



Effective 16 November , 2009

P721 / P727

NON-SANDING SURFACER

Description

2-component chromate-free Low Emission non-sanding surfacer.
Colour: white, black
Composition based on a special hydroxy functional acrylic.

Products

P721	Non-Sanding Surfacers - White
P727	Non-Sanding Surfacers - Black
ET645	Activator HS Fast
ET650	Activator HS
ET655	Activator HS Slow
ET745	Thinner Fast
ET750	Thinner
ET755	Thinner Slow
3989S	Retarder

Properties

- Specially developed for economical wet-on-wet application
- Superior topcoat hold-out.
- No convertor is needed for non-sanding application
- Part of ValueShade[®] concept.
- Can be tinted with PT PowerTints[®] (up to max.10 % by weight).
- Can be coated with all Imron[®] Fleet Line topcoats and DuPont Refinish solventbased basecoats
- VOC compliant, conform with directive 2004/42/EC.

Substrates

- OEM or cured repair finishes.
- E-coats.
- Sanded DuPont Refinish polyester putties.
- Imron[®] Fleet Line wash primers.
- Imron[®] Fleet Line epoxy primers.









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PRODUCT PREPARATION

 Mixing ratio (1)		Fast		Standard		Slow	
		Volume	Weight	Volume	Weight	Volume	Weight
	P721/P727 (2)	4	100	4	100	4	100
	ET645	1	20	-	-	-	-
	ET650	-	-	1	20	-	-
	ET655	-	-	-	-	1	20
	ET745	1.75	27	-	-	-	-
	ET750	-	-	1.75	29	-	-
	ET755/3989S	-	-	-	-	1.50	26
VOC	540 g/l						
 Pot life at 20°C	ET645 ET650 ET655	1 hr 30 min 2 hr 30 min 3 hr					
 Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	17-19 s 17-20 s 19-22 s					
 Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip		Distance		Pressure	
		1.4-1.6 mm		20-25 cm		3-4 bar	
		1.6-1.8 mm		20-25 cm		3-4 bar	
	1.0-1.2 mm		20-25 cm		3-4 bar		
	Compliant guns (HVLPHTE) Gravity feed Suction feed Pressure feed	1.4-1.6 mm		15 cm		According to supplier's specifications	
		1.6-1.8 mm		15 cm			
1.0-1.2 mm		15 cm					
 Number of coats		1					
 Flash time		30-35 min (till 8 hr maximum) before recoating.					
DFT		25-35 µ					
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.							

(1) The different activators and thinners can be intermixed to obtain the best possible system for the ambient temperature and the size of the surface to be painted.

(2) For ValueShade® concept, see remarks



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RECOMMENDED USE

Surface preparation

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
 - a. before applying sanding surfacer: mechanical with P220 - P280, wet with P360 - P500;
 - b. before applying non-sanding surfacer: mechanical with P220 - P320, wet with P600.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.

If sand through areas occur, treat bare metal spots as described below.

- Apply 5717S, rinse with plenty of water and dry.
5717S is not recommended if polyester putty is required.
- Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
- Apply 1 coat of Imron[®] Fleet Line wash primer or Imron[®] Fleet Line epoxy primer.

Bare metals (steel, galvanised steel, aluminium or surface treated aluminum)

1. Clean surface with a DuPont Refinish preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.
5. Apply 1 coat of Imron[®] Fleet Line wash primer or Imron[®] Fleet Line epoxy primer.

Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



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RECOMMENDED USE (con'd)

Remarks

- Do not use activated P721/P727 beyond the pot life nor reduce it further to get viscosity down again.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.



**Mixing ratio
for P721 / P727**

VS1: P721 / P727	100 / 0
VS2: P721 / P727	94 / 6
VS3: P721 / P727	86 / 14
VS4: P721 / P727	67 / 33
VS5: P721 / P727	40 / 60
VS6: P721 / P727	25 / 75
VS7: P721 / P727	13 / 87

- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

Product data

Package viscosity: 2500-3000 cp
 Theoretical coverage: 16.6 m²/l at recommended DFT - ready-to-spray
 Directive 2004/42/EC: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
P721	3.5	2	1.350
P727	3.5	2	1.340
ET645	1 - 5	3	1.062
ET650	5	3	1.076
ET655	5	3	1.081
ET745	5	4	0.823
ET750	1 - 5	4	0.905
ET755	5	4	0.918
3989S	1	4	0.935

Safety

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.