Technical Data Sheet

PUR300

2K Waterbased Filler

Description

PUR300 is a 2-component waterbased polyurethane filler developed for application on trains, machines and commercial vehicles.
Composition based on acrylic resin.

Products

PUR300	2K WB Sanding Filler
PUR350	Activator PUR300
PUR355	Activator Low VOC PUR300
HT204	Imron® HyrdoTopcoat Activator High Temperature
HT300	Imron® HydroTopCoat Reducer

Colours

PUR300	RAL 7035	Grey
PUR300W	RAL 9016	White

Properties

- Good sandability and optimal appearance.
- Can be applied as filler or high-build filler depending on the amount of thinner added.
- Can be applied as non-sanding filler at DFT 40 µm or as high-build sanding filler at DFT 80-120 µm

Substrates

- Epoxy: waterbased and solventbased
- Full cured 2K finish
- E-coat
- GRP Plastics (see section ‘Remarks’)

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Surface preparation

- OEM and old finish: sand and degrease.
- Primer / Filler: according their specifications.
- Degrease before recoating.

Solvent Content – ready for use (RFU) at maximum dilution using PUR355 activator

- PUR300 Grey 81 g/l

Product preparation

Mixing Ratio		Weight	Volume
	PUR300	100	5
	PUR350	15	1
	PUR355	12	1
	HT204	15	1
	Stir well with powered mixer.		
Thinner	HT300		
Pot life at 20°C	3 hours		
Recommended dry film thickness	40 – 60 µ		

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Application

	Application viscosity DIN 4 at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
 **Gravity feed**  **Suction feed** (High pressure spraying)	30-35*	12 - 15	1.4-1.8	3-4	2
HVLP **HVLP** (Low pressure spraying)	30-35*	12 - 15	1.4-1.6	0.7	2
 **Pressure pot Feed pump** (high pressure spraying)	30-35*	12 - 15	1.2-1.4	3	2
 **Airless** **Airmix**	50-60	10	Airless 0.33 Airmix 0.28 0.33	170-200 3-4 air Min 120 (material)	2
 **Electrostatic**	According to the advice of the Axalta Technical Representative.				
*** Remark**	**When used as non-sanding filler, further dilute to ca. 25 s DIN4 After first coat is applied allow at least 30 minutes flash before second coat is applied ensuring all water has evaporated**				

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Drying

Air drying at 20°C	
Sanding	Overnight

Forced drying	Flash time: 30 minutes.
Drying time	30 - 60 minutes
Drying temperature	60 – 80°C object temperature

Recoatability

Recoatable	With Axalta solventbased and waterbased topcoats

Product data

Package viscosity	Thyxotropic
Flash point	> 85°C

	Solids	**Density**	**Theoretical coverage**		**Theoretical materialconsumption**	
	Weight (%)	(kg/l)	(at 40 µ)		(at 40 µ)	
RFU at max. dilution	+/- 1	+/- 0.01	m^2/l	m^2/kg	ml/m^2	g/m^2
PUR300	58	1.33	10.7	8	94	125

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Remarks

	• Stir filler thoroughly before use for 3 to 4 minutes. • Before adding HT300 for viscosity correction, the activator has to be accurately mixed-in into the paint with a mechanical mixer for 3 to 4 minutes. • Preferably, a blade of 1/3 the size of the container is used. • Avoid air entrapment while stirring.
	• Before application the substrates need to be cleaned with a waterbased silicon remover.
Remarks	• The spray equipment has to be from stainless steel. All stirring rods / containers in use have to be from stainless steel or plastic. • Material is frost-sensitive. • Material has to be stored at a temperature between 5°C and 35°C. • Material has to be at room temperature (18-25°C) before use. • Close can of activator tightly immediately after use, as these products will react with humid air and water and lose their hardening effect. • Activated material should not be returned to original can of non-activated material. • Due to the variety of plastics and application methods, tests must be carried out before mass production can be started in order to check properties. • If HT204 activator has been used at temperature below 25°C, baking at 60°C is strongly recommended.

	Shelf Life (5-35°C) (months)	**Density** (kg/l) +/- 0.01	**Theoretical VOC** (g/l)
PUR300	24	1.43	56
PUR350	36	1.10	274
PUR355			
HT204	36	1.08	454
HT300	60	1.00	0

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Safety

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

Information

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.
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