

# 5:1 FILLER THX

## CPG-02.125 (grey)

### CHARACTERISTICS:

Two-component, highly thixotropic acrylic filler for application on steel surfaces, polyester putties, old renovation coatings, as well as polyester laminates. It has filling and insulating properties, can be easily sand with sandpapers. This filler is intended for dry or wet manual/machine sanding. This product contains an anti-corrosive pigment.

### 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 - 30 vol. % of component A. Apply with a spray gun (spray nozzle 1.6 - 2.0 mm) in 2 - 3 layers, with a 5 - 10 minute (depends on the hardener) interval to evaporate solvents before applying the next layer.

### TECHNICAL DATA:

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

#### Filler CPG-02.125:

Shelf life: 18 months      Density (20°C): 1.52 – 1.54 g/cm<sup>3</sup>      Colour: grey

#### Hardener fast CDL-04.049/ very fast CDL-04.072:


Shelf life: 12 months      Density (20°C): 0.99 – 1.01 g/cm<sup>3</sup>      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/cm<sup>3</sup>      Colour: colourless

Also available in white (CPG-02.126) and black (CPG-02.127)



### MIXING RATIO

|  | -            | by volume                     | by weight                        |
|---|--------------|-------------------------------|----------------------------------|
|   | Filler (A)   | 5                             | 100                              |
|   | Hardener (B) | 1                             | 13.1                             |
|   | Thinner (C)  | 20 - 30 vol. % of component A | 11.7 - 17.5 wt. % of component A |

### SPRAYING VISCOSITY

|   |                     |           |
|---|---------------------|-----------|
|  | DIN cup 4 mm (20°C) | 35 - 55 s |
|---|---------------------|-----------|

### APPLICATION

|   |                        |                  |   |   |                   |
|---|------------------------|------------------|---|---|-------------------|
|  | Gravity feed spray gun | nozzle           |   | pressure  |                   |
|   |                        | 1.6 - 2.0 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 (CDL-04.049)<br>5 - 7 min (CDL-04.072) | 50 - 65 µm  | 100 - 195 µm      |

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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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|   |   |
|---|---|
| <b>Recommended application conditions</b> | temperature 18 - 22°C, humidity 40 - 60%                    |
| <b>Theoretical coverage</b>               | 8.5 - 9 m <sup>2</sup> /l (with a layer thickness of 65 µm) |
| <b>Pot life (20°C)</b>                    | up to 1 h   |

| <b>DRYING TIMES</b>   |                           |                 |   |             |
|---|---------------------------|-----------------|---|-------------|
|  | <b>Object temperature</b> |                 | <b>60°C</b>   | <b>20°C</b> |
|   | <b>Hardener type</b>      |                 |   |             |
|   |                           | fast CDL-04.049 |   | 30 - 35 min |
|   | very fast CDL-04.072      |                 | 20 - 25 min   | 3.5 - 4.5 h |
|  | <b>IR drying</b>          |                 | Short and medium wave: 7 - 15 min<br>Follow IR lamp manufacturer's recommendations.<br>Keep the flash-off time before drying. |             |
|  | <b>Dry sanding</b>        |                 | P400 - P600   |             |
|   | <b>Wet sanding</b>        |                 | 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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