

5:1 FILLER THX CPG-02.127 (black)

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 15 - 25 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-02.127:

Shelf life: 18 months Density (20°C): 1.47 – 1.49 g/cm³ Colour: black

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


Shelf life: 12 months Density (20°C): 0.99 – 1.01 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 colour (CPG-02.125) and white colour (CPG-02.126)



MIXING RATIO

	-	by volume	by weight
	Filler (A)	5	100
	Hardener (B)	1	13.2
	Thinner (C)	15 - 25 vol. % of component A	9.5 - 15.1 wt. % of component A

SPRAYING VISCOSITY

	DIN cup 4 mm (20°C)	30 - 50 s
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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) 5 - 7 min (CDL-04.072)	50 - 65 µm	100 - 195 µm

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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CPG-02.127 (black)

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

DRYING TIMES

	Object temperature	60°C	20°C
	Hardener type		
	fast CDL-04.049	30 - 35 min	4.5 - 5.5 h
	very fast CDL-04.072	20 - 25 min	3.5 - 4.5 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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