



## 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	
XF1092/3.6	Hi-Tech 2K Filler 4:1 Black	
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					
	<b>Hi-Tech 2K Filler 4:1 XF1091 Hardener XFH1057</b>	<b>by volume</b>		<b>by weight at 1L</b>	
		100		1176g	
		25		200g	
SPRAY VISCOSITY					
	<b>DIN4 at 20°C</b>	25-30 seconds			
SPRAYGUN SETTING					
	<b>Spray gun gravity feed</b>	<b>nozzle</b>		<b>pressure</b>	
		1,6 – 2,2 mm		as recommended by the manufacturer of the spray gun	
APPLICATION					
	<b>Application process</b>	<b>coats number</b>	<b>flash off time</b>		<b>dry film thickness</b>
			between coats	before baking	
		1-3	5 - 7 min.	5 - 7 min.	40 – 180 µm
<b>Process conditions</b>		temperature > 15°C, relative air humidity up to 75%			
<b>Theoretical efficiency</b>		5,5 m <sup>2</sup> /l			
<b>Pot life at 20°C</b>		Up to 1 hours			
DRYING TIMES					
	<b>Dry</b>	<b>20°C</b>		<b>60°C</b>	
		2,5-3 hours		15-20 min	
<b>IR drying</b>		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 <sup>3</sup>	grey	12 months
Hardener XFH1057	0.9L	1,00 g/cm <sup>3</sup>	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
	<b>XF1091</b>	<b>1470 g/l</b>	<b>XFH1057</b>	<b>1000 g/l</b>
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](http://www.trixxal.com)

**PRODUCER**

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