












**TECHNICAL INFORMATION**

FOR PROFESSIONAL USE ONLY

<b>ACRYL FILLER 5:1</b>	
<b>PRODUCTS</b>	
Acrylic Filler 5:1 - Primer Premium Hardener 1:5 for Acrylic Filler Thinner for acrylic systems INTER TROTON	
<b>PRODUCT DESCRIPTION</b>	
2K acrylic filler for car repairs designed for car body repairs. <ul style="list-style-type: none"> <li>• Very short hardening time.</li> <li>• Good filling properties.</li> <li>• Easy and quick sanding.</li> </ul>	<b>COLOUR:</b> lightgrey, white, black <b>GLOSS GRADE:</b> matt

<b>VOLATILE ORGANIC COMPOUNDS</b>	
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.	
<b>SURFACE PREPARATION</b>	
Acrylic Filler 5:1 can be applied over: <ul style="list-style-type: none"> <li>• Steel and aluminum after flatting and degreasing.</li> <li>• Sanded polyester-glass laminates (GFK/GRP).</li> <li>• Polyester putties.</li> <li>• Polyester primers.</li> <li>• Isolation primers.</li> <li>• Old finishes in good condition after matting and degreasing.</li> </ul>	Good surface preparation is necessary for achieving best results.  Following sandpaper gradations are recommended: <ul style="list-style-type: none"> <li>• by hand (dry or wet): P280÷P320 (GRP P400).</li> <li>• by machine (dry): P180÷P220.</li> </ul>

<b>APPLICATION PROCESS</b>			
	<b>USE</b>		<b>NUMBER OF LAYERS</b>
	For car repairs as a filling primer		2÷3 layers. <b>RP gun parameters:</b> Nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. <b>HVLP gun parameters:</b> Nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.
	<b>MIXING RATIO</b> by volume		<b>EVAPORATION TIME</b>
	Filler: 5 Hardener: 1 Thinner: 25÷30%  Stir thoroughly until achieving homogenous mixture.		Between layers: approx. 5 minutes Before banking: approx. 10 minutes Evaporation time depends on the temperature and the number of layers.
	<b>SPRAYING VISCOSITY</b>		<b>POT LIFE</b>
	Approx. 30÷50 seconds at 20°C/DIN4.		Approx. 60 minutes at 20°C.
	<b>HARDENING TIME</b>		<b>IR DRYING</b>
	For thickness of 200µm: <ul style="list-style-type: none"> <li>• 3-4 hours at 20°C</li> <li>• 30 minutes at 60°C</li> </ul> Temperature below 20°C significantly increases the hardening time.		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>DRY SANDING</b>		<b>WET SANDING</b>
	Machine sanding: P360÷P500. Hand sanding: P280÷P320.		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 5:1	– 12 months from the date of production
Hardener 1:5 for Acrylic filler	– 12 months from the date of production

PRODUCT	ART. No.
Acrylic Filler 5:1	(0,5l): 1525; 1428; 1519; 1380; 1491 (0,8l + 0.16l): 1578; 1418; 1574; 1374; 1577 (2,5l + 0,5l): 1443; 1553; 1431; 1404
Hardener 1:5 for Acrylic filler	1920 (0,1l)
Thinner for acrylic systems INTER TROTON	300002236; 300002237 (1l; 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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