Pyroflex® Filler 0651

AkzoNobel
Tomorrow's Answers Today

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

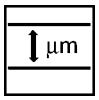
60 minutes

Initial Spraying Viscosity (21ºC/70ºF)

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

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905, Fax (31) 71 308 2056

Internet: www.akzonobel.com/aerospace

	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 (21ºC/70ºF)	8 hours
	Dry Film Thickness (DFT)	100 µm 4 mils

Application Recommendations

	Conditions	Temperature: 15 – 35ºC 59 – 95ºF Relative Humidity: 35 – 75%
	Note	Pyroflex® Filler 0651 may be applied in conditions outside of the the limits shown above.Care must be excercised 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 60º
	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.

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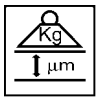
Physical Properties

Drying Times

Dust free	1 hour
Dry to touch	4 hours
Dry to sand	24 hours
Recoatable minimum	12 hours
Recoatable 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 m^2 per liter base material at 100 µm dry film thickness
257 ft^2 per US gallon base material at 4 mil dry film thickness



Dry film weight

2,35 $g/m^2/\mu m$
0.0122 $lbs/ft^2/mil$

Gloss (60º)

Maximum 10 GU

Color

White

Flash-point

Pyroflex Filler 0651	<21ºC / 70ºF
Hardener 0651	<21ºC / 70ºF
Thinner 0651	<21ºC / 70ºF

Storage

Store the product dry and at a temperature between 5 and 25ºC / 41 and 77ºF. 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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