MASTER
TROTON

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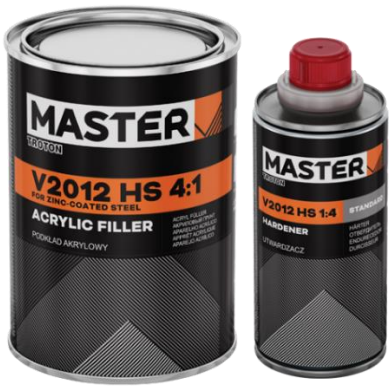
TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

V2012 HS 4:1

ACRYLIC FILLER HS 4:1



PRODUCTS

V2012 MASTER Acrylic Primer 4:1 – HS Filler primer for galvanized steel
Hardener 1:4 for Acrylic Filler V2012
Thinner for acrylic systems

PRODUCT DESCRIPTION

The highest quality 2K acrylic primer with excellent adhesion to steel, aluminum, galvanized steel, polyester putties and old finishes. Intended for car body repairs.

- Excellent adhesion to difficult substrates.
- Easy to mix and apply.
- Very good vertical stability.
- Good filling and insulating properties.
- Easy sanding.

COLOURS: white, lightgrey, black

GLOSS GRADE: matt

VOLATILE ORGANIC COMPOUNDS

VOC with 10% of thinner = 460 [g/l], VOC with 20% of thinner = 510 [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

Acrylic Filler V2012 4:1 can be applied over:

- Steel and aluminum after flatting and degreasing.
- Zinc coated steel after flatting and degreasing.
- Sanded polyester-glass laminates (GFK/GRP).
- Polyester putties.
- Epoxy primers.
- Wash primers.
- Old finishes in good condition after flatting and degreasing.

Good preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

- Sanding by hand (dry or wet): P280÷P320 (GRP P400).
- Sanding by machine (dry): P180÷P220.

APPLICATION PROCESS

USE

For car body repairs as an isolating (thin-coat) or filling primer.

MIXING RATIO by volume

Primer	4 parts
Hardener	1 part
Thinner:	
Acrylic filler	10%
Primer	20%

Stir thoroughly until achieving homogenous mixture.

SPRAYING VISCOSITY

Acrylic filler: 40÷50 sec. at 20°C
Primer: 25÷30 sec. at 20°C

POT LIFE

Approx. 60 minutes at 20°C/DIN4.

EVAPORATION TIME

Between layers:	5÷10 minutes
Before baking:	5÷15 minutes

Evaporation time depends on the temperature and the thickness of layers.

HARDENING TIME

Acrylic filler (130÷300 µm):

- **at 20°C:** ready for sanding after overnight drying.
- **at 60°C:** ready for sanding after baking for 35÷40 minutes and cooling the coating (about 2 hours).

Primer (60÷130 µm):

- **at 20°C:** ready for sanding after 3÷4 h.
- **at 60°C:** ready for sanding after baking for 25÷30 minutes and cooling the coating (about 2 hours).

Temperature below 20°C significantly increases the hardening time.

NUMBER OF LAYERS

2÷3 layers; 60÷300µm depending on the size of the spray nozzles.
Gun parameters:
RP nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars.
HVLP nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.

IR DRYING

Acrylic filler (130÷200µm): 10÷15 minutes of short waves.
Primer (60÷130 µm): 8÷10 minutes of short waves.

Do not exceed 60°C.
Use as recommended by the equipment manufacturer.
Wait about 10 minutes before starting the heater drying.

	DRY SANDING		WET SANDING
	Machine sanding: P360÷P500. Hand sanding: P280÷P360.		Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.

FURTHER WORK

2K acrylic fillers can be directly over coated with:

- 2K acrylic topcoats.
- 1K base coats.

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.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components 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

V2012 MASTER Acrylic Primer 4:1	– 12 months from the date of production
Hardener 1:4 for Acrylic Filler V2012	– 12 months from the date of production

PRODUCT	ART. No.
V2012 MASTER Acrylic Primer 4:1	(0.8l + 0.2l): 7228; 12452; 13019 (3.75l): 9974; 9973; 9972
Hardener 1:4 for Acrylic Filler V2012	(0.94l): 9975
Thinner for acrylic systems	300002253; 300002790 (1l; 5l)

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.

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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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