

## TECHNICAL DATA SHEET

### POLYESTER PUTTY

### NOBEL PE 4000 HEAVY POLYESTER

#### PRODUCT DESCRIPTION

**PE 4000** One is a high-quality polyester putty that is a two-component used for filling gaps on car surfaces. It is suitable for car and bus surfaces

#### product features

- High filling capacity.
- Easy sanding.
- Quick drying.
- Excellent adhesion



#### Substrates

NOBEL PE 4000 putty can be applied over a variety of substrates such as bare metal, galvanized original carpanels, aluminum, glass fiber reinforced plastic (GRP), and properly sanded and prepared old finishes insound conditions.

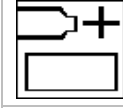
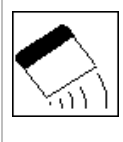




Available in colors (red – yellow – gray).

Available in two sizes: 3 kilograms and 2 kilograms.

#### NOTES

- 1- Mix carefully PE Putty with the hardener to avoid forming air bubbles in the mixture
- 2- Add 1-3% of PE Putty hardener. Do NOT add less or more of the hardener than recommended The use of too much (more than 3%) or too little (less than 1%) of the hardener can cause a problem of bleaching/staining.
- 3- Do NOT apply paints (2K topcoats, basecoats, etc.) directly over 2K PE putties
- 4- Do NOT sandwich PE putty between two layers of topcoats.
- 5- Wet sanding of PE putties is NOT recommended.
- 6- In colder conditions, the warming (infrared or oven) of panels can assist in curing before applying of 2KPE putties.
- 7- After applying PE putties clean all used tools with strong solvents immediately (e.g. NC thinners).

## APPLICATION

	<b>Mixing ratio by weight:</b> 100:1-3	100% NOBEL 4000 PE Putty 1-3% NOBEL 4000 PE Putty Hardener
Pot life (working time) of the mixture is 4-5 minutes at 20°C.		
	<b>Application:</b> Apply by a metal knife. (For edges or curve surfaces use a plastic knife). For deep filling apply in several layers allowing drying between the layers (No sanding in-between is required).	
	<b>Drying time at 20°C:</b> Dry to sand: 20-30 min	
The drying time and pot life of a PE putty mixed with the putty hardener will considerably depend on temperature and the amount of the hardener used.		
<b>"At lower temperature add 2-3 % of the hardener, at higher temperature add 1%."</b>		
	<b>Machine dry sanding:</b> The following grades of sanding papers and steps are recommended: P80-P120 and finish with P180	
	<b>Manual dry sanding:</b> The following grades of sanding papers and steps are recommended: P80-P120 and finish with P180	
<b>IR Drying:</b>		
	Short wave*: 5-8 min  *Guideline for short wave IR equipment.  Refer to the IR equipment manufacturer's instruction for sets-up.	

## Health and Safety

1. For full Health and Safety information please refer to Material Safety Data Sheet (MSDS).
  2. Observe the precautionary notices displayed on the container.
  3. Goggles and suitable protective equipment must be worn while using these products.
- Good ventilation must be provided in the working