

6:1 WET ON WET FILLER

CPG-02.018

CHARACTERISTICS:

Universal two-component acrylic filler designed to be used in the "wet-on-wet" technique. It is ideal for application on new or slightly damaged elements treated with anti-corrosion filler or cataphoresis (surfaces treated with cataphoresis do not require sanding). It can also be used as a standard filler on elements with small repairs using polyester putties (e.g. transport damages or small dents). This filler has anti-corrosive properties.

APPLICATION: The surface being repaired must be clean, dry, matted and degreased.

Wet-on-wet version:

Measure out the A+B mixture by volume: 6 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 15 vol. % of component A. At the application temperature up to 25°C, a standard thinner (CDL-07.002) should be used, while above 25°C a slow thinner (CDL-07.015).

Apply with a spray gun (spray nozzle 1.2 - 1.3 mm) in 1 layer. Prior to application of the topcoat, wait 30 min at 20°C (time to evaporate solvents). Small correction (remove inclusions) can be made after 30 - 35 min at 20°C, using P600 - P1000 dry. Further works can be performed without matting the surface up to 3 days.

Filling version:

Measure out the A+B mixture by volume: 6 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 5 - 15 vol. % of component A. At the application temperature to 25°C, use a standard thinner (CDL-07.002), while above 25°C a slow thinner (CDL-07.015).

Apply with a spray gun (spray nozzle 1.3 - 1.6 mm) in 2 layers, with a 5 - 7 minute interval to evaporate solvents. It can be sand with abrasive materials: P400 - P600 dry or P800 - P1000 wet.

TECHNICAL DATA:

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

Filler CPG-02.018:

Shelf life: 12 months Density (20°C): 1.37 – 1.41 g/cm³ Colour: grey


Hardener standard CDL-04.021/ slow CDL-04.036:

Shelf life: 12 months Density (20°C): 0.99 – 1.01 g/cm³ Colour: colourless


Thinner standard CDL-07.002/ slow CDL-07.015:

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

MIXING RATIO

	-	by volume	by weight
	Filler (A)		6
Hardener (B)		1	12
Thinner (C)		15 vol. % of component A (wet-on-wet version)	9.6 wt. % of component A (wet-on-wet version)
		5 vol. % of component A (filling version)	3.2 wt. % of component A (filling version)

SPRAYING VISCOSITY

	DIN cup 4mm (20°C)	17 - 19 s (wet-on-wet version) 19 - 22 s (filling version)
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Sąd Rejonowy w Szczecinie XVII Wydział Gospodarczy KRS 0000003186, Certyfikat ISO 9001/ ISO 14001/ PN-N 18001

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APPLICATION					
	Gravity feed spray gun	Wet-on-wet version		Filling version	
		nozzle	pressure	nozzle	pressure
		1.2 - 1.3 mm	operating pressure according to spray gun manufacturer's recommendation	1.3 - 1.6 mm	operating pressure according to spray gun manufacturer's recommendation
	Application	number of layers	coating thickness	number of layers	coating thickness
		1	30 µm	1 - 2	40 - 80 µm
		flash-off time			
		5 - 7 min (to matting)			
Recommended process conditions		temperature 18 - 22°C, humidity 40 - 60%			
Theoretical coverage		17.5 m ² /l (wet on wet version, with a layer thickness of 30 µm) 14 m ² /l (filling version, with a layer thickness of 40 µm)			
Pot life (20°C)		up to 1 h			

DRYING TIMES				
	Application version	Wet-on-wet	Filling	
	Object temperature	20°C	60°C	20°C
	Hardener typu			
	standard CDL-04.021	15 - 20 min	20 min	3 - 4 h
slow CDL-04.036	30 - 40 min	30 min	5 - 6 h	
	IR drying	-	Short and medium wave: 12 - 15 min Follow IR lamp manufacturer's recommendations. Keep the flash-off time before drying.	
	Dry sanding	Not required	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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