

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

V2012 Acrylic Filler 4:1



PRODUCTS

V2012 Acrylic Filler 4:1 – **Filling and grounding primer for galvanized steel.**

Hardener 1:4 for Acrylic Filler V2012.

Thinner for acrylic systems.

PRODUCT DESCRIPTION

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

- ✓ Excellent adhesion to difficult surfaces.
- ✓ Easy to mix and apply.
- ✓ Exceptional vertical stability.
- ✓ Good filling and isolation properties.
- ✓ Easy to sand.

Colour – White, Light Grey, Black.

Gloss – Matt.

VOLATILE ORGANIC COMPOUNDS

VOC with 10% thinner = 460 [g/l]

VOC with 20% thinner = 510 [g/l]

The share of VOC is below 540 g/l. These products meet the EU directive (2004/42/EC/II B) that sets the VOC value for its category (C), at 540 g/l

SURFACE PREPARATION

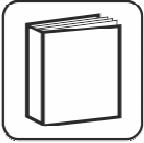
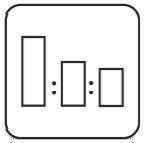

Acrylic Filler V2012 4:1 can be applied over:

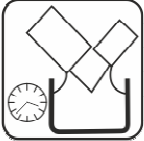

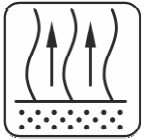



- ✓ Steel and aluminum after flatting and degreased.
- ✓ Galvanized steel after flatting and degreased.
- ✓ Sanded polyester glass laminates (GFK/GRP).
- ✓ 2K polyester putties, polyester spray fillers.
- ✓ Wash primers.
- ✓ 2K acrylic primers.
- ✓ 2K epoxy primers.
- ✓ Old finishes in good condition after matting 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 or grounding primer.</p>						
	<p>Mixing Ratio by volume</p> <table style="width: 100%; border: none;"> <tbody> <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;">10% (filling primer) 20% (grounding primer)</td> </tr> </tbody> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>	Filler	4	Hardener	1	Thinner	10% (filling primer) 20% (grounding primer)
Filler	4						
Hardener	1						
Thinner	10% (filling primer) 20% (grounding primer)						
	<p>Spraying Viscosity 40÷50 seconds at 20°C (filling primer) 25÷30 seconds w 20°C (grounding primer)</p>						

	<p>Pot Life Approx. 60 minutes at 20°C.</p>
	<p>Number of layers 2÷3 layers; 60÷300µm depending on the size of the nozzle gun.</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 inside the nozzle: 2,0 bar.</p>
	<p>Evaporation Time</p> <p>Between coats: 5÷10 minutes Before baking: 5÷15 minutes</p> <p>Evaporation time depends on temperature and film thickness.</p>
	<p>Curing time at 20°C: Filling primer /130÷300 µm/ - ready to sand after drying overnight. Grounding primer /60÷130 µm/ - ready to sand after 3÷4 h.</p> <p>Curing time at 60°C object temperature: Filling primer /130÷300 µm/ - ready to sand after baking for 35÷40 minutes and cooling dawn (about 2 h). Grounding primer /60÷130 µm/ - ready to sand after baking for 25÷30 minutes and cooling dawn (about 2 h).</p> <p>Temperature below 20°C significantly increases the hardening time.</p>
	<p>IR Drying</p> <p>Filling primer /130÷250µm/: 10÷15 minutes under short wave. Grounding primer /60÷130 µm/: 8÷10 minutes under short wave.</p> <p>Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.</p>
	<p>Dry Sanding:</p> <p>Machine Sanding: P360÷P500. Hand Sanding: P280÷P360.</p>

**Wet Sanding:**

Hand Sanding: P800÷P1000.
Machine Sanding: P600÷P1000.

FURTHER WORK

2K acrylic primers 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

V2012 Acrylic Filler 4:1 - 12 months from the date of Manufacture.

Hardener 1:4 for V2012 Acrylic filler – 12 months from the date of Manufacture.

Limitation of liability:

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's **services**.

All information is based on meticulous laboratory tests and many years of experience. An established position on the market does not release us from continuous quality control of our products. However, we are not responsible for the final effects of improper storage or use of our products, and for work that is not in line with good craftsmanship.

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