

Technical information

October 2007

**THE PRODUCT IS SUITABLE FOR
PROFESSIONAL USE ONLY**

INTER TROTON ACRYL FILLER 5:1

ACRYL FILLER 5:1

HARDENER TO ACRYL FILLER 1:5

THINNER TO ACRYL PRODUCTS

PRODUCT DESCRIPTION

High quality product for priming all surfaces. It assures good fluidity, and precise coating of primed surface. It quickly hardens, even in the thick layer; good in grinding. It has very good filling properties. It assures the substrate of great look and durability.

Colour: white, grey, black, yellow, beige, red, graphit

Glass grade: matt

VOLATILE COMPONENTS CONTENT

VOC for mixture =534 [g/l] , for viscosity 22 s., FORD 4 in 20°C

The product fulfils the requirements of the European Directive (2004/42/WE), which defines the volatile components content for that products category (cat. B/3) at the level of 540[g/l] for the ready product.

SUBSTRATE AND PREPARING THE SURFACE

Product has good adherence to the surfaces of all kind. It can be applied on:

- metal surface, also not-grounded,
- steel or aluminium surface,
- polyester filler,
- old lacquer layers.

Metal surface should be first grinded and cleaned.

Steel surface should be first degreased and grounded with reactive undercoat

APPLICATION PROCESS

| | | |
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| | <p>USE For the repairs of all kind, as a filling or grounding undercoat.</p> | |
| | <p>Proporcja mieszania składników</p> <p>Filler Hardener Thinner</p> | <p>Parts of capacity</p> <p>5 parts 1 part Max.30%</p> |
| <p>Mix ingredients to obtain unified color</p> | | |
| | <p>Spraying viscosity circa 22÷24 s., DIN 4/20°C,</p> <p>Pot life of the prepared mixture 2 hour in 21°C</p> | |
| | <p>Fed: Nozzle: 1,6-1,9mm Pressure: like in the recommendations of the manufacturer</p> | |
| | <p>Number of layers 2-3 layers</p> <p>Dry film thickness = circa 150 µm</p> | |
| | <p>Evaporation time Between layers 5-10 minutes Before soaking ok.15 minutes</p> | |
| | <p>Hardening time</p> <ul style="list-style-type: none"> - Specific dryness in 20°C – after 3 hours - Specific dryness in 60°C – after 30-40 min.. <p>Temperature below 20°C significantly increases the hardening time.</p> | |

GRINDING

When cured, the surface needs to be ground :

- dry mechanic grinding –with sanding paper with P320-P500 grain
- dry manual grinding- with sanding paper with P280-P320 grain
- wet mechanic grinding -with sanding paper with P600-P1000 grain

-wet manual grinding- with sanding paper with P600-P800 grain

GENERAL NOTES

- When working with 2K products one must use operating personal protective gear. One shall protect eyes and breathing system.
- Rooms shall be well ventilated.
- Spraying guns and tools shall be washed directly after use.
- **One must not exceed recommended doses of hardener!**

Caution: To maintain safety, always follow the instructions given in the Safety Data Sheet for the given product.

STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: After each use the container with acryl filler and another container with hardeners shall be immediately closed! Protect against freeze and humidity!

WARRANTY PERIOD

Inter Troton Acryl filler 5:1-12 months from the production date

Inter Troton Hardener to Acryl filler 1:5 – 9 months from the production date

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 practices.

TROTON sp. z o.o. Zabrowo