



## Polyurethane

### SURFACE PREPARATION

#### Surface Cleaning

All surfaces to be coated should be clean, dry and free from contamination. Oil or grease should be removed prior to paint application. The surfaces should be cleaned thoroughly of all dust, using a vacuum or clean dry compressed air to blow while wiping with clean, oil free, dry cloths.

#### Sanding Preparation

When sanding or grinding, work in areas with adequate ventilation, maintaining a continuous flow of fresh air.

#### Gelcoats and Primers

A sanding paper of grit 120-180 is recommended on the gelcoat and primer surfaces. Ensure any remaining contamination, such as dust or coating / filler particles is removed from the surface by suitable means, prior to application of RELEST Wind Putty Porefiller.

### APPLICATION

<b>Mixing</b>	<p>Once the unit has been mixed it must be used within the working pot life specified.</p> <p>(1) Combine the Hardener (Part B) with the Base (Part A) and mix thoroughly with a low-speed stirrer. Ensure that Hardener container is completely empty.</p> <p>(2) Transfer to another clean container. Remove all residue from first mixing container, add and mix again.</p> <p>Take care to avoid the introduction of air / foam to the mixture. Small quantities may be mixed manually.</p>						
<b>Mix Ratio</b>	<p>Using Part B RELEST Hardener PUR 3313 (I385-3313) or Part B RELEST Hardener PUR 1013 (I385-1013):</p> <p>100 part(s) : 62 part(s) by volume</p> <p>100 part(s) : 65 part(s) by weight</p>						
<b>Working Pot Life</b>	<table border="0"> <tr> <td>20°C (68°F)</td> <td>23°C (73°F)</td> <td>35°C (95°F)</td> </tr> <tr> <td>20 minutes</td> <td>15 minutes</td> <td>8 minutes</td> </tr> </table> <ul style="list-style-type: none"> <li>• The figures quoted above have been determined at: 20°C / 30% RH    23°C / 65% RH    35°C / 85% RH</li> </ul>	20°C (68°F)	23°C (73°F)	35°C (95°F)	20 minutes	15 minutes	8 minutes
20°C (68°F)	23°C (73°F)	35°C (95°F)					
20 minutes	15 minutes	8 minutes					
<b>Roller</b>	Recommended						
<b>Thinner</b>	DO NOT THIN						
<b>Cleaner</b>	RELEST Thinner PUR 132						
<b>Work Stoppages</b>	Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.						
<b>Clean Up</b>	<p>Clean all equipment immediately after use with RELEST Thinner PUR 132.</p> <p>All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.</p>						

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### PRODUCT CHARACTERISTICS

On mixing, RELEST Wind Putty Porefiller will exotherm, which affects the workable life of the the material. Smaller quantities are recommended to reduce wastage.

RELEST Hardener PUR 1013 is a clear hardener. For visual mixing control please use RELEST Hardener PUR 3313 (black).

Application of RELEST Wind Putty Porefiller should be by brush or roller. Immediately after application, all excess material should be removed by means of a metal filler knife. High pressure and up and down movement should be applied to ensure that pores are completely filled.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

For optimum application and drying characteristics, the air and substrate temperature should be between 15°C (59°F) and 35°C (95°F) and relative humidity less than 85%. Good air flow and ventilation should be maintained to improve drying and recoat properties and speed up the application. Application at temperatures below 15°C (59°F) will retard drying and extend overcoatings intervals.

Relative humidities below 35% can significantly retard the curing speed and increase minimum overcoating intervals.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

### SYSTEMS COMPATIBILITY

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RELEST Wind Putty Porefiller is compatible with the whole RELEST Wind product portfolio. For further information please contact your local representative.

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### ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at [www.international-pc.com](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

### SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult your local representative for further advice.

**Warning: Contains isocyanate. Wear air-fed hood for spray application.**

### PACK SIZE

### SHIPPING WEIGHT (TYPICAL)

### STORAGE

#### Shelf Life

18 months minimum at 25°C (77°F) in original, unopened containers. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. Opened containers must be tightly resealed and material used promptly.

### Important Note

*The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.*

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