

**TECHNICAL INFORMATION**

FOR PROFESSIONAL USE ONLY

**RAPID HS 4:1**

ACRYLIC PRIMER

**PRODUCTS****RAPID HS 4:1** - Fast Acrylic FillerHardener **RAPID HS 1:4** for Acrylic FillerThinner for acrylic systems **MULTI FÜLLER****PRODUCT DESCRIPTION**

High quality 2K fast-drying acrylic primer with added anti-corrosive agents, designed for automotive body repairs. The primer features high solids content, excellent filling properties and very short curing time - ready for sanding just 1 hour after application (at 20°C). Additionally, it offers excellent adhesion to difficult substrates and easy application.

- Very short curing time (1h/20°C after application).
- Excellent filling properties.
- Excellent adhesion to difficult substrates.
- Anti-corrosive properties.
- Easy application.

**COLOUR:** white,, grey, black**GLOSS GRADE:** matt**VOLATILE ORGANIC COMPOUNDS**

VOC for mixture = 420 [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 **RAPID HS 4:1** can be applied over:

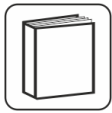

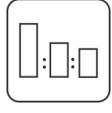



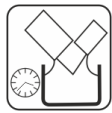

- Steel and aluminum after flatting and degreasing.
- Zinc coated steel after flatting and degreasing.
- Sanded polyester-glass laminates (GFK/GRP).
- Polyester putties.
- Epoxy primers.
- Wash primers.
- Old finishes in good condition after flatting and degreasing.

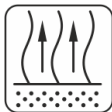

Good preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

- Sanding by hand (dry or wet): P280÷P320 (GRP P400).
- Sanding by machine (dry): P180÷P220.

**APPLICATION PROCESS**

<b>USE</b>		<b>NUMBER OF LAYERS</b>	
	Filling acrylic primer designed for car body repairs		2÷3 layers. Approx. 70÷90 µm for one layer.  <b>Gun parameters:</b> 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.
<b>MIXING RATIO</b> by volume		<b>HARDENING TIME</b>	
	Primer 4 Hardener 1 Thinner 5%  Stir thoroughly until achieving homogenous mixture.		<b>For thickness of 150÷180 µm:</b> <ul style="list-style-type: none"><li>• at 20°C: approx. 1 h.</li><li>• at 60°C: approx. 10 minutes.</li></ul> <b>For thickness of 180÷250 µm:</b> <ul style="list-style-type: none"><li>• at 20°C: approx. 2 h.</li></ul> Temperature below 20°C significantly increases the hardening time.
<b>SPRAYING VISCOSITY</b>		<b>IR DRYING</b>	
	30÷50 seconds at 20°C/DIN4.		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.
<b>POT LIFE</b>		<b>DRY SANDING</b>	
	Approx. 65 minutes at 20°C.		Machine sanding: P360÷P500. Hand sanding: P280÷P320.

	<b>EVAPORATION TIME</b>		<b>WET SANDING</b>
	Between layers: 5÷10 minutes Before baking: approx. 10 minutes  Evaporation time depends on the temperature and the number of layers.		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**

<b>RAPID HS 4:1</b> - Fast Acrylic Filler	– 12 months from the date of production
Hardener <b>RAPID HS 1:4</b> for Acrylic Filler	– 12 months from the date of production
Thinner for acrylic systems <b>MULTI FÜLLER</b>	– 24 months from the date of production

PRODUCT	ART. No.
RAPID HS 4:1 - Fast Acrylic Filler	(0,8l + 0,2l) : 16512; 16513; 16514 (3,6l) : 16516, 16517, 16518
Hardener RAPID HS 1:4 for Acrylic Filler	(0,9l) : 16522
Thinner for acrylic systems <b>MULTI FÜLLER</b>	300002258; 300002260 (1l; 5l)
Thinner for acrylic systems – slow <b>MULTI FÜLLER</b>	14712 (5l)
Thinner for acrylic systems – fast <b>MULTI FÜLLER</b>	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.

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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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