

## PRODUCT DESCRIPTION

# TWO COMPONENT WATER-BORNE SPRAY FILLER

COPON HYCOTE SPRAY FILLER has been specifically developed for use as a high build spray filler coat for use in conjunction with Copon water-borne coating systems used predominately within the Rail Industry.

COPON HYCOTE SPRAY FILLER has been formulated to offer a highly effective, fast drying spray filler with excellent sanding properties.

**Standard Colour Availability** Manufactured only in a buff colour.

## GENERAL PROPERTIES

<b>Adhesion</b>	Excellent to correctly prepared surfaces.
<b>Sanding</b>	Excellent sanding properties producing a smooth surface ready for subsequent overcoating.

## PHYSICAL CONSTANTS

<b>Total Solids Content (Average) by Volume</b>	50%
<b>V.O.C. (As Supplied)</b>	28 gms/litre
<b>Specific Gravity (Average Mixed)</b>	1.55
<b>Film Thickness (Typical)</b>	Wet 200 microns Dry 100 microns
<b>Theoretical Coverage Rate</b>	3.2 sq metres per kilo at 100 microns dft

## SURFACE PREPARATION

<b>Method</b>	Surfaces will have first been primed with COPON HYCOTE EA9WB PRIMER. Surfaces should be clean, dry and free from contamination.
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## MIXING

<b>Number of Components</b>	Supplied in two parts: Base component and Activator component.
<b>Mixing Ratio (by volume)</b>	6 parts Base component. 1 part Activator component.
<b>Pot (Usable) Life</b>	Approximately 30 minutes at 20°C.
<b>Method of Mixing</b>	Stir the contents of the base component. Continue stirring whilst gradually adding the total contents of the activator container. Continue stirring until a homogeneous mix is obtained.
<b>Note</b>	When mixing the product, the use of a slow or variable speed mechanical mixer is beneficial in terms of ensuring and complete mixing.

## APPLICATION

<b>Conditions for Application</b>	Do not apply when relative humidity exceeds 80% or when the surface to be coated is less than 3°C above the dew point. For optimum results a minimum material and substrate temperature of 15°C is necessary.
<b>Method</b>	COPON HYCOTE SPRAY FILLER is supplied ready for application by airless spray. For application by air assisted airless and air spray equipment, the mixed product may be thinned with up to 5% by volume with clean water. This water addition should be kept to a minimum to promote a high build application.  Material should be applied in multiple passes to provide a wet film thickness of 150 to 250 microns. Once adequately dried a further coat may be applied to build up a smooth level surface.

### Typical Spray Settings are:

**Airless Spray** Recommended for large applications  
Tip Pressure = 3000 - 3500  
Tip Size = 15 - 25 thou

**Air Spray** Recommended for small applications

	<b>Pressure Pot</b>	<b>Gravity Feed</b>
<b>Tip Size</b>	2.5mm	1.8mm

**Sanding** Once built to a level surface the dried material is flatted easily with abrasive paper 120-240 grade. For a smoother finish finer grades may be employed.

Ideally dedicated spray equipment should be used for applying water-borne coating. If this is not possible, equipment should first be flushed with a solvent related to the previous solvent based coating. This should then be followed by a second flushing using COPON 3000 CLEANING SOLVENT, a water miscible solvent, then by rinsing through with clean water. After use, wash out with clean water followed by flushing with COPON 3000 CLEANING SOLVENT.

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## DRYING AND CURE TIMES AT 20°C

Sanding Time	3 hours
Minimum Overcoating	1 hour (with COPON HYCOTE SPRAY FILLER) 4 hours (with COPON HYCOTE EA9WB PRIMER)
Maximum Overcoating	3 months
Full cure	7 days

**NOTE:** Drying times are dependant on film build, air movement and temperature.

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## HEALTH & SAFETY

1. COPON HYCOTE SPRAY FILLER is a water based system and does not present any health hazard during normal industrial use.
2. Undue contact with the skin should be avoided. Any affected areas should be washed with soap and water.
3. Where eye contact occurs, the eye should be washed immediately with copious clean water.

**NOTE:** Full Health & Safety Data is available from E Wood Ltd.

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## PACKAGING AND STORAGE

Supplied in 10 kilo packs.

Use within 12 months of purchase. Store in original sealed containers at temperatures between 5°C and 30°C.

Protect from frost during storage and use.

**Copon System Recommendations take precedence over individual Copon product data sheets and are available on request.**



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