

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

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

VOLATILE ORGANIC COMPOUNDS	
VOC for 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.	
SURFACE PREPARATION	
Acrylic Filler 4:1 can be applied over: <ul style="list-style-type: none"> • Steel and aluminum after flattening and degreasing. • Sanded polyester-glass laminates (GFK/GRP). • Polyester putties. • Polyester primers. • Isolation primers. • Wash primers. • Old finishes in good condition after flattening and degreasing. 	Good surface preparation is necessary for achieving best results. Following sandpaper gradations are recommended: <ul style="list-style-type: none"> • by hand (dry or wet): P280÷P320 (GRP P400). • by machine (dry): P180÷P220.

APPLICATION PROCESS									
	USE		NUMBER OF LAYERS AND RP GUN PARAMETERS						
	For car repairs as a filling primer.		2÷3 layers; 150÷300µm. RP gun parameters: Nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP gun parameters: Nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.						
	MIXING RATIO		HARDENING TIME						
	<table border="0"> <tr> <td>Filler:</td> <td>4</td> </tr> <tr> <td>Hardener:</td> <td>1</td> </tr> <tr> <td>Thinner:</td> <td>15÷20%</td> </tr> </table> Stir thoroughly until achieving homogenous mixture.	Filler:	4	Hardener:	1	Thinner:	15÷20%		For thickness of 200µm: <ul style="list-style-type: none"> • 3-4 hours at 20°C • 30 minutes at 60°C Temperature below 20°C significantly increases the hardening time.
Filler:	4								
Hardener:	1								
Thinner:	15÷20%								
	SPRAYING VISCOSITY		IR DRYING						
	Approx. 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.						
	POT LIFE								
	Approx. 60 minutes at 20°C.								
	EVAPORATION TIME		DRY SANDING						
	<table border="0"> <tr> <td>Between layers:</td> <td>approx. 5 minutes</td> </tr> <tr> <td>Before banking:</td> <td>approx. 10 minutes</td> </tr> </table> Evaporation time depends on the temperature and the number of layers.	Between layers:	approx. 5 minutes	Before banking:	approx. 10 minutes		Machine sanding: P360÷P500. Hand sanding: P280÷P320.		
Between layers:	approx. 5 minutes								
Before banking:	approx. 10 minutes								
			WET SANDING						
			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 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 Filler 4:1	- 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

PRODUCT	ART. No.
Acrylic Filler 4:1	(0,8l + 0,2l): 1334; 1345; 1353
	(3,6l): 9601; 11626; 11627
	(4l): 4833; 6376; 6375
Hardener 1:4 for Acrylic filler	9602 (0,9l); 4835 (1l)
Thinner for acrylic systems.	300002236 (1l); 300002237 (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.

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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