



POLYESTER PUTTY- TECHNICAL DATA SHEET

POLYESTER PUTTY / BODY FILLER (2K) – GREY/WHITE

Supplier: Lexco International Group (Pvt) Ltd - China

Product Type: Two-component polyester putty / surfacer filler

Appearance: Greyish-white viscous paste

Mixing Ratio (Putty: Hardener): 100: 2 (by weight)

Recommended Use: Surface defect filling and leveling prior to intermediate/topcoat application

PRODUCT DESCRIPTION

This is a 2K polyester-based putty formulated from unsaturated polyester resin, modified resin, pigments, fillers, anti-settling materials, additives, and a special curing agent. It is designed to fill and refine minor surface defects and provide a smooth, flat surface for subsequent coatings.

KEY FEATURES & BENEFITS

- Excellent **leveling** and surface smoothness after scraping
- Strong **adhesion** to suitable prepared substrates
- Good **flexibility** and **impact resistance**
- Adequate **baking resistance** (suitable for controlled oven processes)
- Effective filling of **depressions, pinholes, cracks, and minor weld seams**
- Good repair performance for **fiberglass products**

SUBSTRATE COMPATIBILITY

Suitable Substrates

- Ground two-component primer surfaces
- Pre-treated cold-rolled sheet (CR sheet)

Not Recommended / Restrictions

- **Do not apply on galvanized Sheet**
- Do not apply on contaminated/oily surfaces

MIXING INSTRUCTIONS

1. Mix **Main Putty: Hardener = 100: 2** until color is uniform.
2. Use the mixed putty **within the gel time** (usable period).
3. Do not return mixed material back into the original container.

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TECHNICAL PROPERTIES (TYPICAL VALUES)

Test methods are referenced from GB/T standards as provided.

Material / Appearance

Property	Requirement / Specification	Typical Result	Test Method
Color & appearance (in can)	No skin, no lumps, no obvious particles	Greyish-white viscous paste	Visual
Appearance after scraping	Smooth and fine	Light yellow, smooth after scraping	Visual
Film after drying	No visible particles, scratches, or cracks	Pass	Visual

Application / Curing Performance

Property	Specification	Typical Value	Test Method
Dry grinding time @ 25°C	≤ 3 h	≤ 3 h	GB/T 1728
Consistency	9–12 cm	9–12 cm	GB/T 1749
Gel time (usable period)	≥ 5 min	≥ 5 min	GB/T 1728

Mechanical Properties (Cured Film)

Property	Specification	Typical Value	Test Method
Adhesion	≥ 50 kg / 1.2 cm ²	≥ 50	GB/T 5210
Flexibility	≤ 50 mm	≤ 50	GB/T 1748
Impact strength	≥ 15 kg·cm (or 35 kg·cm not falling off)	Pass	GB/T 1732
Heat resistance (baking)	140°C: no bubbling/cracking	Pass	GB/T 1735

Temperature Cycling Resistance

Requirement: Two cycles or more – Pass

Cycle Definition (1 cycle):

- -40°C for 1 hour → Ambient for 1 hour → 120°C for 1 hour

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APPLICATION GUIDELINES (CONSTRUCTION REFERENCE)

1. Apply on **ground 2K primer** or **pre-treated cold-rolled sheet**.
2. For thick filling, apply **multiple thin coats** until desired thickness is achieved.
3. If air bubbles appear, **scrape off fully** and re-apply to ensure adhesion.

Sanding / Grinding Window (Typical)

- **Wet grinding time: 0.5 – 1 hour** after application
- **Dry grinding time: 2 – 3 hours** after application (*typical @ 25°C*)

Drying/curing time may increase at lower temperatures and higher humidity.

IMPORTANT NOTES / PRECAUTIONS

- Once mixed with hardener, **do not re-pack** into the main container.
- Close lid immediately after use to prevent deterioration from solvent loss.
- **Do not add thinner ("Tian Na water") or any solvent** to dilute for application.
- At low temperature / high humidity, curing time extends; gel time and consistency may be adjusted if required.
- **Not suitable for galvanized sheets.**

STORAGE & SHELF LIFE

- Store in a cool, dry, well-ventilated area away from direct sunlight.
- **Shelf life: 12 months** from manufacturing date.
- If exceeded, material may be re-tested to confirm compliance before use.

DISCLAIMER

The above data are typical values based on provided test requirements and standard application conditions. Actual performance may vary with substrate condition, surface preparation, film build, ambient conditions, and application technique.

(HB International Trading Pvt Ltd)

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