

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

Acryl Filler 4:1

PRODUCTS

Acryl Filler 4:1
Hardener 1:4 for Acryl Filler
Thinner for acrylic systems

PRODUCT DESCRIPTION

2-pack acrylic high build primer for car and train repairs.

- ✓ Easy to mixing and apply.
- ✓ Very short hardening time.
- ✓ Good filling properties.

Color - Light grey, gray, white, black.
Gloss Grade – Matt.
Density – 1,68 kg/l

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 538 [g/l]

The share of VOC is below 540 g/l. Due to that these products fulfill the EU directive (2004/42/EC) that sets the VOC value for this product category (B/3), as 540 g/l.

SUBSTRATES AND PREPARATION

Acryl Filler 4:1 can be applied over:

- ✓ Bare steel and aluminum.
- ✓ Polyester laminates (GFK/GRP).
- ✓ 2-pack polyester putties, polyester spraying fillers.
- ✓ 2-pack wash primers.

- ✓ 2-pack acryl fillers.
- ✓ 2-pack epoxy fillers.
- ✓ Old finishes in good condition.

Steel surface should be first degreased, dry sanded and degreased again.


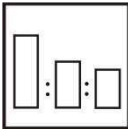
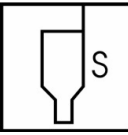
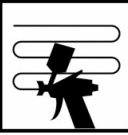
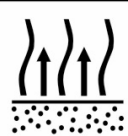
The aluminum and galvanized steel should be degreased, dulled with the abrasive cloth and degreased again.



The old coatings should be degreased, dry sanded and degreased again.

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>USE For car and train repairs as a filling or grounding primer</p>
	<p>Mixing ratio by volume</p> <p>Filler 4 parts Hardener 1 part Thinner 15% (filling primer) 20% (grounding primer)</p> <p>Stir well the mixture.</p>
	<p>Spraying viscosity approx. 50 seconds at 20°C for filling primer. approx. 30 seconds at 20°C for grounding primer.</p> <p>Pot life approx. 30 minutes at 20°C</p>
	<p>Nozzle</p> <p>Gravity: 1,6÷1,8 mm, Pressure: According to gun`s producer recommendations. Number of layers: 2÷3 layers</p>
	<p>Evaporation time</p> <p>between layers approx. 5 minutes before baking approx. 10 minutes</p>

	<p>Hardening time Specific dryness at 20⁰C – after 2 hours Specific dryness at 60⁰C – after 25 minutes</p> <p>Temperature below 20⁰C significantly increases the hardening time.</p>	
	<p>Hand sanding P280÷P320 (dry) P600÷P800 (wet)</p>	<p>Machine sanding P360÷P500 (dry) P600÷P1000 (wet)</p>

FURTHER WORKS

2K acryl fillers can be directly over coated with:

- ✓ 2-pack acryl topcoats.
- ✓ 1-pack basecoats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results you can achieve at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, 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 in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: *After each use the container with products shall be immediately closed! Protect hardener against freeze and humidity!*

WARRANTY PERIOD

Acryl Filler 4:1 - 12 months from the date of Manufacture.
 Hardener 1:4 for Acryl filler – 12 months from the date of Manufacture.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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