



Axalta 13225S™ Clear Polyurethane Filler-Sealer



GENERAL

DESCRIPTION

A high-productivity clear-pigmented polyurethane filler-sealer designed to provide excellent appearance and durability for interior cabin surfaces. It is formulated to deliver excellent clarity, dry times, and sandability while filling/sealing substrate for final clearcoat application.

RECOMMENDED USES

13225S is recommended for use with 13325S™ as part of a wood cabinetry finishing system. This system is designed to provide excellent appearance while reducing overall material usage and labor cost in the production of high-build, mirror-finish wood surfaces. Flame retardant is typically added at the level required to pass completed part flammability testing.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

13225S Clear Polyurethane Filler-Sealer
13125S™ Urethane Activator

See 13325S product data sheet for clearcoat information.

MIX RATIO

Thoroughly mix 13225S prior to activation. Filter activated material prior to spray application.

Components

13225S Clear Polyurethane Filler-Sealer
13125S Urethane Activator

Parts by Volume

4
1

ADDITIVES

Flame retardant additive is typically added at 4-7% by volume. Burn testing of actual part/surface is required to determine appropriate flame retardant amount.

INDUCTION TIME

No induction time is required prior to application.

POT LIFE

30 minutes at 70°F (21°C).



APPLICATION

ENVIRONMENTAL CONDITIONS

Substrate and ambient temperature must be between 50°F (10°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated paint above 110°F (43°C) may cause gelation.



SUBSTRATES AND SURFACE PREPARATION

Surface preparation is critical to final appearance. All substrate should be sanded, using 240 grit or higher sandpaper. Wood substrates should thoroughly dry and tacked prior to application.

GUN SETUP

Can be applied with conventional, HVLP, and electrostatic spray equipment using pressure, or gravity fluid delivery. Due to high productivity (fast cure), a two-component (plural) system may be necessary for high volume production.

Conventional Fluid Tip

Pressure Pot	1.2mm-1.6mm (.047"-.063")
Gravity Feed	1.2mm-1.6mm (.047"-.063")

HVLP

Pressure Pot	1.2mm-1.6mm (.047"-.063")
Gravity Feed	1.2mm-1.6mm (.047"-.063")

FLUID DELIVERY

Conventional	10-12 oz./minute
HVLP	10-12 oz./minute

AIR PRESSURE

Conventional	50-60 psi atomizing air
HVLP	25-30 psi atomizing air

APPLICATION

- A 3-coat application process is recommended for 13225S. Spray the first coat medium wet, with a wet film build of approximately 1.0 mil. Allow the coat to flash 3-5 minutes before the next coat. Repeat with a second and then third coat. Once the 3-coat process is completed, allow the coating to dry for 2 hours at 70°F (or 30 minutes at 120°F).
- Repeat the 3-coat process (additional 3 coats with 3-5 minute flash in between each coat). After the second 3-coat process is completed, allow the coating to dry for at least 8 hours at 70°F.
- The coating should be sanded smooth with 320 grit (or higher) sandpaper and wiped/tacked. The surface should appear smooth and free of any texture from underlying wood grain. Additional 13225S application processes are recommended if texture remains. Once the wood grain is suitably filled, the substrate is ready for clearcoat finishing.

CLEANUP SOLVENTS

Axalta 107™ Low VOC Gun & Equipment Cleaner
Axalta 105™ Gun & Equipment Cleaner



DRY TIMES

AIR DRY AT 70°F (21°C)

Flash Between Coats	3-5 minutes
Dust Free	10 minutes
Dry to Sand	3 hours (8 hours recommended)

FORCE DRY AT 120°F (49°C)

Flash Before Force Dry	none required
Dry to Touch	10 minutes (after cool down)
Dry to Sand/Polish	30 minutes (after cool down)

*Note that addition of flame retardant will increase dry times. Infrared drying is not recommended.

RECOAT

If recoating 13225S after 24 hours or longer, scuff sand with 320 grit or lower paper.



PHYSICAL PROPERTIES

VOC

	Less Exempts (LE)	As Packaged (AP)
13225S	4.8 lbs./gal	4.5 lbs./gal
RTS 13225S With 13125S	4.8 lbs./gal	4.5 lbs./gal

FACTORY-PACKAGED FILLER-SEALER

Color	Cloudy
Closed Cup Flash Point	20°F-73°F
Shelf Life	2 years (Unopened at 50°-110°F)

READY-TO-SPRAY

Theoretical Coverage	470 ft ² /gal at 1 mil dry film thickness
Weight Solids	38%
Volume Solids	29%
Gallon Weight	7.8 lbs./gal

DRY FILM

Gloss	≥ 90 measured at 60°, with 13325S Clearcoat
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COATING PERFORMANCE

Chemical and Solvent Resistance	Very Good
Humidity Resistance	Excellent
Acid and Alkali Resistance	Very Good
Abrasion Resistance	Very Good
Flexibility	Very Good

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
1.855.6.AXALTA
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In Canada:
1.800.668.6945
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