

5:1 FILLER THN CPG-02.015 (black)

CHARACTERISTICS:

Two-component filler based on acrylic resin. It is characterised by easy application, good filling power and sanding properties. It is recommended for application on steel, aluminium, galvanised surfaces, polyester laminates, as well as on old paint coatings and puttied surfaces.

APPLICATION:

The surface being repaired must be clean, dry, matted and degreased. Measure out the A+B mixture by volume: 5 parts by volume of filler (A) and 1 part by volume of hardener (B), then mix thoroughly. Add a thinner for acrylic products (C) in an amount of 20 - 25 vol. % of component A. Apply with a spray gun (spray nozzle 1.6 - 1.8 mm) in 2 - 3 layers, with a 8 - 10-minute interval to evaporate solvents before applying the next layer.

TECHNICAL DATA:

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

Filler CPG-02.015:

Shelf life: 18 months Density (20°C): 1.48 – 1.52 g/cm³ Colour: black

Hardener CDL-04.012/ fast CDL-04.061/ very slow CDL-04.051/ universal CDL-04.059/ winter CDL-04.085:


Shelf life: 12 months Density (20°C): 0.94 – 1.03 g/cm³ Colour: colourless/slightly yellow

Thinner standard CDL-07.002/ fast CDL-07.017/ slow CDL-07.015:


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

Also available in grey (CPG-02.014), white (CPG-02.016) and dark grey RAL 7043 (CPG-02.075)



MIXING RATIO

	-	by volume	by weight
	Filler (A)	5	100
	Hardener (B)	1	13.2 (CDL-04.012, fast, universal) 12.6 (very slow) 13.5 (winter)
	Thinner (C)	20 - 25 vol. % of component A	11.8 - 14.8 wt. % of component A

SPRAYING VISCOSITY

	DIN cup 4 mm (20°C)	25 - 30 s
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APPLICATION

	Gravity feed spray gun	nozzle		pressure	
		1.6 - 1.8 mm		operating pressure according to spray gun manufacturer's recommendation	
	Application	number of layers	flash-off time	single layer thickness	coating thickness
		2 - 3	8 - 10 min	55 - 80 µm	110 - 240 µm
Recommended application conditions		temperature 18 - 22°C, humidity 40 - 60%			
Theoretical coverage		7 m ² /l (with a layer thickness of 80 µm)			
Pot life (20°C)		up to 1 h			




Chemical Alliance Polska Sp. z o.o.

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NIP 781 16 87 419, REGON 634159570, Kapitał Zakładowy 2.000.000,00 PLN

Sąd Rejonowy w Szczecinie XVII Wydział Gospodarczy KRS 0000003186, Certyfikat ISO 9001/ ISO 14001/ PN-N 18001

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DRYING TIMES			
	Object temperature		
	Hardener type	60°C	20°C
	CDL-04.012	30 min	5 - 7 h
	fast CDL-04.061	20 - 25 min	4.5 - 6.5 h
	very slow CDL-04.051	45 - 50 min	10 - 12 h
	universal CDL-04.059	30 - 35 min	6 - 8 h
	winter CDL-04.085	25 - 30 min	2.5 - 3 h
	IR drying	Short and medium wave: 7 - 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 and 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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