TECHNICAL BULLETIN

HARDENER RATIO GUIDELINES FOR POLYESTER BODY FILLERS AND POLYESTER FINISHING GLAZES

Body Fillers

THE CORRECT MIX RATIO FOR BODY FILLER IS 98% FILLER AND 2% HARDENER (50 PARTS FILLER TO 1 PART HARDENER). BODY FILLER DOES NOT LEVEL AND FLOW AS MUCH AS GLAZE WHEN IT IS DISPENSED ONTO A MIXING PALLET. TO ACHIEVE A 2% HARDENER RATIO, RUN A STRAIGHT, UNIFORM BEAD OF HARDENER ACROSS THE DIAMETER OF THE PORTION OF FILLER. REMEMBER TO THOROUGHLY KNEAD THE TUBE OF HARDENER BEFORE DISPENSING.

CORRECT HARDENER RATIO FOR BODY FILLER

Finishing Glazes

THE CORRECT MIX RATIO FOR FINISHING GLAZE IS 98% GLAZE AND 2% HARDENER (50 PARTS GLAZE TO 1 PART HARDENER). FINISHING GLAZE WILL LEVEL AND FLOW (SOME MORE THAN OTHERS) WHEN IT IS DISPENSED ONTO A MIXING PALLET. TO ACHIEVE A 2% HARDENER RATIO, RUN A STRAIGHT, UNIFORM BEAD OF HARDENER AT LEAST 1/2 BUT NOT MORE THAN 3/4 ACROSS THE DIAMETER OF THE PORTION OF GLAZE. REMEMBER TO THOROUGHLY KNEAD THE TUBE OF HARDENER BEFORE DISPENSING.

CORRECT HARDENER RATIO FOR GLAZE

TECH TIPS FOR POLYESTER FILLER AND GLAZE

1. Do not alter hardener ratio to compensate for temperature conditions. Under-hardening results in the filler or glaze never achieving the full physical properties. This results in poor adhesion, strength and durability. Over-hardening may result in residual hardener on the sanded surface, which could react with primers and top coats.
2. When mixing fillers or glaze, fold the hardener into the product with a plastic spreader (do not stir). Apply pressure with the spreader during mixing and application to minimize air entrapment.

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