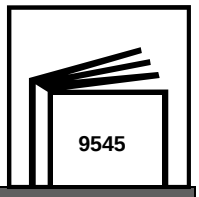
Standox® PF Filler

Ordering Information:		
3.5 Liter	PF Filler - White	020 16220
3.5 Liter	PF Filler – Dark Gray	020 16221



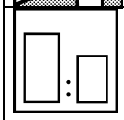
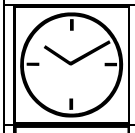
Features:

- ✧ **Exceptionally fast, air-dry qualities and excellent sanding properties**
- ✧ **Outstanding vertical hold out**

Working Process: Sanding Filler / Isolator

Substrates:

- ✓ Through-hardened, sanded paintwork
- ✓ Properly prepared unsanded e-coat
- ✓ **Standox** Polyester substrates, sanded
- ✓ GRP, sanded
- ✓ **Standox** Etching Adhesion Primer
- ✓ **Standox** 2K EP Primer Surfacer/ 2K EP Primer Aerosol

	For substrate preparation information see **Standox** Painting System S1!
	5:1 with **Standox** PFH Hardeners **(See Mixing Table)** potlife 90 min/68°F (20°C) **For U. S. National Rule; Standox** PF Filler can be mixed with **Standox** 2K Hardeners 4:1
	10-20% **Standox** PF Thinner or a PF Reaction Agent **(See Mixing Table)** 20-24 s/DIN 4 mm/68°F (20°C) **For U. S. National Rule; Standox** PF Filler can be mixed with **Standox** 2K Thinner 5-10%
	1.7 - 1.8 mm 2-4 coats = 4.0-6.0 mil Flash 5-10 min between coats Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
	1.7 - 1.8 mm 2-4 coats = 4.0-6.0 mil Flash 5-10 min between coats
	Air dry for 2 - 2.5 hours/ 68°F (20°C).or 30 in 130°F (55°C) panel temperature
	Short wave 10-12 min Medium wave 14-16 min (see Painting System S9)
	Orbital sand P600 Wet sand P600
	**Standocryl** 2K VOC Compliant Topcoats

Standox® PF Filler

Important Technical Remarks:

Mixing Table						
	PF Filler – White (Pint – Cumulative)			PF Filler – Dark Gray (Pint – Cumulative)		
	10%	15%	20%	10%	15%	20%
PF Filler	597.0	571.5	547.5	563.0	538.5	516.0
PFH Hardeners	681.5	652.5	625.0	647.5	619.5	593.5
PF Thinner	739.0	735.0	730.5	705.0	702.0	699.0
PF Filler	597.0	571.5	547.5	563.0	538.5	516.0
PFH Hardeners	681.5	652.5	625.0	647.5	619.5	593.5
PF Reaction Agent (16224)	735.5	730.0	723.5	701.5	697.0	692.0
PF Filler	597.0	571.5	547.5	563.0	538.5	516.0
PFH Hardeners	681.5	652.5	625.0	647.5	619.5	593.5
PF Reaction Agent Slow (16225)	731.5	724.0	716.5	697.5	691.0	685.0

- For areas outside of the 2.1 lbs/gal limit, **Standox** PF Filler can be mixed with **Standox** 2K Hardeners and 2K Thinners. 4:1+5-10% 20-24s/DIN 4mm. The addition of 2K Thinners and 2K Plasticiser will slow the flash off times in warm weather conditions and on large areas.

Repairing Plastic Parts			
PF Filler	2K Plasticizer	PFH Hardeners	PF Thinners
5 parts (Regulated)	+15%	:1	+10-20%
4 parts (US National Rule)	+15%	:1	+5-10%

- **Standox** 2K Fast Dry Additive (16169) can be used with this product. PF Filler can be mixed with **Standox** 2K Hardeners and **Standox** 2K Fast Dry Additive (16169). 4:1+10% 20-24s/DIN 4mm. Air dry for 60 min/ (20°C) 68°F.
- To achieve the existing **Standox** 2.1 Filler color, **Standox** PF Filler White may be mixed 4:1 with **Standox** PF Filler Dark Gray. **Standox** PF Filler White and Dark Gray may also be mixed at various ratios to achieve custom color matches.
- Do not use **Standox** 2.1 Hardeners or **Standox** 2.1 Thinners in this product. For areas with 2.1 lbs/gal limit, must use PF components only.
- Use a **Standox** Etch Primer on all bare metal for Warranty compliance and adhesion.
- For areas with Specialty Coating % limitations, **Standox** PF Filler can be used for plastic refinishing. Raw plastic must be pre-primed with **Standoflex**® 1K Plastic Primer (12065). This filler should not be used on polycarbonate.
- Standox PF Filler can also be used for plastic refinishing in regulated markets. Raw plastic must be pre-primed with either Standoflex 1K Plastic Primer Aerosol (14408) or Standoflex 1K Plastic Primer (16227). This filler should not be used on polycarbonate.

Important Legislative Remarks:

- Please see the appropriate VOC Wallchart for compliance in your area. The values depicted below are “ready to spray”.

VOC Category	VOC Regulatory & Actual	Wt% Volatiles, Water & Exempts	Gallon Weight
Primer (US National Rule)	282/412 g/l	48.8%, 0.002%, 28.9%	11.8 lbs/gal
Elastomeric Primer (US National Rule)	290/399 g/l	47.8%, 0.002%. 25.9%	11.42 lbs/gal
Primer (Regulated)	126/228 g/l	48.3%, 0.001%, 39.8%	12.4 lbs/gal
Elastomeric Primer (Regulated)	133/231 g/l	47.8%, 0.001%, 38.5%	12.5 lbs/gal

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product’s suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.