

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

PRIMER FILLER 4:1

ACRYLIC PRIMER 4:1



COLOURS: grey

GLOSS GRADE: matt

PRODUCTS

SPEC PRIMER FILLER 4:1 Acrylic Primer
 SPEC HARDENER 1:4 for PRIMER FILLER
 SPEC UNIVERSAL THINNER Acrylic Systems

PRODUCT DESCRIPTION

2K high build acrylic primer designed for the repair of commercial vehicles and all means of transport. It features very good stability on vertical surfaces. To be used with wash primer as anti-corrosion protection for steel surfaces or as an intermediate layer in epoxy-polyurethane systems.

- Easy mixing and application process.
- Short curing time.
- Very good filling properties.
- Excellent coverage and flow.
- Easy and quick processing.
- High efficiency.

VOLATILE ORGANIC COMPOUNDS

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.

SURFACE PREPARATION

SPEC Primer Filler 4:1 can be applied over:

- Sanded polyester-glass laminates (GFK/GRP).
- Polyester putties.
- Epoxy primers.
- Isolation primers.
- Wash primers.
- Old or new finishes after flattening and degreasing.

Good surface preparation is necessary for achieving best results.




Following sandpaper gradations are recommended:

- Sanding by hand (dry): P180÷P320.
- Sanding by machine (dry): P240÷P320.

METHOD OF APPLICATION

- pneumatic spraying
- airless spraying

APPLICATION PROCESS

USE		NUMBER OF LAYERS AND SPRAYING PARAMETERS	
 <p>Primer filler for the repair of all means of transport incl. commercial vehicles.</p>			Number of layers: 1÷3 layers Recommended coating thickness: 150÷300 µm dry (200÷400 µm wet) Pneumatic spraying Gun parameters RP/HVLP Nozzle: 1,6÷2,2 mm; Inlet pressure: 2,0÷2,5 bar Airless spraying with air jacket* Nozzle: 0,33÷0,38 mm; Pressure: 100÷160 bar; air jacket: 2 bar *depending of the recommendations of the equipment manufacturer
	MIXING RATIO by volume Primer 4 parts Hardener 1 part Thinner 15÷20% Stir thoroughly until achieving homogenous mixture.		

	SPRAYING VISCOSITY Approx. 30÷50 seconds at 20°C/DIN4.		IR DRYING 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.
	POT LIFE Approx. 60 minutes at 20°C.		DRY SANDING Hand sanding: P280÷P320 Machine sanding: P320÷P400
	EVAPORATION TIME Between layers: approx. 5 minutes Before baking: approx. 10 minutes Evaporation time depends on the temperature and the number of layers.		

FURTHER WORK

2K acrylic primers can be directly over coated with following Troton products:

- 2K acrylic topcoats.
- 1K basecoats

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.
- The product cannot be applied over wash primers and 1K primers.

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

SPEC PRIMER FILLER 4:1	– 12 months from the date of production
SPEC HARDENER PRIMER FILLER 1:4	– 12 months from the date of production
SPEC UNIVERSAL THINNER Acrylic Systems	– 12 months from the date of production

PRODUCT	Art. No.
SPEC PRIMER FILLER 4:1	16530 (3,6l)
SPEC HARDENER PRIMER FILLER 1:4	16531 (0,9l)
SPEC UNIVERSAL THINNER Acrylic Systems - STANDARD (18-25°C)	300010563 (5l standard)
SPEC UNIVERSAL THINNER Acrylic Systems - FAST (< 18°C)	16525 (5l fast)
SPEC UNIVERSAL THINNER Acrylic Systems - SLOW (>25°C)	16526 (5l slow)

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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