

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<h3>ACRYL FILLER 4:1</h3>		
PRODUCTS Acrylic Filler 4:1 - Primer Premium Hardener 1:4 for Acrylic Filler Thinner for acrylic systems INTER TROTON		
PRODUCT DESCRIPTION 2K acrylic filler for car repairs.		
<ul style="list-style-type: none"> • Easy to mix and apply. • Very short hardening time. • Good filling properties. 		
		COLOUR: white, grey, black GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS VOC for mixture = 538 [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 Acrylic Filler 4:1 can be applied over:	
<ul style="list-style-type: none"> • Steel and aluminum after flatting and degreasing. • Sanded polyester-glass laminates (GFK/GRP). • Polyester putties. • Polyester primers. • Isolation primers. • Wash primers. • 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 For car repairs as a filling primer.		NUMBER OF LAYERS AND RP GUN PARAMETERS 2÷3 layers; 150÷300µm. RP gun parameters: Nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP gun parameters: Nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.
		MIXING RATIO by volume Filler: 4 Hardener: 1 Thinner: 15÷20% Stir thoroughly until achieving homogenous mixture.	HARDENING TIME For thickness of 200µm: <ul style="list-style-type: none"> • 3-4 hours at 20°C • 30 minutes at 60°C Temperature below 20°C significantly increases the hardening time.
	SPRAYING VISCOSITY Approx. 30÷50 seconds at 20°C/DIN4.		IR DRYING 10÷15 minutes of short waves for the thickness of 150÷250 µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	POT LIFE Approx. 60 minutes at 20°C.		
	EVAPORATION TIME Between layers: approx. 5 minutes Before banking: approx. 10 minutes Evaporation time depends on the temperature and the number of layers.		DRY SANDING Machine sanding: P360÷P500. Hand sanding: P280÷P320.
			WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.

FURTHER WORK

2K acrylic fillers can be directly over coated with:

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

GENERAL NOTES

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar.
- When working with 2K products, 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 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:

1. *After each use the container with product should be immediately closed!*
2. *Protect the hardener from frost and dampness!*

WARRANTY PERIOD

Acrylic Filler 4:1	– 12 months from the date of production
Hardener 1:4 for Acrylic filler	– 12 months from the date of production
Thinner for acrylic systems INTER TROTON	– 24 months from the date of production

PRODUCT	ART. No.
Acrylic Filler 4:1	(0,8l + 0,2l): 1334; 1345; 1353
	(3,6l): 9601; 11626; 11627
	(4l): 4833; 6376; 6375
Hardener 1:4 for Acrylic filler	9602 (0,9l); 4835 (1l)
Thinner for acrylic systems INTER TROTON	300002236 (1l); 300002237 (5l)

LIMITATION OF LIABILITY

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

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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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