

4:1 FILLER EC

CPG-02.063 (grey)

CHARACTERISTICS:

Two-component acrylic filler with good filling properties and excellent adhesion to polyester putties and old paint coatings. This product gives a smooth coating which, in turn, reduces the time of surface preparation before applying the base coat. It is not recommended for unprotected steel surfaces.

APPLICATION:

The surface being repaired must be clean, dry, matted and degreased. Measure out the A+B mixture by volume: 4 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 up to 10 vol. % of component A. Apply with a spray gun (spray nozzle 1.6 - 1.8 mm) in 2 - 3 layers, with a 7 - 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-02.063:

Shelf life: 18 months Density (20°C): 1.45 – 1.49 g/cm³ Colour: grey

Hardener CDL-04.048:


Shelf life: 12 months Density (20°C): 0.96 – 0.98 g/cm³ Colour: colourless

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 white (CPG-02.121) and black (CPG-02.122)



MIXING RATIO

	-	by volume	by weight
	Filler (A)	4	100
	Hardener (B)	1	16.4
	Thinner (C)	0 - 10 vol. % of component A	0 - 6 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 recommendations	
	Application	number of layers	flash-off time	single layer thickness	coating thickness
		2 - 3	7 - 10 min	40 - 50 µm	80 - 150 µm
Recommended application conditions		temperature 18 - 22°C, humidity 40 - 60%			
Theoretical coverage		11.5 - 12 m ² /l (with a layer thickness of 50 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	60°C	20°C
	Drying times	30 min	5 - 7 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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