



Technical Data Sheet

ACRYLIC FILLER 4:1

Acrylic filler with anti-corrosion additives

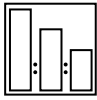

FILLER HARDENER
THINNER









RELATED PRODUCTS

Acrylic filler hardener
Acrylic and polyurethane thinner

PROPERTIES

- A product designed and dedicated for renovation of classic cars
 - Universal acrylic filler
- Excellent anti-corrosion properties
- Can be used as a filler or insulator
 - Excellent dry machine sanding
 - Smooth surface

| SUBSTRATES | | | | | | | |
|--|--|---|--------------|-----------------|--------------|--------------------|--------------|
| Old paint coatings, including thermoplastic paints | | Degrease and dry sand with P220 – P360. | | | | | |
| Polyester putties | | Dry sand, finishing levelling with P240 – P320. | | | | | |
| Epoxy primers | | No sanding for up to 12 hours, sand with P320 afterwards. | | | | | |
| Steel | | Degrease and dry sand with P120. | | | | | |
| Stainless steel | | Degrease. | | | | | |
| Original elements with cathaphoretic coating. | | Degrease with SILICON REMOVER, no sanding is necessary. | | | | | |
| Wash primers | | Apply after drying. | | | | | |
| Polyester laminates | | Degrease and dry sand with P280. | | | | | |
| MIXING RATIO | | | | | | | |
|  | ACRYLIC FILLER 4:1 FILLER HARDENER THINNER | Filling version | | Priming version | | Wet on wet version | |
| | | Volume ratio | Weight ratio | Volume ratio | Weight ratio | Volume ratio | Weight ratio |
| | | 4 | 100 | 4 | 100 | 4 | 100 |
| | | 1 | 17 | 1 | 17 | 1 | 17 |
| | | 15% | 7.5 | 25% | 15 | 38% | 22 |
| Apply the thinner in the amount calculated for the primer. | | | | | | | |
| VISCOSITY | | | | | | | |
|  | DIN 4/20°C | Filling version | | Priming version | | Wet on wet version | |
| | | 35 – 50 s | | 25 – 35 s | | 18 – 21 s | |
| CONTENT OF VOLATILE ORGANIC COMPOUNDS | | | | | | | |
| VOC II/B/c limit* | | | | 540 g/l | | | |
| VOC actual, filling version | | | | 510 g/l | | | |
| VOC actual, priming version | | | | 539 g/l | | | |
| Actual VOC content, wet on wet version | | | | 590 g/l | | | |
| * For ready to use mixture acc. to EU Directive 2004/42/CE | | | | | | | |
| APPLICATION CONDITIONS | | | | | | | |
| It is recommended to apply the primer at a temperature above 15°C and a humidity of no more than 80 %. | | | | | | | |

| APPLICATION | | | | |
|--|--|--|---------------------------------|--------------------|
|  CAUTION: Instructions of the equipment manufacturer must be followed. | Conventional gravity fed spray gun | Nozzle | Pressure | Distance |
| | Filling and priming versions | 1.6 – 1.8mm | 3 – 4 bar | 15 – 20 cm |
| | Wet on wet version | 1.2 – 1.4mm | 3 – 4 bar | 15 – 20 cm |
| | Low-pressure gravity fed spray gun | | | |
| | Filling and priming versions | 1.6 – 1.7 mm | 2 bar | 10 – 15 cm |
| | Wet on wet version | 1.4 – 1.6 mm | 2 bar | 10 – 15 cm |
|  | Number of layers | 1–3 | | |
| | Single dry layer thickness | Filling version | Priming version | Wet on wet version |
| | | 50 – 70 µm | 30 – 50 µm | 20 – 30 µm |
| The yield of the ready to use mixture for the given range of dry layer thickness | 4.1 m ² /l at 100 µm | 7.8 m ² /l at 50 µm | 11.2 m ² /l at 30 µm | |
|  | Mixture life at 20°C | 1 h | | |
|  | Flash-off time between layers | 5 – 10 min | | |
| CURING TIME | | | | |
|  | 20°C | 60°C | | |
| | 3 h | 30 min | | |
| CAUTION: The curing times apply to the temperatures of the individual elements. | | | | |
| IR DRYING | | | | |
|  | Distance | Follow the recommendations of the equipment manufacturer | | |
| | Time depending on the type and power of the lamp | 10 – 20 min | | |
| CAUTION: Start IR heating after at least 10 mins from applying the last coat. | | | | |
| SANDING | | | | |
|  | Dry sanding | P360 – P500 | | |
|  | Wet sanding | P600 – 1000 | | |



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| | |
|--|----------------|
| COLOUR | |
| Grey | |
| EQUIPMENT CLEANING | |
| THINNER acrylic and polyurethane thinner or NC solvent. | |
| STORAGE CONDITIONS | |
| Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight. | |
| SHELF LIFE | |
| ACRYLIC FILLER 4:1 | 24 months/20°C |
| FILLER HARDENER | 12 months/20°C |
| THINNER | 24 months/20°C |
| SAFETY | |
| See Safety Data Sheet. | |
| OTHER INFORMATION | |
| The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a trial/test application of the product due to the potential variation of product performance between substrate materials. We may not be held liable for defects if final results were affected by factors beyond our control. | |

ADDITIONAL INFORMATION

| WEIGHT QUANTITY OF COMPONENTS: 4+1+15% filling version | | | |
|---|--------------------|-----------------|---------|
| CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components. | | | |
| Mixture amount | ACRYLIC FILLER 4:1 | FILLER HARDENER | THINNER |
| 0.10 l | 109 g | 18 g | 10 g |
| 0.15 l | 164 g | 27 g | 14 g |
| 0.20 l | 218 g | 36 g | 19 g |
| 0.25 l | 273 g | 45 g | 24 g |
| 0.30 l | 327 g | 53 g | 29 g |
| 0.40 l | 437 g | 71 g | 38 g |
| 0.50 l | 546 g | 89 g | 48 g |
| 0.75 l | 819 g | 133 g | 71 g |
| 1.00 l | 1091 g | 178 g | 95 g |



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WEIGHT QUANTITY OF COMPONENTS: 4+1+25% priming version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

| Mixture amount | ACRYLIC FILLER 4:1 | FILLER HARDENER | THINNER |
|----------------|--------------------|-----------------|---------|
| 0.10 l | 102 g | 17 g | 15 g |
| 0.15 l | 153 g | 25 g | 22 g |
| 0.20 l | 204 g | 33 g | 30 g |
| 0.25 l | 255 g | 42 g | 37 g |
| 0.30 l | 306 g | 50 g | 45 g |
| 0.40 l | 408 g | 66 g | 59 g |
| 0.50 l | 509 g | 83 g | 74 g |
| 0.75 l | 764 g | 125 g | 111 g |
| 1.00 l | 1019 g | 166 g | 148 g |

WEIGHT QUANTITY OF COMPONENTS: 4+1+38% wet on wet version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

| Mixture amount | ACRYLIC FILLER 4:1 | FILLER HARDENER | THINNER |
|----------------|--------------------|-----------------|---------|
| 0.10 l | 94 g | 15 g | 21 g |
| 0.15 l | 141 g | 23 g | 31 g |
| 0.20 l | 188 g | 31 g | 41 g |
| 0.25 l | 235 g | 38 g | 52 g |
| 0.30 l | 281 g | 46 g | 62 g |
| 0.40 l | 375 g | 61 g | 83 g |
| 0.50 l | 469 g | 76 g | 104 g |
| 0.75 l | 703 g | 115 g | 155 g |
| 1.00 l | 937 g | 153 g | 207 g |