

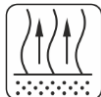
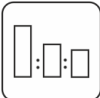









TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>SHS 4:1 ACRYLIC PRIMER</p>	
<p>PRODUCTS</p> <p>SHS Acryl Filler 4:1 – filler for zinc coated steel Hardener 1:4 for SHS Acrylic Filler Thinner for acrylic systems MULTI FÜLLER</p>	
<p>PRODUCT DESCRIPTION</p> <p>Highest quality 2K acrylic filler with excellent adhesion to steel, aluminum, zinc coated steel, polyester putties and old coatings. Designed especially for car body repairs.</p> <ul style="list-style-type: none"> • Excellent adhesion to difficult substrates. • Easy to mix and apply. • Exceptional vertical stability. • Good filling and isolation properties. • Easy to work with. 	<p>COLOURS: white, lightgrey, black</p> <p>GLOSS GRADE: matt</p>

VOLATILE ORGANIC COMPOUNDS	
VOC for 10% thinner = 460 [g/l]	VOC for 20% thinner = 510 [g/l]
This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c) 540 g/l.	
SURFACE PREPARATION	
<p>Acrylic Filler 4:1 can be applied over:</p> <ul style="list-style-type: none"> • Steel and aluminum after sanding and degreasing. • Zinc coated steel after sanding and degreasing. • Sanded polyester-glass fibre (GFK/GRP). • Polyester putties. • Epoxy fillers. • Wash primers. • Old or factory finishes in good condition after sanding and degreasing. 	<p>Good Surface preparation is necessary to achieve the best results of repairs.</p> <p>Recommended sand paper with gradation as follows:</p> <ul style="list-style-type: none"> • sanding by hand (dry or wet): P280÷P320 (GRP P400). • sanding by machine (dry): P180÷P220.

APPLICATION PROCESS			
	USE		EVAPORATION TIME
	For car repairs as a filling or grounding filler.		<p>Between layers: 5÷10 minutes</p> <p>Before baking: 5÷15 minutes</p> <p>Evaporation time depends on the temperature and the number of layers.</p>
	MIXING RATIO by volume		HARDENING TIME
	<p>Filler 4 parts</p> <p>Hardener 1 part</p> <p>Thinner:</p> <p>filling primer 10%</p> <p>grounding primer 20%</p> <p>Stir thoroughly until achieving homogenous mixture.</p>		<p>At 20°C:</p> <p>Filling primer (130÷300 µm):</p> <ul style="list-style-type: none"> • ready to sand after drying overnight. <p>Grounding primer (60÷130 µm):</p> <ul style="list-style-type: none"> • ready to sand after 3÷4 h. <p>At 60°C:</p> <p>Filling primer (130÷300 µm)</p> <ul style="list-style-type: none"> • ready to sand after baking for 35÷40 minutes and cooling down (about 2 h). <p>Grounding primer (60÷130 µm):</p> <ul style="list-style-type: none"> • ready to sand after baking for 25÷30 minutes and cooling down (about 2 h). <p>Temperature below 20°C significantly increases the hardening time.</p>
	SPRAYING VISCOSITY		
	<p>Filling primer: 40÷50 seconds at 20°C/DIN4.</p> <p>Grounding primer: 25÷30 seconds at 20°C/DIN4.</p>		
	POT LIFE		
	Approx. 60 minutes at 20°C.		
	NUMBER OF LAYERS AND RP GUN PARAMETERS		IR DRYING
	<p>Number of layers</p> <p>2÷3 layers; 60÷300µm depending on the size of the gun nozzle.</p> <p>RP gun parameters:</p> <p>Nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars.</p> <p>HVLP gun parameters:</p> <p>Nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.</p>		<ul style="list-style-type: none"> • Filling primer (130÷200 µm): 10÷15 minutes of short waves. • Grounding primer (60÷130 µm): 8÷10 minutes of short waves. <p>Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.</p>

	DRY SANDING Machine standing: P360÷P500. Hand standing: P280÷P320.		WET SANDING Machine standing: P600÷P1000. Hand sanding: P800÷P1000.
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FURTHER WORK

2K acrylic fillers can be directly over coated with:

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

GENERAL NOTES

- Do not exceed recommended doses of hardener!
- Best results achieved at room temperature. The ambient temperature and the temperature of the used product should be the same.
- When working with 2K products, it is recommended to use personal protective equipment. Protect the eyes and the 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 product.*

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. Close the container after use.
2. Protect the hardener from frost and dampness

WARRANTY PERIOD

SHS Acrylic Filler 4:1	– 12 months from the date of production
Hardener 1:4 for SHS Acrylic Filler	– 12 months from the date of production

PRODUCT	ART No.
SHS Acrylic Filler 4:1	(0,8 l + 0,2 l): 2816; 2812; 2813 (3,75l): 10022; 10024; 10023
Hardener 1:4 for SHS Acrylic Filler	(0,94l): 10025

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.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

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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