



Hi-Tech 2K Filler 4:1

CHARACTERISTIC

Hi-Tech 2K Filler 4:1 is very fast drying filler. It has got very good application properties – excellent levelling and filing. It is dedicated for fast and small repair. Excellent sanding properties without clogging of sanding paper. Hi-Tech 2K Filler 4:1 gives corrosion protection and very good adhesion. Manual or machine sanding dry.

APPLICATION

The surface must be cleaned, dry, degreased and matted. Mixing ratio: 4:1 by volume. Mix thoroughly. Apply with a spray gun with nozzle diameter 1,6 – 2,2 mm in 1 - 3 normal coats with 5-7 min. flash off at 20°C between the coats. Drying: 15-20 min. at 60°C, 2,5 - 3h at 20°C. Sand dry with P400 - P500 or wet with P600 - P1000.

RELATED PRODUCTS






XF1091/3.6	Hi-Tech 2K Filler 4:1	
XFH1057/0.9	Hardener for Hi-Tech 2K Filler 4:1	
XM0004/1	Accelerator Additive	
XM0012/0.5	Pigment Paste Black	

SURFACE PREPARATION



The surface must be cleaned, dry, degreased and matted.



MIXING RATIO					
	Hi-Tech 2K Filler 4:1 XF1091 Hardener XFH1057	by volume		by weight at 1L	
		100		1176g	
		25		200g	
SPRAY VISCOSITY					
	DIN4 at 20°C	25-30 seconds			
SPRAYGUN SETTING					
	Spray gun gravity feed	nozzle		pressure	
		1,6 – 2,2 mm		as recommended by the manufacturer of the spray gun	
APPLICATION					
	Application process	coats number	flash off time		dry film thickness
			between coats	before baking	
		1-3	5 - 7 min.	5 - 7 min.	40 – 180 µm
Process conditions		temperature > 15°C, relative air humidity up to 75%			
Theoretical efficiency		5,5 m²/l			
Pot life at 20°C		Up to 1 hours			
DRYING TIMES					
		20°C		60°C	
	Dry	2,5-3 hours		15-20 min	
IR drying		12 – 15 min.			



TECHNICAL DATA				
Product	Packing	Density (20°C)	Colour	Shelf-life
Hi-Tech 2K Filler 4:1 XF1091	3.6L	1,46 – 1,48 g/cm ³	grey	12 months
Hardener XFH1057	0.9L	1,00 g/cm ³	colourless	12 months
MIXING RATIO BY WEIGHT				
The required volume of the mixture, ready to use	Weight for weight in grams	Density	The cumulative weight in grams	Density
	XF1091	1470 g/l	XFH1057	1000 g/l
0,1l	117,60 g		137,60 g	
0,2l	235,20 g		275,20 g	
0,3l	352,80 g		412,80 g	
0,4l	470,40 g		550,40 g	
0,5l	588,00 g		688,00 g	
0,6l	705,60 g		825,60 g	
0,75l	882,00 g		1032,00 g	
0,9l	1058,40 g		1238,40 g	
1l	1176,00 g		1376,00 g	
1,5l	1764,00 g		2064,00 g	
2l	2352,00 g		2752,00 g	
2,5l	2940,00 g		3440,00 g	

**VOC INFORMATION**

VOC limit 2004/42/II B(c): 540 g/l
VOC content: max. 520 g/l

HEALTH AND SAFETY

Trixxal products are intended only for professional use. They may not be used for any purpose other than that for which they are intended.

When using them, follow the appropriate personal protective equipment, especially respiratory protection, eye and skin protection.

The information referred in data list are based on chemical research and it is on users to use this product in an appropriate manner.

Information on the composition, health and safety, see the Safety Data Sheet, which is available at www.trixxal.com

PRODUCER

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