MASTER
TROTON

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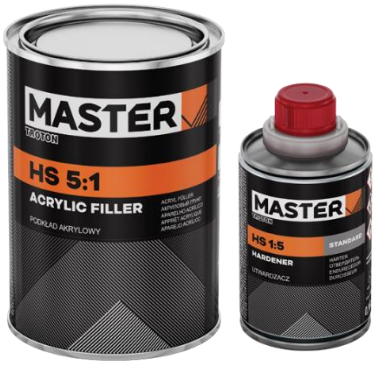
TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

HS 5:1

ACRYLIC FILLER HS 5:1



COLOUR: lightgrey

GLOSS GRADE: matt

PRODUCTS

HS MASTER Acrylic Primer 5:1 – Filler.
Hardener 1:5 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.

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

For car repairs as a filling primer.

NUMBER OF LAYERS

2÷3 layers; approx. 80 µm for one layer.

Gun parameters:
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.

MIXING RATIO by volume

Primer	5 parts
Hardener	1 part
Thinner	25÷30%

Stir thoroughly until achieving homogenous mixture.

HARDENING TIME

For thickness of 200µm:

- approx. 3÷4 hours at 20°C
- approx. 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.

EVAPORATION TIME

Between layers:	approx. 5 min.
Before baking:	approx. 10 min.

Evaporation time depends on the temperature and the thickness of layers.

DRY SANDING

Machine sanding	P360÷P500
Hand sanding	P280÷P320

POT LIFE

Approx. 60 minutes at 20°C.

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 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 5:1 – Filler.	– 12 months from the date of production
Hardener 1:5 for Acrylic Filler HS MASTER.	– 12 months from the date of production
Thinner for acrylic systems.	– 12 months from the date of production

PRODUCT	ART. No.
HS MASTER Acrylic Primer 5:1 – Filler	(0,8l + 0,16l): 1860; 6329; 6330
Hardener 1:5 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.

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