



REFACE SPRAYABLE FILLER

UP0719, UP0733

Version: 13.0 Date of issue: 01/01/2016 Revision date: 28/07/2021 Supersedes: 28/07/2021



DRIVING SURFACE PERFECTION

TECHNICAL DATASHEET

Reface is a high build, 2K sprayable polyester specially developed to create an ultra flat surface prior to priming. The improved formulation features excellent adhesion to most substrates, creating an easy to sand base over steel and fiberglass surfaces, even vertical surfaces.

- High film build.
- Easy to sand.
- Includes liquid hardener.

Product	Order Code	Format	Shelf Life
REFACE SPRAYABLE FILLER	UP0719	1L Tin ; 50ml Bottle	1 year
REFACE SPRAYABLE FILLER	UP0733	2.5L Tin ; 125ml Bottle	1 year

APPLICATION INFORMATION



FOR PPE RECOMMENDATIONS REFER TO SDS

IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use. This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information.



Surface Preparation



Substrate	Degreaser	Abrasion
Bare Steel	SYSTEM 20 Solvent-Based Degreaser	P80
Original Paint	SYSTEM 20 Solvent-Based Degreaser	P180
Fiberglass / GRP, SMC	SYSTEM 20 Water-Based Degreaser	P180
Polyester Body Filler	SYSTEM 20 Solvent-Based Degreaser	P80 - P180

For best results, good preparation is essential. Clean and degrease removing dirt, oil, grease and wax with cleaning solutions such as U-POL's SYSTEM 20 Degreasers (please check local VOC regulations). Abrade with grit paper as stated above for each respective substrate. Re-clean, dry and degrease the abraded substrate ready for application. PLEASE NOTE: this product is not recommended for application over thermoplastic acrylics. PLEASE NOTE: this product is not recommended for application over aluminium, galvanized (zinc coated) or etch primers.

Mixing ratio - Volume



Amount of hardener required	5 vol %				
REFACE SPRAYABLE FILLER	100 ml	250 ml	500 ml	750 ml	1000 ml
Liquid Hardener	5 ml	12.5 ml	25 ml	37.5 ml	50 ml
REFACE SPRAYABLE FILLER	3.5 fl oz	8 fl oz	16 fl oz	24 fl oz	32 fl oz
Liquid Hardener	0.17 fl oz	0.4 fl oz	0.8 fl oz	1.2 fl oz	1.6 fl oz

Mixing ratio - Weight



Amount of hardener required	3 wt%				
REFACE SPRAYABLE FILLER	100 g	250 g	500 g	750 g	1000 g
Liquid Hardener	3 g	7.5 g	15 g	22.5 g	30 g

Mixing



Ensure this product is well shaken/mixed prior to application.

Gun Setup



Gun Tip Size (HVLP)	2.0 – 3.0 mm
Air Pressure at Gun (HVLP)	2.1 bar / 30 PSI

Application



Application Temperature	> 15 °C / 60 °F
Application Viscosity (Zahn #2)	775 Seconds
Working Pot-Life at 70 °F	45 – 60 minutes
Number of Coats	2 – 3
Application Distance From Substrate	15 – 20 cm / 6 - 8 inches
Flash-off at 70°F	Not required between coats
Total Dry Film Thickness	100 – 150 µm / 4 - 6 MIL
Theoretical Coverage at indicated DFT	8 m ² /L / 391 ft ² /gal
	*Theoretical Coverage assuming total dry film thickness is attained at 100% transfer efficiency.

Drying Time



PLEASE NOTE: drying times are dependent upon film thickness, humidity and temperature.	
Dry to Sand at 70 °F	2 – 3 hours
Dry to Sand at 140°F	30 minutes

Sanding



Dry Sanding	P180 - P220
Wet Sanding	Do not wet sand.
U-POL recommends using GUIDE #7 Guide Coat Aerosol during the sanding process to identify the high and low spots.	



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Overcoating



Once sanded, this formulation can be overcoated with most water/solvent-based paint systems. A primer must be used prior to topcoat application.

Additional information



Important Remarks

Activated material should not be returned to the original can of non-activated material.

Do not exceed recommended levels of addition.

Do not use activated product beyond pot life

Equipment Cleaning

Clean gun immediately after use with acetone.

TECHNICAL INFORMATION

Physical properties



Appearance

Liquid.

Color

white

Density

1.595 (1.575 – 1.615) g/cm³

Viscosity, dynamic

4250 (3500 – 5000) cP

VOC Information



As Packaged Regulatory VOC

Unmixed

405 g/l (3.4 lb/gal)

Mixing ratio 5 vol %

As Packaged Actual VOC

405 g/l (3.4 lb/gal)

As Applied Regulatory VOC

370 g/l (3.09 lb/gal)

As Applied Actual VOC

370 g/l (3.09 lb/gal)

Percent Solids

74.8 wt%

Percent Solids

46.54 vol %

Volatiles

25.2 wt%

Water Content

0 wt%

Water Content

0 vol %

Exempt Compounds by weight

0 wt%

Exempt Compounds by volume

0 vol %

% EPA HAPS

22.46 wt%

Storage



Store in a well-ventilated place. Keep cool. Keep container tightly closed. Store locked up. Keep only in original container.

Recommended Storage Temperature (°F)

< 77 °F

Associated Products



Product

Order Code

Format

REFACE Polyester Spray Liquid Hardener

UP0739

60ml Bottle

SYSTEM 20 Water-Based Degreaser

UP2002

5L Canister

SYSTEM 20 Solvent-Based Fast Degreaser

UP2012

5L Tin

SYSTEM 20 Solvent-Based Slow Degreaser

UP2021

1L Tin

SYSTEM 20 Solvent-Based Slow Degreaser

UP2022

5L Tin

GUIDE #7 Guide Coat Aerosol

UP0873

450ml Aerosol

HVLP Gravity Gun 2.5mm tip

UP0313

1-pack

U-POL disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the U-POL website at WWW.U-POL.COM. U-POL is not responsible for the results obtained by others over whose methods we have no control and thereof U-POL is not liable for consequential or incidental damages including loss of profits. U-POL is not liable for mis-use or abuse of its products and no application warranty is expressed or implied.

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