. The layers must be closed and homogeneous.



Cleaning the material

Do the first cleaning with cleaning thinner (noble solvent without water and not recycled) and finish cleaning with the application solvent of the MAP YACHTING Paint Systems system.

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Physical properties		USE LIMIT TEMPERATURE :	+120 °C
	Time to Drying (at 23°C – 40 to 60% RH)	Dust free: 30 minutes Dry to touch: 1 hour Sandable: 8 hours	
	Recovery (at 23°C – 40 to 60% RH)	Without Sanding by itself (for 80µm dry): Minimum: 3 hours Maximum: 24 hours	
	YIELD THEORETICALLY	6.5 m ² /l for 80µm dry (without loss)	
	Dry extract in Volume you Mixed	52 +/- 3%	
	Density of Mix at 20°C	1,56 +/-0,05%	
	Compounds organic Volatiles	Base: 410.00 g/l Hardener: 570.00 g/l	

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ASPECT
(at 60°)

Satin



Colors

White



Flash point

Base and Hardener: 23°C ≤ PE ≤ 55°C



Storage

Store the product in a dry place and at a temperature between + 10°C and + 25°C according to the specifications of MAP YACHTING Paint Systems. Store in original unopened containers. Storage temperature may vary depending on OEM specification requirements. Refer to container label for specific information on storage time.

Lifetime
+10°C to 25°C

The information is given for closed containers in the original packaging, i.e. 24 months according to the commercial specifications of MAP YACHTING Paint Systems for the base of PORE FILLER PU 228 HB and 24 months for the hardener. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Safety instructions

Comply with all local safety, disposal and transportation regulations. Carefully check the Safety Data Sheet (SDS) and label of each product before using it.

Safety Data Sheets are available on request.

Publication date: September 2022 - ONLY FOR PROFESSIONAL USE -

Exhaustive and is based on the current state of our knowledge and on the laws in force: anyone using the product for purposes other than those specifically recommended in the data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended use does so at its own risk. It is always the responsibility of the user to take all necessary measures to meet the requirements set by local rules and legislation. Always read the Material Data Sheet and Technical Data Sheet for that product, if available. All advice we give or statements we make about the product (whether in this data sheet or elsewhere) are correct to the best of our knowledge, but we have no control over the quality or condition of the substrate or on the many factors affecting the use and application of the product. Therefore, unless we agree otherwise in writing, we accept no liability whatsoever for the performance of the product or for any loss or damage arising from the use of the product. All products supplied and technical advice given are subject to our terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to change from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check that this data sheet is up to date before using the product. **Brand names mentioned in this data sheet are registered trademarks or licensed to:**