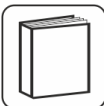


TECHNICAL DATA SHEET

FOR PROFESSIONAL USE ONLY

FILL UP 2K POLYESTER PRIMER	
PRODUCTS	
FILL UP – 2K polyester primer Hardener for FILL UP 2K polyester primer Reducer for polyester primers INTER TROTON	
PRODUCT DESCRIPTION Troton high build 2K polyester primer with very good isolating properties. Characterized by easy spray gun application and very easy sanding. Excellent for blending multiple repairs and eliminating ripples. Its main advantages are easy application and sanding, high built properties, short hardening time. Perfectly isolates primers and top coats from polyester body fillers. Available in light grey.	
COLOUR: light tgrey	
GLOSS GRADE: matt	
DENSITY: 1.55 (+/- 0.03) kg/l	

VOLATILE ORGANIC COMPOUNDS	
VOC for the mixture = 437 [g/l] – 3.648 [lb/gal] 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	
The product has very good adhesion to various surfaces. It can be applied over: - Bare steel and aluminum after flatting and degreasing. - Sanded glass fibre (GFK/GRP), polyester putties and body fillers, urethane and epoxy primers, existing coatings in good condition.	We recommend sandpaper with gradations: P180÷P320. Caution: Do not apply the putty directly on the reactive primers, 1K acrylic and nitrocellulose products.

APPLICATION PROCESS			
	USE It is dedicated for filling small scratches left from application of polyester putties and body fillers , in order to isolate urethane coatings from polyester putties/body fillers.		APPLICATION PARAMETERS Number of layers: 1÷3 layers Gun parameters: Nozzle: 2.0÷3.0 mm Pressure: According to the the gun producer's recommendations. Usually 2.0÷2.5 bars. Film thickness: Do not exceed the thickness of 200µm (7.87 mils) of a wet film. Do not exceed a total dry film thickness of 600 µm (23.6 mils).
	MIXING RATIO by volume Primer 100 parts Hardener 4.5 parts Reducer max. 10% Stir thoroughly until achieving homogenous mixture.		FLASH-OFF TIME Between layers: approx. 5 minutes Before baking: approx. 10 minutes Evaporation time depends on the temperature and the thickness of layers.
	SPRAYING VISCOSITY 50 (+/-5) seconds at 20°C (68°F) Pot life: 20 (+/-3) minutes at 20°C (68°F)		IR DRYING 5÷7 minutes of short waves, depending on the layer thickness and the type of radiator. Do not exceed the temperature of 60°C (140°F). Use as recommended by the equipment manufacturer. Wait about 5 minutes before the IR drying process.
	SANDING Finishing sanding (dry): P180÷P320		HARDENING TIME 2-3 hours at 20°C (68°F) 25-30 minutes at 60°C (140°F) Temperature below 20°C (68°F) significantly increases the hardening time.

**Caution:** Stir well before using!**PRODUCT EFFICIENCY**

1 liter of mixture is enough to cover 8 m² yielding a dry film thickness of 100 µm (3.94 mils).

FURTHER WORK

Polyester primers can be overcoated with:

- 2K urethane primers,
- 2K epoxy fillers.

GENERAL NOTES

- Excessive amount of hardener will cause problems with bleaching of the topcoat!
- 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 (59 to 77°F) 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 it from overheating!

WARRANTY PERIOD

FILL UP – 2K polyester primer	– 12 months from the date of production
Hardener for the polyester primer	– 12 months from the date of production

PRODUCT	ART. No.
FILL UP – polyester primer	14770 (3.75l)

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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