

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

V2018 HS 5:1

ACRYLIC FILLER HS 5:1

PRODUCTS

Fast Acrylic Filler HS 5:1 V2018
Hardener for Fast Acrylic Filler HS 1:5 V2018
Thinner for acrylic systems.

PRODUCT DESCRIPTION

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

- Short drying time.
- Excellent adhesion to difficult surfaces.
- Easy to mix and apply.
- Exceptional vertical stability.
- Good filling properties.



COLOURS: white, grey, black

GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 430 [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 Primer 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		NUMBER OF LAYERS									
	For car repairs as a filling primer.		2÷3 layers. Approx. 70÷90 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.								
	<table border="1"> <thead> <tr> <th>MIXING RATIO</th> <th>by volume</th> </tr> </thead> <tbody> <tr> <td>Primer</td> <td>5 parts</td> </tr> <tr> <td>Hardener</td> <td>1 part</td> </tr> <tr> <td>Thinner</td> <td>5÷10%</td> </tr> </tbody> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>	MIXING RATIO	by volume	Primer	5 parts	Hardener	1 part	Thinner	5÷10%		HARDENING TIME For thickness of 150÷180 µm: <ul style="list-style-type: none"> • at 20°C: approx. 1 h. • at 60°C: approx. 10 minutes. For thickness of 180÷250 µm: <ul style="list-style-type: none"> • at 20°C: approx. 2 h. Temperature below 20°C significantly increases the hardening time.
MIXING RATIO	by volume										
Primer	5 parts										
Hardener	1 part										
Thinner	5÷10%										
	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.								
	Approx. 65 minutes at 20°C.		DRY SANDING Machine sanding: P360÷P500. Hand sanding: P280÷P320.								
	EVAPORATION TIME Between layers: 5÷10 minutes Before baking: approx. 10 minutes Evaporation time depends on the temperature and the number of layers.		WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.								

FURTHER WORK	
2K acrylic fillers can be directly over coated with: <ul style="list-style-type: none"> • 2K acrylic topcoats. • 1K base coats. 	
GENERAL NOTES	
<ul style="list-style-type: none"> • 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. <p>Caution: <i>To maintain safety, always follow the instructions given in the MSDS for the products.</i></p>	
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. <p>Note:</p> <ol style="list-style-type: none"> 1. <i>After each use the container with product should be immediately closed!</i> 2. <i>Protect the hardener from frost and dampness!</i> 	
WARRANTY PERIOD	
Fast Acrylic Filler HS 5:1 V2018	– 12 months from the date of production
Hardener for Fast Acrylic Filler HS 1:5 V2018	– 12 months from the date of production
Thinner for acrylic systems	– 12 months from the date of production

PRODUCT	ART. No.
Fast Acrylic Filler HS 5:1 V2018	(0.8l + 0.16l): 11953; 12002; 12003 (3l): 12248; 12255; 12256
Hardener for Fast Acrylic Filler HS 1:5 V2018	(0.6l): 12249
Thinner for acrylic systems	300002253; 300002790 (1l; 5l)

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