Technical Data Sheet

ACRYLIC FILLER 4:1

Acrylic filler with anti-corrosion additives

RELATED PRODUCTS

FILLER HARDENER — Acrylic filler hardener
THINNER — Acrylic and polyurethane thinner

PROPERTIES

- A product designed and dedicated for renovation of classic cars
- Universal acrylic filler
- Excellent anti-corrosion properties
- Can be used as a filler or insulator
- Excellent dry machine sanding
- Smooth surface

SUBSTRATES	
Old paint coatings, including thermoplastic paints	Degrease and dry sand with P220 – P360.
Polyester putties	Dry sand, finishing levelling with P240 – P320.
Epoxy primers	No sanding for up to 12 hours, sand with P320 afterwards.
Steel	Degrease and dry sand with P120.
Stainless steel	Degrease.
Original elements with cataphoretic coating.	Degrease with SILICON REMOVER, no sanding is necessary.
Wash primers	Apply after drying.
Polyester laminates	Degrease and dry sand with P280.

MIXING RATIO

	Filling version		Priming version		Wet on wet version	
	Volume ratio	Weight ratio	Volume ratio	Weight ratio	Volume ratio	Weight ratio
ACRYLIC FILLER 4:1	4	100	4	100	4	100
FILLER HARDENER	1	17	1	17	1	17
THINNER	15%	7.5	25%	15	38%	22

Apply the thinner in the amount calculated for the primer.

VISCOSITY

	Filling version	Priming version	Wet on wet version
DIN 4/20°C	35 – 50 s	25 – 35 s	18 – 21 s

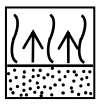
CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC II/B/c limit*	540 g/l
VOC actual, filling version	510 g/l
VOC actual, priming version	539 g/l
Actual VOC content, wet on wet version	590 g/l

* For ready to use mixture acc. to EU Directive 2004/42/CE

APPLICATION CONDITIONS

It is recommended to apply the primer at a temperature above 15°C and a humidity of no more than 80 %.

APPLICATION				
 CAUTION: Instructions of the equipment manufacturer must be followed.	Conventional gravity fed spray gun Filling and priming versions Wet on wet version	Nozzle	Pressure	Distance
		1.6 – 1.8mm 1.2 – 1.4mm	3 – 4 bar 3 – 4 bar	15 – 20 cm 15 – 20 cm
	Low-pressure gravity fed spray gun Filling and priming versions Wet on wet version	1.6 – 1.7 mm 1.4 – 1.6 mm	2 bar 2 bar	10 – 15 cm 10 – 15 cm
	Number of layers	1–3		
	Single dry layer thickness	Filling version	Priming version	Wet on wet version
		50 – 70 µm	30 – 50 µm	20 – 30 µm
	The yield of the ready to use mixture for the given range of dry layer thickness	4.1 m^2/l at 100 µm	7.8 m^2/l at 50 µm	11.2 m^2/l at 30 µm
	Mixture life at 20°C	1 h		
	Flash-off time between layers	5 – 10 min		
CURING TIME				
	20°C	60°C		
	3 h	30 min		
CAUTION: The curing times apply to the temperatures of the individual elements.				
IR DRYING				
	Distance	Follow the recommendations of the equipment manufacturer		
	Time depending on the type and power of the lamp	10 – 20 min		
CAUTION: Start IR heating after at least 10 mins from applying the last coat.				
SANDING				
	Dry sanding	P360 – P500		
	Wet sanding	P600 – 1000		

COLOUR
Grey
EQUIPMENT CLEANING
THINNER acrylic and polyurethane thinner or NC solvent.
STORAGE CONDITIONS
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.
SHELF LIFE

ACRYLIC FILLER 4:1	24 months/20°C
FILLER HARDENER	18 months/20°C
THINNER	24 months/20°C

SAFETY
See Safety Data Sheet.
OTHER INFORMATION
Registration number: 000024104. The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a trial/test application of the product due to the potential variation of product performance between substrate materials. We may not be held liable for defects if final results were affected by factors beyond our control.

ADDITIONAL INFORMATION

WEIGHT QUANTITY OF COMPONENTS: 4+1+15% filling version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture amount	ACRYLIC FILLER 4:1	FILLER HARDENER	THINNER
0.10 l	109 g	18 g	10 g
0.15 l	164 g	27 g	14 g
0.20 l	218 g	36 g	19 g
0.25 l	273 g	45 g	24 g
0.30 l	327 g	53 g	29 g
0.40 l	437 g	71 g	38 g
0.50 l	546 g	89 g	48 g
0.75 l	819 g	133 g	71 g
1.00 l	1091 g	178 g	95 g

WEIGHT QUANTITY OF COMPONENTS: 4+1+25% priming version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture amount	ACRYLIC FILLER 4:1	FILLER HARDENER	THINNER
0.10 l	102 g	17 g	15 g
0.15 l	153 g	25 g	22 g
0.20 l	204 g	33 g	30 g
0.25 l	255 g	42 g	37 g
0.30 l	306 g	50 g	45 g
0.40 l	408 g	66 g	59 g
0.50 l	509 g	83 g	74 g
0.75 l	764 g	125 g	111 g
1.00 l	1019 g	166 g	148 g

WEIGHT QUANTITY OF COMPONENTS: 4+1+38% wet on wet version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture amount	ACRYLIC FILLER 4:1	FILLER HARDENER	THINNER
0.10 l	94 g	15 g	21 g
0.15 l	141 g	23 g	31 g
0.20 l	188 g	31 g	41 g
0.25 l	235 g	38 g	52 g
0.30 l	281 g	46 g	62 g
0.40 l	375 g	61 g	83 g
0.50 l	469 g	76 g	104 g
0.75 l	703 g	115 g	155 g
1.00 l	937 g	153 g	207 g