

FILLER GREY 5:1 PRO45110



v.01-05.2022

CHARACTERISTICS:

Two-component acrylic filler, characterized by good filling power and quick drying time at ambient temperature (2.5-3h/20°C). Easy to apply, creates a smooth coating without runs. Distinguished by very good sanding properties. Equipped with anticorrosive additives. Recommended on steel, zinc, aluminium, old paint coatings and polyester putties. It can be covered with water- or solventborne base coats. Available also in 6:1 mixing ratio.

APPLICATION:

The surface being repaired must be clean, dry, matted and degreased. Measure out the A+B mixture by volume: 5 parts of filler (A) and 1 part of hardener (B). Add a thinner for acrylic products (C) in an amount 10 vol% of component A+B, then mix thoroughly. Apply with a spray gun (spray nozzle 1.6 - 1.8 mm) in 2 layers with 10 minutes break to evaporate solvents before applying the next layer.

TECHNICAL DATA:

VOC 2004/42/II B(c)(540) max. 540 g/l

Filler CPG-02.166:

Shelf life: 12 months Density (20°C): 1.48 – 1.50 g/cm³ Colour: grey

Hardener CDL-04.093:

Shelf life: 12 months Density (20°C): 0.93 – 0.94 g/cm³ Colour: colourless/slightly yellow

Thinner standard CDL-07.002:

Shelf life: 24 months Density (20°C): 0.88 – 0.90 g/cm³ Colour: colourless

MIXING RATIO			
		by volume	by weight
	Filler (A)	5	100 g
	Hardener (B)	1	12.5 g
	Thinner (C)	10 vol% of A+B	7 g
SPRAYING VISCOSITY			
	DIN cup 4 mm (20°C)	18-26s	
APPLICATION			
	Gravity feed spray gun	nozzle	pressure
		1.6 – 1.8 mm	operating pressure according to spray gun manufacturer's recommendations
	Application	number of layers	flash-off time (20°C)
		2	10 min
		dry single layer thickness	dry coating thickness
		45 - 55 µm	90 - 110 µm
Recommended application conditions		temperature 18 - 22°C, humidity 40 - 60%	
Theoretical coverage		5.5 – 6.5 m ² /l (for dry coating thickness 90 -110 µm)	
Pot life (20°C)		30-40 min	




Billakkspesialisten AS

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DRYING			
	Object temperature	60°C	20°C
	Drying time	30 min	2.5 – 3 h
	IR drying	Short and medium wave: 8 - 15 min Follow IR lamp manufacturer's recommendations. Keep the flash-off time before drying.	
	Dry sanding	P400 - P600	
	Wet sanding	P800 - P1000	

NOTES:

Allow the product to reach the recommended application temperature in a natural, unforced way (avoid rapid heating/cooling). Temperature of the product, the object being painted and ambient temperature should be approx. 20°C.

STORAGE AND TRANSPORT:

Protect from frost, heat, sunlight and moisture. Store tightly closed in a dry and cool place. Recommended storage temperature: +10 to +30°C.

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