

TECHNICAL DATA SHEET**Acrylic filler 3:1 HS**

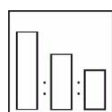
Two component filler based on high quality acrylic resins. Easy mixing process. Characterized by short drying time, it is excellent to sand and has good filling properties, thanks to which it is possible to fill in scratches which appear during the sanding process. It is an ideal ground to guarantee excellent look of coated layers.

GROUND TYPE

- ◆ old paint coats,
- ◆ polyester putties,
- ◆ steel,
- ◆ wash primers,
- ◆ epoxy primers,
- ◆ plastics,
- ◆ polyester laminates.

SURFACE PREPARATION

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

MIXING RATIO

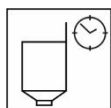
	By volume	By weight
Filler	3	100
Hardener	1	21
Thinner	0% - 5%	0 - 5

ATTENTION! Recommended Thinner for acrylic products RANAL.

TECHNICAL DATA SHEET**INSTRUCTION FOR USE**

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 layer. 10 minutes after the application of the last layer the coat can be cured in higher temperature.

SPRAYING VISCOSITY

**Filling system:**

0-5% of the Thinner for acrylic products
DIN 4/20°C about 50s

Priming system:

20% of the Thinner for acrylic products
DIN 4/20°C about 35s

NOZZLE, WORKING PRESSURE

**Filling system:**

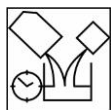
0-5% of the Thinner for acrylic products
Ø 1.6÷1.8 mm, 1,8÷2,2 bar

Priming system:

20% of the Thinner for acrylic products
Ø 1.6÷1.8 mm, 1,8÷2,2 bar

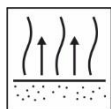
ATTENTION! Layer thickness about 40 – 50 µm for each layer.

POT LIFE ONCE MIXED WITH HARDENER



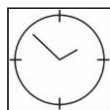
about 1h in the temperature of 20°C

EVAPORATION TIME



5 – 10 min.

TECHNICAL DATA SHEET**DRYING TIME**



3 hours in the temperature of 20°C
30 min. in the temperature of 60°C.

SANDING



Dry sanding: P360 – P500



Wet sanding: P600 – P1000

CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC II/B/c= 540g/L, VOC = 538 g/L

THEORETICAL EFFICIENCY

A set (1 litre of the filler + hardener in adequate proportion) allows obtaining about 4 m² of a dry coat 100 µm thick.

TOOLS CLEANING

NITRO or Thinner for acrylic products RANAL.

STORAGE CONDITIONS

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.

HEALTH AND SAFETY RECOMMENDATIONS

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

TECHNICAL DATA SHEET**PACKAGING**

Art. No	Capacity, L	Package, pieces:	Package weight, kg:
10310	1 + hard. 0,34	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.