

2K High Build Filler

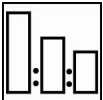



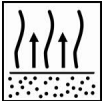




Primers/Surfacers

08/11/2019

L2.02.06 UK & Ireland

DESCRIPTION

Two component high build primer/filler for general use in refinishing cars, and also light commercial vehicles. User-friendly with excellent filling properties.

Mixing ratio		5 1 1	2K High Build Filler Universal Hardener Multi Thinner
Mixing stick		G	
Equipment		Spray gun set up: 1.6-1.8 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		1-3 x 1 coat	
Flash-off		Between coats 5-10 minutes at 20°C	Before curing 5-10 minutes at 20°C
Drying			20°C 60°C 3 hrs 30 min
Sanding		Final sanding step: P400-P500	
Recoatability		Topcoat HS 420	Basecoat WB (GT)
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

Product 2K High Build Filler

Hardener Universal Hardener Extra Fast
Universal Hardener Fast
Universal Hardener StandardThinner Multi Thinner Fast
Multi Thinner StandardChemical Basis 2K High Build Filler Acrylic resins
Universal Hardener Polyisocyanate resins

METHOD OF USE

Grey Shades Please use the Lesonal Grey Shaded Primer System wall chart to decide which primer shade should be used.

Code	Grey Shade	Ratio	Grey Shade
W	White	White 100	
W/G	Light Grey	White 50 / Grey 50	
G	Grey	Grey 100	
G/B	Dark Grey	Grey 50 / Black 50	
B	Black	Black 100	

If the code is followed by "ADV" the use of the Grey Shade is strongly recommended

Substrates Original finishes, including thermoplastic acrylics
(sanded) OEM Electrocoat
Steel
1K Etch Primer
1K Multi Plastic Primer
2K Epoxy Primer
Polyester Body Filler
Spraying FillerSubstrate preparation Original finishes: Sand with P180-P280 grit dry
OEM Electrocoat: Sand with P180-P280 grit dry
Steel: Sand with P180-P280 grit dry
Polyester Body Filler: Sand with P180-P280 grit dry

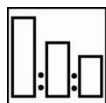
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Mixing ratio 5 2K High Build Filler
 1 Universal Hardener
 1 Multi Thinner



Mixing stick G

Spray gun set up



Sanding

Spray gun:
 HVLP Gravity
 LVLP/HR Gravity

Fluid opening:
 1.6-1.8 mm
 1.6-1.8 mm

Spraying pressure:
 0.7 bar (at air cap)
 1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application

Apply one to three single coats, allowing to dry until matt after each coat

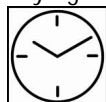


Potlife

1 hour at 20°C

Equipment cleaning Use Multi Thinners or nitro cellulose thinner

Drying



	20°C	60°C
Dry to sand	3 hrs	30 min

Infrared short wave	Half power	Full power
	3 min	11 min

Layer thickness 70 – 100 microns

Material usage Ready for use mixture at 1 µm layer thickness : 410 m²/liter

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances

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Sanding grades	Dry sanding :	Initial sanding P320	Final sanding P400-P500
Recoatability	Topcoat HS 420 Basecoat WB GT		
Product storage	Avoid extreme temperature fluctuation and high humidity levels		
Shelf life	2 years at 20°C		
VOC	2004/42/IIB(c)(540)520 The EU limit value for this product (product category : IIB.c) in ready to use form is max. 540 g/l VOC. The VOC content of this product in ready to use form is max. 520 g/litre.		
Ancillaries	Texture Additive : TDS L1.08.03 Flexible Additive : TDS L1.08.02		

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