

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

Acrylic Filler 5:1

PRODUCTS

Acrylic Filler 5:1
Hardener 1:5 for Acrylic Filler
Thinner for acrylic systems

PRODUCT DESCRIPTION

2K acrylic filler for car repairs.

- ✓ Easy to mix and apply.
- ✓ Excellent covering properties
- ✓ Easy and fast sanding

Color - Light grey, white, black.
Gloss Grade – Matt.

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 538 [g/l]


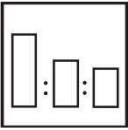
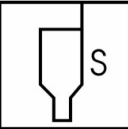
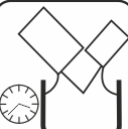
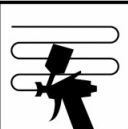
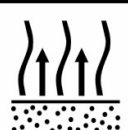

The share of VOC is below 540 g/l. These products meet the EU directive (2004/42/EC) that sets the VOC value for its category (IIIB), at 540 g/l.




SURFACE PREPARATION

Acrylic Filler 5:1 can be applied over:

- ✓ Steel and aluminum after flatting and degreasing.
- ✓ Sanded polyester-glass laminates (GFK/GRP).
- ✓ Polyester putties
- ✓ Epoxy primers
- ✓ Wash primers
- ✓ Old finishes in good condition after flatting and degreasing.

APPLICATION PROCESS

	<p>USE For car repairs as a filling primer</p>						
	<p>Mixing ratio by volume</p> <table border="0"> <tr> <td>Filler</td> <td>5 parts</td> </tr> <tr> <td>Hardener</td> <td>1 part</td> </tr> <tr> <td>Thinner</td> <td>25÷30%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture</p>	Filler	5 parts	Hardener	1 part	Thinner	25÷30%
Filler	5 parts						
Hardener	1 part						
Thinner	25÷30%						
	<p>Spraying viscosity approx. 30÷50 seconds at 20°C</p>						
	<p>Pot life Approx. 1 hour at 20°C</p>						
	<p>Number of layers: 2÷3 layers</p> <p>RP gun parameters: Nozzle: 1,6÷2,0 mm, Pressure: 2,0÷2,2 bar</p> <p>HVLP gun parameters: Nozzle: 1,5÷1,9 mm; Pressure: 2,0 bar</p>						
	<p>Evaporation time</p> <table border="0"> <tr> <td>between layers</td> <td>approx. 5 minutes</td> </tr> <tr> <td>before baking</td> <td>approx. 10 minutes</td> </tr> </table> <p>Evaporation time depends on the temperature and the number of layers</p>	between layers	approx. 5 minutes	before baking	approx. 10 minutes		
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before baking	approx. 10 minutes						
	<p>Hardening time for thickness of 200 µm</p> <p>3-4 hours at 20°C 30 minutes at 60°C.</p> <p>Temperature below 20°C significantly increases the hardening time.</p>						

	<p>IR Drying: 15÷20 minutes of short waves for the thickness of 150÷250 µm. The drying process time may change depending on the IR dryer type.</p>
	<p>Dry sanding Machine sanding: P360÷P500. Hand sanding: P280÷P320.</p>
	<p>Wet sanding Hand sanding: P800÷P1000.</p>

FURTHER WORK

2K acrylic fillers can be directly over coated with:

- ✓ 2K acrylic topcoats.
- ✓ 1K basecoats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of the hardener!
- ✓ The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar
- ✓ 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 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

Acrylic Filler 5:1- 12 months from the date of Manufacture.

Hardener 1:5 for Acrylic Filler – 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.

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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.