





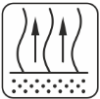




TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<h1>ACRYL FILLER 1 K</h1>		
PRODUCTS		
Acryl Filler 1K Thinner for acrylic systems INTER TROTON		
PRODUCT DESCRIPTION		
1K acrylic primer for car repairs. <ul style="list-style-type: none">• Easy to use.• Short curing time.• Good filling properties.		
		COLOURS: beige, grey, black
		GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS	
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.	
SURFACE PREPARATION	
1K Acrylic Filler can be applied on: <ul style="list-style-type: none">• Steel and aluminum after flatting and degreasing.• Sanded polyester-glass laminates (GFK/GRP).• Polyester putties.• Plastic after grounding with 1K Plastic Primer.• Old finishes in good condition after flatting and degreasing.	Good surface preparation is necessary for achieving best results. Following sandpaper gradations are recommended: <ul style="list-style-type: none">• by hand (dry or wet): P280÷P320 (GRP P400).• by machine (dry): P180÷P220.

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

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