



VOC FILLER 4:1

Product code 20320, 20330, 20340, 20350, 20400, 20420
TDS code TDS410-EN
TDS date V1 - 13.1.2008

Product	⇒ VOC Filler 4:1
Colour	⇒ 20320 white, 20330 light grey, 20340 dark grey, 20350 black
Product description	⇒ high solid primer filler for car and truck refinish with high filling power ⇒ excellent adhesion, high corrosion protection, fast drying ⇒ very easy to sand, wet or dry sanding
Use for	⇒ car- and commercial vehicle refinishing
Resin	⇒ isocyanate-crosslinking hydroxi-acrylic resin
Substrate	⇒ primed steel, aluminum, OE-paint, zinc-plated steel ⇒ all substrates must be dry, free of grease and any dirt
Application	⇒ conventional guns: 1,5-2,0 mm nozzle, 3-5 bar hose pressure, 15-20% standard 2K acrylic thinner ⇒ HVLP: 1,7-2,2 mm nozzle, 2-3 bar hose pressure, 0,7 bar nozzle pressure, 5 % standard 2K acrylic thinner ⇒ 1-2 spray passes, total film build 60-90 µm dry film
Viscosity	⇒ 25-30 sec. 4 mm / DIN (ready for use)
Mixing ratio	⇒ 4:1 by volume
Hardener	⇒ filler-hardener 80805
Thinner	⇒ Thinner 40610, 40620, 40630 (5-15%, see above)
Pot life	⇒ 1-2 hours at 20°C
Drying time at 21° C	⇒ touchable after 30 min. ⇒ sanding after 3-5 hours (dry sanding P 400)
Drying time at 60° C	⇒ flash off time ca. 10 min., 20-30 min. at 60° object temperature ⇒ sanding right after cooling down (dry sanding P 400)
Specific weight	⇒ ca. 1,6 g/cm ³
VOC	⇒ 2004/42/IIIB(c)(540)535
Shelf life	⇒ 1 year at 20°C in closed can
Flashpoint	⇒ > +23 °C
Special instructions	⇒ wet-on-wet possible by adding ca. 25-30% thinner, 2-3 spray passes 30-40 µm each only, flash off 10 min. until matt. Loss of topcoat-brilliance to be expected.