2K Filler VOC 540

2K acrylic filler

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CHARACTERISTIC

The 2K Filler VOC 540 has very good filling properties due to its high content of solids. It provides a smooth surface quality which reduces the sanding effort and thus a lower consumption of abrasives, both in dry sanding and wet sanding.
Even with thicker layers, the 2K Filler VOC 540 has a perfect flow, is easy to apply and has an excellent corrosion protection.

APPLICATION

The 2K Filler VOC 540 is a universal 2K filler, which is perfectly suitable on surfaces like steel, OEM-primers, KTL, polyester putty and GRP.

PRODUCT DATA

MATERIAL DATA

V.O.C.:	2004/42/IIB(c)(540) < 540 g/l	
Shelf life:	12 month in closed original container at 20°C	
Density filler at 20°C:	white:	1.58 - 1.62 g/cm³
	grey:	1.56 - 1.60 g/cm³
	black:	1.48 - 1.52 g/cm³
Density hardener at 20°C:	0.92 - 1.01 g/cm³	
Tinting:	Depending on the desired colour, the filler can be pigmented with CARSYSTEM pigment paste between 1% and 5%. **Warning,** the pigment paste should be hardened at the same time.	
Efficiency:	7 – 8 m²/l at 80 µm	

HANDLING

The surface should be dry, clean, free from greases and other impurities. Pre-treated steel, aluminum and galvanized parts should also be cleaned.
For aluminum and galvanized parts we recommend to pre-spray a wash primer.
Can be painted with all conventional basecoats on the market, waterborne basecoats, solid paints and clearcoats.
It is strongly recommended to work in the system. Drying and adhesion problems cannot be excluded with the use of thinning and hardening materials of external systems.

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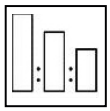
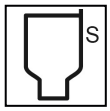
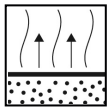
MIXING RATIO		
	**2K Filler VOC 540** **2K Hardener** **Thinner**	**by volume** 4 1 10 - 20% vol. on component A
	2K Filler VOC 540 **2K Hardener standard white** **2K Hardener standard grey** **2K Hardener standard black** **Thinner**	**by weight** 100 g 15.4 g 15.6 g 16.4 g 5.9 - 11.8% wt. on component A
SPRAYING VISCOSITY		
	**DIN cup 4mm at 20°C**	25 - 30 seconds
APPLICATION		
	**Spray gun** **gravity feed**	**Nozzle size / pressure** Nozzle size: 1.5 - 2.2mm Air pressure: Please pay attention to operating pressure recommendations of the manufacturer.
	**Application**	**1 - 3 spraying operations** 1 - 3 coats
	**Pot life at 20°C**	up to 1h
	**Flash off**	10 minutes between coats 10 - 20 minutes with hardener slow
	**Dry coat thickness**	50 - 80µm per coat; up to 240µm possible
	**Process conditions**	Temperature 18 - 22°C Relative air humidity 40 - 60%

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PROCESSING			
	**Object temperature**	**20°C**	**60°C**
	Hardener standard **Hardener very fast** **Hardener winter**	5 - 8 h 3 - 5 h 2 - 3 h	35 - 45 min. 20 - 30 min. 20 - 25 min.
	**IR Drying**	12 - 15 min. 12 - 20 min. with hardener slow Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying	
	**Dry sanding**	P400 - P600	
	Wet sanding	P800 - P1200	

STORAGE AND TRANSPORTATION CONDITIONS

Protect from freezing, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage and transportation temperature range is: +10 to +30°C. Avoid extreme temperature fluctuation.
Note: The storage and transportation temperature must be not lower than +5°C. Acclimatize the product to room temperature naturally.

REMARKS

Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the product at a temperature below 18°C. Low application temperature changes the coating‘s properties and may impair the visual effect. Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20°C.

SAFETY ISSUES

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions.
In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgement in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

Directions for handling and waste disposal are in our Material Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry.