

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

Acryl Filler 1K

PRODUCTS

Acryl Filler 1K
Thinner for acrylic systems

PRODUCT DESCRIPTION

1-pack acrylic high build primer for car repairs.

- ✓ Easy to use.
- ✓ Short drying time.
- ✓ Good filling properties.

Color - Gray, white, beige.
Gloss Grade – Matt.
Density – 1,46 kg/l.

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 533 [g/l]

The share of VOC is below 540 g/l. Due to that these products fulfill the EU directive (2004/42/EC) that sets the VOC value for this product category (B/3), as 540 g/l.

SUBSTRATES AND PREPARATION

1K Acryl Filler can be applied on:


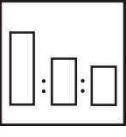
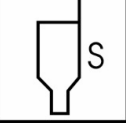

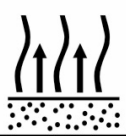

- ✓ Bare steel and aluminum.
- ✓ Plastics.
- ✓ 2-pack polyester putties, polyester spraying fillers.
- ✓ Polyester laminates (GFK/GRP).
- ✓ Old finishes in good condition.


Steel surface should be first degreased, dry sanded and degreased again.
 The aluminum should be degreased, dulled with the abrasive cloth and degreased again.
 The old coatings should be degreased, dry sanded and degreased again.

Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended:

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

APPLICATION PROCESS

	<p>USE For car repairs, as a filling or grounding primer.</p>								
	<table border="0"> <tr> <td>Mixing ratio</td> <td>by volume</td> </tr> <tr> <td>Filler</td> <td>1</td> </tr> <tr> <td>Thinner</td> <td>5% (filling primer)</td> </tr> <tr> <td></td> <td>15% (grounding primer)</td> </tr> </table>	Mixing ratio	by volume	Filler	1	Thinner	5% (filling primer)		15% (grounding primer)
Mixing ratio	by volume								
Filler	1								
Thinner	5% (filling primer)								
	15% (grounding primer)								
	<p>Spraying viscosity approx. 50 seconds at 20°C for filling primer. approx. 30 seconds at 20°C for grounding primer.</p>								
	<p>Nozzle Gravity: 1,6÷1,8 mm. Pressure: According to gun`s producer recommendations. Number of layers: 2÷3 layers.</p>								
	<p>Evaporation time between layers approx. 5 minutes before baking approx.10 minutes (to matt)</p>								
	<p>Drying time Specific dryness at 20°C: approx. 40 minutes Specific dryness at 60°C: approx. 15 minutes</p> <p>Temperature below 20°C significantly increases the drying time.</p>								

	Hand sanding	Machine sanding
	P280÷P320 (dry) P600÷P800 (wet)	P360÷P500 (dry) P600÷P1000 (wet)

FURTHER WORKS

1K acryl fillers can be directly over coated with:

- ✓ 2-pack acryl topcoats.
- ✓ 1-pack basecoats.

GENERAL NOTES

- ✓ The best repair results you can achieve at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ The rooms should be well ventilated.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: *After each use the container with products shall be immediately closed!*

WARRANTY PERIOD

Acryl Filler 1K - 12 months from the date of Manufacture.

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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