

4:1 MULTI/R FILLER GREY

CPG-02.130

CHARACTERISTICS:

Very fast drying, two-component acrylic filler with anticorrosive properties. Characterized by easy application, high filling power and excellent sanding results only after 2 - 2.5 hours of drying at 20°C. It has good adhesion to steel, aluminium, zinc-coated surfaces, cathodic electrodeposited primers, polyester laminates and puttied surfaces. It can be applied in three different ways: as high build, build or wet on wet version.

APPLICATION:

High Build version and Build version:

Dedicated hardeners: **Standard 086 CDL-04.086/ Very fast CDL-04.014**

Dedicated thinner: **Standard CDL-07.002**

Measure out the A+B mixture by volume: 4 parts of filler (A) and 1 part of hardener (B), then mix thoroughly. Add thinner (C) in an amount of 5 vol. % of component A (for high build version) or 10 - 20 vol. % of component A (for build version). Apply with a spray gun (spray nozzle 1.6 - 2.0 mm) in 1 - 2 layers, with a 7 - 10 minute interval to evaporate solvents. The coating can be sanded with abrasive materials: P400 - P500 dry or P800 - P1000 wet.

Wet on wet version:

Dedicated hardener: **Standard 086 CDL-04.086**

Dedicated thinners: **Standard CDL-07.002** at temperatures ≤ 20°C, **Extra Slow Special CDL-07.032** at temperatures > 20°C

Measure out the A+B mixture by volume: 4 parts of filler (A) and 1 part of hardener (B), then mix thoroughly. Add thinner (C) in an amount of 25 - 30 vol. % of component A. Apply with a spray gun (spray nozzle 1.3 mm) in 1 layer. Prior to application of the topcoat, wait 25 - 30 min at 20°C (time to evaporate solvents).

TECHNICAL DATA:

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

Filler CPG-02.130:

Shelf life: 12 months Density (20°C): 1.60 – 1.65 g/cm³ Colour: grey


Hardener standard 086 CDL-04.086/ very fast CDL-04.014:

Shelf life: 12 months Density (20°C): 0.96 – 1.01 g/cm³ Colour: colourless/slightly yellow


Thinner standard CDL-07.002/ Extra Slow Special CDL-07.032:

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

MIXING RATIO

	by volume		by weight
	Filler (A)	4	100 g
Hardener (B)	1	15.2 g	
Thinner (C)	5 vol.% of comp. A (high build version) 10 - 20 vol.% of comp. A (build version) 25 - 30 vol.% of comp. A (wet on wet version)	2.8 g (high build version) 5.5 - 11 g (build version) 13.5 - 16.0 g (wet on wet version)	

SPRAYING VISCOSITY

	DIN cup 4 mm (20°C)	25 - 45 s (high build version) 18 - 35 s (build version) 15 - 21 s (wet on wet version)
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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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APPLICATION and DRYING – High build version and build version						
	Gravity feed spray gun	nozzle		pressure		
		1.8 - 2.0 mm (high build version) 1.6 - 1.8 mm (build version)		acc. to spray gun manufacturer's recommendation		
	Application	number of layers	flash-off time (20°C)		single dry layer thickness	dry coating thickness
			between coats	before baking		
		1 - 2	7 - 10 min	10 min	70 - 90 µm (high build) 40 - 60 µm (build)	70 - 180 µm (high build) 40 - 120 µm (build)
		1.5 ^{*)}	0 - 2 min	10 min	-	70 - 80 µm (build)
*) Apply ½ thin coat + 1 full coat. Application at 1.5 layer recommended only for build version						
Theoretical coverage		7 - 8 m ² /l (high build version at a layer thickness 90 µm) 9.5 - 10.5 m ² /l (build version at a layer thickness 60 µm)				
Pot life (20°C)		15 - 20 min (high build version) 20 - 50 min (build version)				
	Drying time	number of layers		object temperature		
		1 - 1.5		20°C	60°C	
				1.5 - 2 h ^{*)}	15 - 20 min ^{*)}	
2		*) Regardless of used hardener		2 - 2.5 h with hardener very fast 2.5 - 3 h with hardener standard 086	20 - 25 min with hardener very fast 25 - 30 min with hardener standard 086	
	IR drying	8 - 10 min Follow IR lamp manufacturer's recommendations. Keep the flash-off time before drying.				
	Dry sanding	P400 - P500				
	Wet sanding	P800 - P1000				




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APPLICATION and DRYING – Wet on wet version			
	Gravity feed spray gun	nozzle	pressure
		1.3 mm	acc. to spray gun manufacturer's recommendation
	Application	number of layers	dry coating thickness
		1	20 - 30 µm
Theoretical coverage		18 - 19 m ² /l at a layer thickness 30 µm	
Pot life (20°C)		0.5 - 1 h	
	Flash-off time (20°C)	25 - 30 min	

NOTES:

This product has a very high filling power. For best results, keep thickness of the dry finish coating at the level of maximum 200 µm. Higher thickness increases drying time and may lead to coating's defects.

Recommended application conditions: temperature 18 - 22°C, humidity 40 - 60%.

Prior to application, 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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