


1/2	Category	Acrylic filler 2K			
	TDS number	NO-21-11	Registration number	000024104	
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# SOLID FILLER 2200


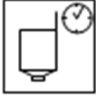









## HIGH BUILD FILLER

PROPERTIES	TYPE <b>HIGH BUILD</b>		HARDENER <b>HARD 90-200</b>		THINNER <b>THIN 80-850</b>		
			AVAILABLE HARDENERS <b>FAST, STANDARD, SLOW</b>		AVAILABLE THINNERS <b>FAST, STANDARD, SLOW</b>		
	COLOUR			<b>DESCRIPTION</b> High build acrylic primer, allows to apply very thick layer and fills highly deep scratches and uneven areas. Thanks to possibility of applying without flash off time, significantly decrease working time. Based on highest quality resins and additives, guarantee excellent adhesion to various substrates, good anticorrosive and isolating properties. Special composition of mineral fillers offers very easy sanding and reduce shrinkage of primer.			
	WHITE	GREY	BLACK				

COMPLEMENTARY PRODUCTS	<b>PLUS 750</b> ACCELERATING AGENT	<b>PLUS 700</b> ADHESION INCREASING AGENT	<b>PLUS 770</b> ELASTICITY INCREASING AGENT	<b>THIN 80-850</b> ACRYLIC THINNER
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SUBSTRATES	GENERAL RULE	Before sanding <b>degrease</b> with silicone remover PLUS 780/PLUS 70-780 After sanding <b>blow out</b> dust with compressed air <b>Degrease</b> again with silicone remover PLUS 780/PLUS 70-780
	OLD PAINT COATINGS	Dry sanding P220 - P240
	POLYESTER PUTTIES	Dry sanding, final sanding P220 - P240
	POLYESTER LAMINATES	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		<b>FILLING VERSION</b>				
<b>MIXING RATIO</b>		<b>SOLID FILLER 2200</b>	VOLUME		WEIGHT	
		<b>HARD 90-200</b>	<b>4</b>		100 g	
		<b>THIN 80-850</b>	<b>1</b>		16.5 g	
			<b>0-10%</b> For component A		0-6 g	
<b>VOC</b>	VOC II/B/c limit * = 540 g/l * for ready to use mixture acc. to UE Directive 2004/42/CE		<b>VOC content: 500 g/l</b>			
<b>APPLICATION</b>		Viscosity DIN 4 in 20°C	<b>32 - 50 s</b>			
	 Follow the equipment manufacture's guidelines	Nozzle	<b>Ø 1.6 - 1.8 mm</b>			
		Pressure	<b>1.7 - 2.2 bar</b>			
		No of coats	<b>2 - 3</b>			
		Flash off time depends on spray booth	<b>0 - 10 min / 20°C</b>			
		Potlife at 20°C	<b>15 min with HARD 90-200 FAST 30 min with HARD 90-200 STANDARD, SLOW</b>			
	Single dry coat thickness		<b>60 - 70 µm</b>			
	Theoretical yield		<b>7 - 10 m<sup>2</sup>/l</b>			
<b>SANDING</b>		Dry sanding	INITIAL P240-P320 FINAL P360-P500			
		Wet sanding	FINAL P800-P1000			
<b>DRYING TIME</b>	At 120µm layer		20°C		60°C	
		with HARD 90-200 SLOW	<b>5 hours</b>		<b>40 min</b>	
		with HARD 90-200 STANDARD	<b>4 hours</b>		<b>40 min</b>	
		with HARD 90-200 FAST	<b>2 hours</b>		<b>30 min</b>	
	15-20 min SHORT WAVES	Heating 10 min after final layer distance 50 - 70 cm temp. max. 90°C				
<b>THINNER/HARDENER SELECTION</b>	Size/number of elements		15 – 20 °C	20 – 25 °C	25 – 35 °C	+ 35 °C
	Spot repair 1-2 parts		HARD 90-200 FAST THIN 80-850 FAST	HARD 90-200 FAST THIN 80-850 STANDARD	HARD 90-200 STANDARD THIN 80-850 STANDARD	HARD 90-200 SLOW THIN 80-850 SLOW
	Middle 3-5 parts		HARD 90-200 FAST 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 STANDARD THIN 80-850 SLOW	HARD 90-200 SLOW THIN 80-850 SLOW	HARD 90-200 SLOW THIN 80-850 SLOW
<b>CAUTION</b>		USE PERSONAL SAFETY EQUIPMENT	SEE SAFETY DATA SHEED SEE GENERAL CONDITIONS FOR PROFESSIONAL USE		<b>SHELF LIFE</b>	
					SOLID FILLER 2200 24 months/20°C	HARD 90-200 STANDARD, SLOW: 18 months/20°C FAST: 12 months/20°C