

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### HS 4:1

ACRYLIC FILLER HS 4:1

#### PRODUCTS

HS MASTER Acrylic Primer 4:1 – Filler.  
Hardener 1:4 for Acrylic Filler HS MASTER.  
Thinner for acrylic systems.

#### PRODUCT DESCRIPTION

2K acrylic filler for car repairs.

- Easy to mix and apply.
- Very short hardening time.
- Good filling properties.



**COLOURS:** white, lightgrey, 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 HS MASTER can be applied over:

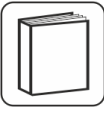

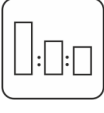



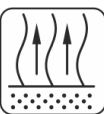

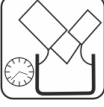

- Steel and aluminum after flatting and degreasing.
- Sanded polyester-glass laminates (GFK/GRP).
- Polyester putties.
- Epoxy primers.
- Wash primers.
- Old finishes in good condition after flatting and degreasing.

Good preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

- Sanding by hand (dry or wet): P280÷P320 (GRP P400).
- Sanding by machine (dry): P180÷P220.

#### APPLICATION PROCESS

USE		HARDENING TIME					
	For car repairs as a filling primer.		For thickness of 200µm: <ul style="list-style-type: none"> <li>• 3-4 hours at 20°C.</li> <li>• 30 minutes at 60°C.</li> </ul> Temperature below 20°C significantly increases the hardening time.				
	<b>MIXING RATIO</b> by volume Primer 4 parts Hardener 1 part Thinner 15÷20% Stir thoroughly until achieving homogenous mixture.		<b>NUMBER OF LAYERS</b> 2÷3 layers; approx. 80µm for one layer.  <b>Gun parameters:</b> RP nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.				
	<b>SPRAYING VISCOSITY</b> 30÷50 seconds at 20°C/DIN4		<b>IR DRYING</b> 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.				
	<b>EVAPORATION TIME</b> Between layers: approx. 5 min. Before banking: approx. 10 min.  Evaporation time depends on the temperature and the number of layers.		<b>DRY SANDING</b>  <table border="0"> <tr> <td>Machine sanding</td> <td>P360÷P500</td> </tr> <tr> <td>Hand sanding</td> <td>P280÷P320</td> </tr> </table>	Machine sanding	P360÷P500	Hand sanding	P280÷P320
Machine sanding	P360÷P500						
Hand sanding	P280÷P320						
	<b>POT LIFE</b> Approx. 60 minutes at 20°C		<b>WET SANDING</b>  <table border="0"> <tr> <td>Machine sanding</td> <td>P600÷P1000</td> </tr> <tr> <td>Hand sanding</td> <td>P800÷P1000</td> </tr> </table>	Machine sanding	P600÷P1000	Hand sanding	P800÷P1000
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 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:**

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

**WARRANTY PERIOD**

HS MASTER Acrylic Primer 4:1 – Filler.	– 12 months from the date of production
Hardener 1:4 for Acrylic Filler HS MASTER.	– 12 months from the date of production
Thinner for acrylic systems.	– 12 months from the date of production

<b>PRODUCT</b>	<b>ART. No.</b>
HS MASTER Acrylic Primer 4:1 – Filler	(0,8l + 0,2l): 1328; 6327; 6328
Hardener 1:4 for Acrylic Filler HS MASTER	
Thinner for acrylic systems	300002253; 300002790 (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.

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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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