



BD7423M DURELASTIC-Spray Filler

Product description

Stability	very good
Grindability	good
Substrate	PS (polystyrene), GRP (glassfibre reinforced plastic), ABS (acrylonitrile butadiene styrene), Non-ferrous metals, Aluminium, Wood

General product properties

Binder-Base	Unsaturated polyester resin based on orthophthalic acid
Colour	Solid colours
Viscosity	Flow time 20 - 33 sec. 6 mm flow cup DIN 53211
Density	ca. 1,6 g/ml theoretical
Solid mass	65 % after addition of hardener theoretical
Resistance to storage	<p>approx. 6 month in original packagings at an ambient temperature of 5 to 25 °C. Open packages are to be used within a short time.</p> <p>The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.</p> <p>As the time in storage increases, the gelling and curing times can change. The original gelling time can be adjusted by adding accelerators (e.g. BD7550).</p>

Application and processing

Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. An adhesive primer may be required.
Note before use	Prior to use, stir slowly and well without letting air in or mix components homogeneously.
Mixin ratio	10 kg BD7423M : 1 kg HD0613
Thinning	EFD dilution 400900
Processing conditions	During processing, a room, material and mould temperature of [Variable] °C must be guaranteed in order to prevent hardening problems and cracking.
Processing time	<p>Max. 30 - 35 min. / 20 °C</p> <p>The processing time can decrease at higher temperatures/humidities and/or under pressure.</p>
High pressure spraying	<p>as delivered viscosity after adding curing agent</p> <p>nozzle 1,8 - 2,5 mm</p> <p>spray pressure 3 - 5 bar</p>
Material usage	<p>without application loss 300 - 1000 g/m² theoretical</p> <p>layer thickness 150 - 600 µm</p>



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Oven drying	80 min. / 40 °C - 0 min. / 0 °C (object temperature)	
Air drying	>16 °C, 50 % relative humidity	
Dust drying	after 30 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 90 minutes (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 8 hours (pendulum damping)	DIN EN ISO 1522
Cleaning of equipment	with EFD cleaning agent 400312 within the processing time.	

Further processing of coated pieces

Repainting	possible after grinding. Clean the grinded surface removing adhesion-impairing materials afterwards.
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Comments

Work-and Healthprotection	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.
Test conditions	<p>All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information.</p> <p>The information provided here contains reference values and does not constitute a specification.</p>