

## 4:1 PRIMER FILLER

v.09-05.2018

**CHARACTERISTICS:**

Two-component acrylic filler with high content of solids. It has very good filling properties. Excellent flow, no tendency to sag, as well as easy application and sanding, allow for excellent surface quality. This product provides very good protection against corrosion. It is recommended for steel, aluminium, galvanised surfaces, polyester laminates, as well as surface covered with polyester putties. It is intended for dry and wet manual/machine sanding.

**APPLICATION:**

The surface being repaired must be clean, dry, matted and degreased. Measure out the A+B mixture by volume: 4 parts by volume of filler (A) and 1 part by volume of hardener (B), then mix thoroughly. Add a thinner for acrylic products (C) in an amount of 10 - 20 vol. % of component A. Apply with a spray gun (spray nozzle 1.5 - 2.2 mm) in 1 - 3 layers, with a 10 - 20 minute (depends on the hardener) interval to evaporate solvents before applying the next layer.

**TECHNICAL DATA:**

**VOC 2004/42/IIB(c)(540) max. 540 g/l**

**Filler:**

Shelf life: 18 months

Density (20°C): 1.56 – 1.60 g/cm<sup>3</sup>

Colour: grey/black/white


**Hardener: Standard**

Shelf life: 12 months


Density (20°C): 0.92 – 1.01 g/cm<sup>3</sup>

Colour: colourless/slightly yellow



**MIXING RATIO**

	-	by volume	by weight
	Filler (A)	4	100
	Hardener (B)	1	15.6
	Thinner (C)	10 - 20 vol. % of component A	9 - 18 wt. % of component A

**SPRAYING VISCOSITY**

	DIN cup 4 mm (20°C)	25 - 30 s
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**APPLICATION**

	Gravity feed spray gun	nozzle		pressure	
		1.5 - 2.2 mm		operating pressure according to spray gun manufacturer's recommendation	
	Application	number of layers	flash-off time	single layer thickness	coating thickness
		1 - 3	10 min	50 - 80 µm	50 - 240 µm

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<b>Recommended application conditions</b>	temperature 18 - 22°C, humidity 40 - 60%
<b>Theoretical coverage</b>	7 - 8 m <sup>2</sup> /l (with a layer thickness of 80 µm)
<b>Pot life (20°C)</b>	up to 1 h

DRYING TIMES			
	Object temperature	60°C	20°C
	Hardener type		
	Standard	20 - 30 min	3 - 5 h
	IR drying	Short and medium wave: 12 - 15 min  Follow IR lamp manufacturer's recommendations. Keep the flash-off time before drying.	
	Dry sanding	P400 - P600	
	Wet sanding	P800 - P1000	

**NOTES:**

Allow the product to reach the recommended application temperature in a natural, unforced way (avoid rapid heating/cooling). Temperature of the product and the object being painted and ambient temperature should be approx. 20°C.

**STORAGE AND TRANSPORT:**

Protect from frost, heat, sunlight and moisture. Store tightly closed in a dry and cool place.  
Recommended storage temperature: +10 to +30°C.

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