

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

Ultimate Rapid Drying HS 4:1 V2018

PRODUCTS

Fast Acrylic Filler HS 4:1 V2018
Hardener 1:4 for Fast Acrylic Filler V2018.
Thinner for acrylic systems.

PRODUCT DESCRIPTION

The highest quality 2K acrylic primer with excellent adhesion to steel, aluminum, galvanized steel, polyester putties and old finishes. Destined for automotive repair.

- ✓ Excellent adhesion to difficult surfaces.
- ✓ Short time drying
- ✓ Easy to mix and apply.
- ✓ Exceptional vertical stability.
- ✓ Good filling properties.

Colour – White, Grey, Black.

Gloss – Matt.

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 420 [g/l]

These products meet the EU directive (2004/42/EC) that sets the VOC value for its category (IIB), at 540 g/l.

SURFACE PREPARATION

Acrylic Primer V2018 can be applied over:

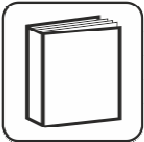
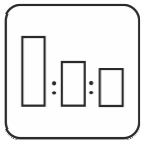

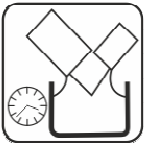

- ✓ Steel and aluminum after flatting and degreased.
- ✓ Galvanized steel after flatting and degreased.
- ✓ Sanded polyester glass laminates (GFK/GRP).

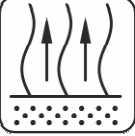



- ✓ 2K polyester putties, polyester spraying fillers.
- ✓ Wash primers.
- ✓ 2K acrylic primers.
- ✓ 2K epoxy primers.
- ✓ Old finishes in good condition after sanding and degreasing.

Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended:

- by hand (dry or wet): P280÷P320 (GRP P400),
- by machine (dry): P180÷P220.

APPLICATION PROCESS

	<p>Application For car repairs as a filling primer.</p>						
	<p>Mixing Ratio by volume</p> <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">Filler</td> <td style="text-align: right;">4</td> </tr> <tr> <td>Hardener</td> <td style="text-align: right;">1</td> </tr> <tr> <td>Thinner</td> <td style="text-align: right;">0-5%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>	Filler	4	Hardener	1	Thinner	0-5%
Filler	4						
Hardener	1						
Thinner	0-5%						
	<p>Spraying Viscosity 30÷50 seconds at 20°C</p>						
	<p>Pot Life Approx. 60 minutes at 20°C.</p>						
	<p>Number of layers 2÷3 layers; Approximately 70÷90µm for one layer.</p> <p>Parameters for RP spray gun Nozzle: 1,6÷2,0 mm; Pressure: 2,0-2,2 bar.</p> <p>Parameters for HVLP spray gun Nozzle: 1,5÷1,9 mm; pressure: 2,0 bar.</p>						

	<p>Evaporation Time</p> <p>Between coats: 5÷10 minutes Before baking: approximately 10 minutes</p> <p>Evaporation time depends on temperature and film thickness.</p>
	<p>Curing time for thick layer 150÷180 µm</p> <p>Approx 1hour in 20°C. Approx 10min in 60°C</p> <p>Curing time for thick layer 180÷250 µm</p> <p>Approx 2 hours in 20°C.</p> <p>Temperature below 20°C significantly increases the hardening time.</p>
	<p>Dry Sanding:</p> <p>Grinding Machine: P360÷P500. Hand Sanding: P280÷P320.</p>
	<p>Wet Sanding:</p> <p>Hand Sanding: P800÷P1000.</p>

FURTHER WORK

2K acrylic filler can be directly over coated with:

- ✓ 2K acrylic clear coats.
- ✓ 1K base coats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- ✓ Clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components between 15 to 25 °C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. *Close the container after use.*
2. *Protect the hardener from frost and dampness*

WARRANTY PERIOD

Fast Acrylic Primer HS 4:1 V2018 - 12 month from the date of Manufacture.
Hardener 1:4 for Fast Acrylic Primer V2018 – 12 months from the date of Manufacture.

Important Information:

The information contained in this document corresponds to our present knowledge and is a guide to our products and their uses.

Read all directions and warnings prior to using Troton products - Safety Data Sheets can be found online at www.troton.com.pl or will be sent according to your request: troton@troton.com.pl

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that Troton believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Many factors beyond Troton's control and uniquely within user's knowledge and control can affect the use and performance of a Troton product in a particular application. Given the variety of factors that can affect the use and performance of a Troton product, user is solely responsible for evaluating the Troton product and determining whether it is fit for a particular purpose and suitable for user's method of application.

Limitation of Liability: Except where prohibited by law, Troton will not be liable for any loss or damage arising from the Troton product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

If used as instructed, this product is designed to comply with the European Volatile Organic Compound (VOC) Emission Standard for Automotive Refinish Coatings. Confirm compliance with your country, state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Troton assumes no obligation or liability for use of this information.