


1/2	Category	Acrylic filler 2K			
	TDS number	NO-21-10	Registration number	000024104	
	SDS number	SDS_NO_2_01	Date of issue	28.10.2022	

DART FILLER 2000












FAST DRYING ACRYLIC FILLER

PROPERTIES	TYPE MULTIPURPOSE		HARDENER HARD 90-200		THINNER THIN 80-850		
			AVAILABLE HARDENERS STANDARD, SLOW		AVAILABLE THINNERS FAST, STANDARD, SLOW		
	Colour		DESCRIPTION Multipurpose acrylic primer, works both as a filler and wet on wet. Low viscosity guarantee perfect levelling and smooth Surface after drying. Very fast resins allows to achieve very short drying time – only 2 hour at 80 microns of dry layer. Excellent adhesion, good anticorrosive and isolating properties, very easy hand and machine sanding complement sets of properties of very good universal acrylic primer.				
	WHITE	GREY					

COMPLEMENTARY PRODUCTS		PLUS 750 ACCELERATING AGENT	PLUS 700 ADHESION INCREASING AGENT	PLUS 770 ELASTICITY INCREASING AGENT	THIN 80-850 ACRYLIC THINNER
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SUBSTRATES	GENERAL RULE	Before sanding degrease with silicone remover PLUS 780/PLUS 70-780 After sanding blow out dust with compressed air Degrease again with silicone remover PLUS 780/PLUS 70-780				
	OLD PAINT COATINGS	Filler version: dry sanding P220 - P240 Wet on wet version: dry sanding P320 - P360				
	POLYESTER PUTTIES	Dry sanding. Final sanding P240 - P280				
	POLYESTER LAMINATES	Filling version: dry sanding P180 - P220				
	STEEL	Dry sanding P80 - P120. For maximum anticorrosive protection use PROTECT 340, PROTECT 360 or EPO PRIMER 3000				
	OEM CATAPHORETIC PRIMER	Degrease with PLUS 780/PLUS 70-780				
	PLASTICS	See instruction „Type of plastics and technology of painting plastics“				
	2K EPOXY PRIMER	See TDS of epoxy primer				
	2K WASH PRIMER	See TDS of wash primer				

COATABILITY		SPECTRAL 2K SPECTRAL WAVE 2.0 SPECTRAL BASE 2.0 2K POLYURETHANE TOPCOAT 2K ACRYLIC TOPCOAT WATERBORNE BASECOAT SOLVENTBORNE BASECOAT				
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2/2		The wet on wet version is intended for use in industrial installations and in countries where regulations of Directive 2004/42/WE do not apply.		FILLING VERSION		WET ON WET VERSION	
MIXING RATIO		DART FILLER 2000	4	100 g	4	100 g	
		HARD 90-200	1	16 g	1	16 g	
		THIN 80-850	10%-20% For component A	5.5-11 g	50% For component A	28 g	
VOC	VOC II/B/c limit * = 540 g/l * for ready to use mixture acc. to UE Directive 2004/42/CE		VOC content: 530 g/l		VOC content: 590 g/l		
APPLICATION		Viscosity DIN 4 w 20°C	24 - 50 s		15 - 18 s		
	 Follow the equipment manufacture's guidelines	Nozzle	Ø 1.6 – 1.8 mm		Ø 1.2 - 1.4 mm		
		Pressure	1.7 - 2.2 bar		1.7 - 2.2 bar		
		No of coats	2 - 3		1		
		Flash off time depends on spray booth	5 - 10 min / 20°C		15 min / 20°C		
		Potlife at 20°C	10 - 20 min		25 min		
	Single dry coat thickness		40 - 60 µm		20 - 25 µm		
	Theoretical yield		7 - 10 m²/l		13 - 16 m²/l		
SANDING		Dry sanding	INITIAL P240-P320 FINAL P360-P500		WITHOUT SANDING for optimum levelling use THIN 850 SLOW		
		Wet sanding	FINAL P800-P1000				
DRYING TIME		At 80 µm layer	20°C	60°C	15 min / 20°C Flash off time before basecoat/topcoat		
		with HARD 90-200 SLOW	3 hours	30 min			
	with HARD 90-200 STANDARD	2 hours	30 min				
	10 - 15 min SHORT WAVES	Heating 10 min after final layer distance 50 - 70 cm temp. max. 90°C		Non sanding application up to 12 hours / 20°C			
THINNER/HARDENER SELECTION	Size/number of elements		15 – 20 °C	20 – 25 °C	25 – 35 °C	+ 35 °C	
	Spot repair 1-2 parts		HARD 90-200 STANDARD THIN 80-850 STANDARD	HARD 90-200 STANDARD THIN 80-850 STANDARD	HARD 90-200 SLOW THIN 80-850 SLOW	HARD 90-200 SLOW THIN 80-850 SLOW	
	Middle 3-5 parts		HARD 90-200 STANDARD THIN 80-850 STANDARD	HARD 90-200 STANDARD THIN 80-850 STANDARD	HARD 90-200 SLOW THIN 80-850 SLOW	HARD 90-200 SLOW THIN 80-850 SLOW	
	Large 5-10 parts		HARD 90-200 STANDARD THIN 80-850 STANDARD	HARD 90-200 TANDARD THIN 80-850 SLOW	HARD 90-200 SLOW THIN 80-850 SLOW	NOT RECCOMENDED	
CAUTION		USE PERSONAL SAFETY EQUIPMENT	SEE SAFETY DATA SHEED SEE GENERAL CONDITIONS FOR PROFFESIONAL USE		SHELF LIFE		
					FILLER 24 months/20°C	HARD 90-200 STANDARD,SLOW 18 months/20°C	