


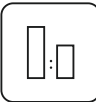







**TECHNICAL INFORMATION**

FOR PROFESSIONAL USE ONLY

<b>ACRYL FILLER 1 K</b>	
<b>PRODUCTS</b>	
Acryl Filler 1K Thinner for acrylic systems	
<b>PRODUCT DESCRIPTION</b>	
1K acrylic primer for car repairs. <ul style="list-style-type: none"> <li>• Easy to use.</li> <li>• Short curing time.</li> <li>• Good filling properties.</li> </ul>	<b>COLOURS:</b> beige, grey, black <b>GLOSS GRADE:</b> matt

<b>VOLATILE ORGANIC COMPOUNDS</b>	
VOC for mixture = 533 [g/l] This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (C), at 540 g/l.	
<b>SURFACE PREPARATION</b>	
1K Acrylic Filler can be applied on: <ul style="list-style-type: none"> <li>• Steel and aluminum after flattening and degreasing.</li> <li>• Sanded polyester-glass laminates (GFK/GRP).</li> <li>• Polyester putties.</li> <li>• Plastic after grounding with 1K Plastic Primer.</li> <li>• Old finishes in good condition after flattening and degreasing.</li> </ul>	Good surface preparation is necessary for achieving best results.  Following sandpaper gradations are recommended: <ul style="list-style-type: none"> <li>• by hand (dry or wet): P280÷P320 (GRP P400).</li> <li>• by machine (dry): P180÷P220.</li> </ul>

<b>APPLICATION PROCESS</b>							
	<b>USE</b>		<b>DRYING TIME</b>				
	For minor car repairs.		Depending on the layer thickness: <ul style="list-style-type: none"> <li>• Approx. 40 minutes at 20°C</li> <li>• Approx. 15 minutes at 60°C</li> </ul> Temperature below 20°C significantly increases the hardening time.				
	<b>MIXING RATIO</b>		<b>NUMBER OF LAYERS AND RP GUN PARAMETERS</b>				
	by volume Filler: 1 Thinner: 10÷15%  Stir thoroughly until achieving homogenous paste.		2÷3 layers.  <b>RP gun parameters:</b> Nozzle: 1.6÷2.0 mm; Pressure: 2.0÷2.2 bars.				
	<b>SPRAYING VISCOSITY</b>		<b>HVLP gun parameters:</b>				
	Approx. 30÷50 seconds at 20°C/DIN4.		Nozzle: 1.5÷1.9 mm; Pressure: 2.0 bars.				
	<b>EVAPORATION TIME</b>		<b>DRY SANDING</b>				
	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Between layers:</td> <td style="width: 50%;">approx. 5 minutes</td> </tr> <tr> <td>Before banking:</td> <td>approx. 10 minutes (to matt)</td> </tr> </table> Evaporation time depends on the temperature and the number of layers.	Between layers:	approx. 5 minutes	Before banking:	approx. 10 minutes (to matt)		Machine sanding: P360÷P500. Hand sanding: P280÷P320.
Between layers:	approx. 5 minutes						
Before banking:	approx. 10 minutes (to matt)						
			<b>WET SANDING</b>				
			Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.				

**FURTHER WORK**

1K acrylic fillers can be directly over coated with:

- 2K acrylic top coats.
- 1K base coats.

**GENERAL NOTES**

- The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- When working , it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.

**Caution:** *To maintain safety, always follow the instructions given in the MSDS for the products.*

**STORAGE**

Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Note:** *Close the container immediately after use.*

**WARRANTY PERIOD**

Acryl Filler 1K – 12 months from the date of production

PRODUCT	ART. No.
Acryl Filler 1K	1601; 1603 (0,5l; 0,8l)
Thinner for acrylic systems	300002236; 300002237 (1l; 5l)

**LIMITATION OF LIABILITY**

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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Ząbrowo, Poland.