

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>ACRYL FILLER HS 4:1 ACRYLIC PRIMER</p>	
<p>PRODUCTS</p> <p>Acrylic Primer 4:1 – Acrylic Filler. Hardener 1:4 for Acrylic Filler. Thinner for acrylic systems.</p>	
<p>PRODUCT DESCRIPTION</p> <p>2K acrylic filler for car repairs.</p> <ul style="list-style-type: none"> • Easy to mix and apply. • Very short hardening time. • Good filling properties. 	<p>COLOURS: white, grey, black</p> <p>GLOSS GRADE: matt</p>

<p>VOLATILE ORGANIC COMPOUNDS</p> <p>VOC for the 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.</p>	
<p>SURFACE PREPARATION</p>	
<p>Acrylic primers can be applied over:</p> <ul style="list-style-type: none"> • Bare steel and aluminum after matting and degreasing. • Zinc coated, galvanized steel after matting and degreasing. • Sanded polyester laminates (GFK/GRP). • Polyester putties. • Polyester primers. • Isolation primers. • Old finishes in good condition after matting and degreasing. 	<p>Good surface preparation is necessary for achieving best results.</p> <p>Following sandpaper gradations are recommended:</p> <ul style="list-style-type: none"> • sanding by hand (dry and wet): P280÷P320 (GRP P400). • sanding by machine (dry): P180÷P220.

APPLICATION PROCESS									
	<p>USE</p> <p>For car repairs as a filling or grounding filler.</p>		<p>EVAPORATION TIME</p> <p>Between layers: approx. 5÷10 minutes Before baking: approx. 10 minutes Evaporating time depends on temperature and layer thickness.</p>						
	<p>MIXING RATIO by volume</p> <table border="0"> <tr> <td>Primer</td> <td>4 parts</td> </tr> <tr> <td>Hardener</td> <td>1 part</td> </tr> <tr> <td>Thinner:</td> <td>15÷20%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>	Primer	4 parts	Hardener	1 part	Thinner:	15÷20%		<p>HARDENING TIME</p> <p>Depending on the layer thickness:</p> <ul style="list-style-type: none"> • at 20°C - approx. 3÷4 hours • at 60°C - approx. 30 minutes <p>Temperature below 20°C significantly increases the hardening time.</p>
Primer	4 parts								
Hardener	1 part								
Thinner:	15÷20%								
	<p>SPRAYING VISCOSITY</p> <p>30÷50 seconds at 20°C/DIN4</p>		<p>IR DRYING</p> <p>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.</p>						
	<p>POT LIFE</p> <p>approx. 60 minutes at 20°C</p>								
	<p>NUMBER OF LAYERS AND GUN PARAMETERS</p> <p>2÷3 layers; 150÷300µm.</p> <p>RP gun parameters Nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars.</p> <p>HVLP gun parameters Nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.</p>		<p>DRY SANDING</p> <table border="0"> <tr> <td>Machine sanding:</td> <td>P320÷P500.</td> </tr> <tr> <td>Hand sanding:</td> <td>P280÷P320.</td> </tr> </table>	Machine sanding:	P320÷P500.	Hand sanding:	P280÷P320.		
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			<p>WET SANDING</p> <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 primers can be directly over coated with:

- 2K top coats.
- 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

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

PRODUCTS	ART. No.
Acrylic Primer 4:1 – Acrylic Filler	(0,8l + 0,2l): 2260; 2252; 2253
Hardener 1:4 for Acrylic Filler	
Thinner for acrylic systems	300002258; 300002260 (1l; 5l)
Thinner for acrylic systems – slow	14712 (5l)
Thinner for acrylic systems – fast	14713 (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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