

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

V2012 HS 4:1

ACRYLIC FILLER HS 4:1

PRODUCTS

V2012 MASTER Acrylic Primer 4:1 – HS Filler primer for galvanized steel

Hardener 1:4 for Acrylic Filler V2012

Thinner for acrylic systems MASTER

PRODUCT DESCRIPTION

The highest quality 2K acrylic primer with excellent adhesion to steel, aluminum, galvanized steel, polyester putties and old finishes. Intended for car body repairs.

- Excellent adhesion to difficult substrates.
- Easy to mix and apply.
- Very good vertical stability.
- Good filling and insulating properties.
- Easy sanding.



COLOURS: white, lightgrey, black

GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS

VOC with 10% of thinner = 460 [g/l], VOC with 20% of thinner = 510 [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 V2012 4:1 can be applied over:

- Steel and aluminum after flatting and degreasing.
- Zinc coated steel 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 body repairs as an isolating (thin-coat) or filling primer.		Filling version (130÷300 µm):
			<ul style="list-style-type: none"> • at 20°C: ready for sanding after overnight drying. • at 60°C: ready for sanding after baking for 35÷40 minutes and cooling the coating (about 2 hours).
	MIXING RATIO by volume		Priming version (60÷130 µm):
	Primer 4 parts Hardener 1 part Thinner: Filling version 10% Priming version 20% Stir thoroughly until achieving homogenous mixture.		<ul style="list-style-type: none"> • at 20°C: ready for sanding after 3÷4 h. • at 60°C: ready for sanding after baking for 25÷30 minutes and cooling the coating (about 2 hours).
	SPRAYING VISCOSITY		Temperature below 20°C significantly increases the hardening time.
	Filling version: 40÷50 sec. at 20°C Priming version: 25÷30 sec. at 20°C		NUMBER OF LAYERS
	POT LIFE		2÷3 layers; 60÷300µm depending on the size of the spray nozzles.
	Approx. 60 minutes at 20°C/DIN4.		Gun parameters:
	EVAPORATION TIME		RP nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars.
	Between layers: 5÷10 minutes Before baking: 5÷15 minutes Evaporation time depends on the temperature and the thickness of layers.		HVLP nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.
		IR DRYING	
		Filling version (130÷200µm): 10÷15 minutes of short waves. Priming version (60÷130 µm): 8÷10 minutes of short waves.	
		Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.	

	DRY SANDING Machine sanding: P360÷P500. Hand sanding: P280÷P360.		WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.
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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

V2012 MASTER Acrylic Primer 4:1	– 12 months from the date of production
Hardener 1:4 for Acrylic Filler V2012	– 12 months from the date of production

PRODUCT	ART. No.
V2012 MASTER Acrylic Primer 4:1	(0.8l + 0.2l): 7228; 12452; 13019 (3.75l): 9974; 9973; 9972
Hardener 1:4 for Acrylic Filler V2012	(0.95l): 9975
Thinner for acrylic systems MASTER	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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TROTON Sp. z o.o.
Ząbrowo, Poland.