



Product Group

Composite coatings / primer surfacers

Characteristics



Product
Information

Pyroflex[®] Filler 0651 is a 3-component isocyanate cured polyurethane filler designed to fill and smoothen the composite surface irregularities before application of the finish.

Components



Hardener Thinner
or
Activator

Hardener 0651
Thinner 0651

Surface Conditions



Cleaning

- Pyroflex[®] Filler 0651 can be applied directly on composite substrate or primer.
- Remove release agents from the substrate very carefully.
- Sand composite panels to a uniform matt surface and blow panels dust free with pressured air.
- Degrease surface with the wipe-on-wipe-off method using a non-substrate aggressive cleaner.
- When using forced cure schedule with composites, it is recommended to degas the substrate prior to application of the primer.
- Clean aged primer and sand with Scotch-Brite[®] type A very fine to a uniform matt surface.
- Remove dust with e.g. tack rags just prior to application.

Instruction for Use



Mixing Ratio
(volume)

5 parts Pyroflex[®] Filler 0651
1 part Hardener 0651

Reduce to spraying viscosity with:

1 – 1,5 parts Thinner 0651

- Allow the products to acclimatize to room temperature before use
- Stir or shake the Pyroflex[®] Filler 0651 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 0651 and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.



Induction Time

60 minutes



Initial Spraying
Viscosity
(21°C/70°F)

20 – 35 seconds ISO Cup #4
11 – 17 seconds Gardner Signature Zahn Cup #2



Note

Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.



Pot Life
(21°C/70°F)

8 hours



Dry Film
Thickness
(DFT)

100 µm
4 mils

**Application
Recommendations**



Conditions

Temperature: 15 – 35°C
59 – 95°F
Relative Humidity: 35 – 75%



Note

Pyroflex[®] Filler 0651 may be applied in conditions outside of the the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside the recommended range.



Equipment

Air 1.4 mm nozzle orifice
HVLP 1.4 mm nozzle orifice
Airless / Air assist 6.11 – 6.13 (.011 - .013 inch) angle 60°



Number of Coats

Apply 2 to 3 cross coats with 5 minutes flash off time in between.



Cleaning of
Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068.



Note

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.



Physical Properties



Drying Times

Dust free	1 hour
Dry to touch	4 hours
Dry to sand	24 hours

Recoat minimum	12 hours
Recoat maximum	72 hours.

If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite[®] type A very fine.



Theoretical Coverage

6,4 m² per liter base material at 100 µm dry film thickness
257 ft² per US gallon base material at 4 mil dry film thickness



Dry film weight

2,35 g/m²/µm
0.0122 lbs/ft²/mil



Gloss (60°)

Maximum 10 GU



Color

White



Flash-point

Pyroflex Filler 0651	<21°C / 70°F
Hardener 0651	<21°C / 70°F
Thinner 0651	<21°C / 70°F



Storage

Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F. Stored in the original unopened containers.

Pyroflex Filler 0651	24 months
Hardener 0651	12 months
Thinner 0651	36 months

Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDS's are available on request.

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard 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 modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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