

**TECHNICAL DATA SHEET**

## Acrylic filler M+M

Acrylic filler M+M is a product intended for wet to wet working system. Acrylic or base coats are applied on the surface of unhardened and unsanded filler. It is possible thanks to excellent fluidity of the filler, which, when applied, results in perfectly smooth surface. The main advantage of this product is reduction of coating time. Its adhesion, isolation and anti corrosion properties are as good as in case of other our fillers. This product is to be applied in thin layers so it requires perfectly prepared surface as its ability to fill in scratches is quiet poor.

### GROUND TYPES

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- ◆ old paint coats including thermoplastic coats
- ◆ polyester putties
- ◆ steel
- ◆ aluminium
- ◆ galvanized steel
- ◆ stainless steel
- ◆ wash primers
- ◆ plastics
- ◆ polyester laminates

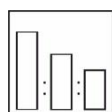
### SURFACE PREPARATION

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- ◆ old paint coats should be degreased and sanded with P220 - P360 paper,
- ◆ polyester putties should be dry sanded for final smoothing with P240 – P320 paper,
- ◆ steel surfaces should be degreased and sanded with P120 - P240 paper,
- ◆ aluminium surfaces should be degreased, matted with abrasive needled cloth and degreased again,
- ◆ galvanized surfaces should be degreased, matted with very fine abrasive needled cloth and degreased again.
- ◆ stainless steel should be degreased,
- ◆ plastics should be wiped with Silicone remover RANAL and matted with abrasive needled cloth, degreased again and covered with Adhesion increasing agent RANAL and Elasticity increasing agent RANAL,
- ◆ polyester laminates should be degreased and sanded with P280 paper.

## TECHNICAL DATA SHEET

### MIXING RATIO



#### Sanding version

	By volume	By weight
Filler	3	100
Hardener	1	21

#### „wet on wet”

Filler		
Hardener	3	100
Thinner	1	21
	1	20

**ATTENTION!** Use Thinner for acrylic products RANAL.

### INSTRUCTION FOR USE

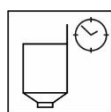
#### Sanding version:

Apply two or three single wet layers, leaving them for evaporation for 5-10 minutes after each application. Evaporation time depends on temperature and thickness of the coat.

#### Wet on wet version:

Apply two single wet layers, leaving them for evaporation for 10-15 minutes after each application. Evaporation time depends on temperature and thickness of the coat.

### SPRAYING VISCOSITY



#### Sanding version:

DIN 4/20°C 25÷30 s

#### Wet on wet version:

DIN 4/20°C 16÷18 s

### NOZZLE, WORKING PRESSURE



#### Sanding version:

Ø1.6÷1.8mm, 3÷4 bar

#### Wet on wet version:

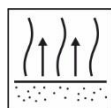
Ø1.2÷1.4mm, 3÷4 bar

### ATTENTION!

Sanding version: 25÷40 µm for each layer.

Wet on wet version: 15÷25 µm for each layer.

### EVAPORATION TIME

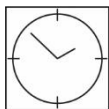


5 – 10 min.

## TECHNICAL DATA SHEET

### DRYING TIME

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**Sanding version:**

3 hours in 20°C;  
30 min in 60°C, for the thickness of 75-120 µm.

### SANDING

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Mechanical dry sanding: P360 – P500  
Hand dry sanding: P400 – P500



Mechanical wet sanding: P600 – P1000  
Hand wet sanding: P800 – P1000

### CONTENT OF VOLATILE ORGANIC COMPOUNDS

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VOC II/B/c limit = 540 g/L

**Sanding version:**

VOC effective= 520 g/L

**“Wet on wet” version:**

VOC effective= 600g/l

### COLOUR

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grey

### THEORETICAL EFFICIENCY

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**Sanding version**

A set (1 litre of the filler + hardener in adequate proportion) allows obtaining about 5m<sup>2</sup> of dry coat 100µm thick.

**„Wet on wet” version**

A set (1 litre of the filler + hardener in adequate proportion) allows obtaining about 12m<sup>2</sup> of dry coat 40µm thick.

### TOOLS CLEANING

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NITRO or Thinner for acrylic products RANAL

### STORAGE CONDITIONS

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Store in a dark and dry place away from sources of fire and heat. The shelf life in original package in temperature 20°C is 24 months for the filler and 12 months for the hardener.

## TECHNICAL DATA SHEET

### HEALTH AND SAFETY RECOMMENDATIONS

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According to Safety Data Sheet of Dangerous Substance for particular product.

### PACKAGING

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Art. No	Capacity	Package, pieces:	Package weight, kg:
10801	1L+0,34L hardener	6	12,6

This information is based on careful, laboratory research and our long-standing experience. Strong market position does not absolve us from constant control of the quality of our products. However, we are not responsible for the final results after incorrect use of the product.