



Premium 2K Filler 5:1

CHARACTERISTIC

New two-component acrylic filler with OH groups. Due to high thixotropy has extremely good filling properties and is very easy to apply with thick layers on vertical surfaces, without leaving runs. It isolates very good polyester products. Due to use of high quality anticorrosive pigments, provides good protection against corrosion. It is designated to use under solvent- and waterborne base coat. Manual/machine sanding dry or wet. Filler is also suitable for colouring with black pigment paste, allowing to get a perfect colour final result. In case of using black pigment paste, add first about 0-5% of paste to acrylic filler (depending on applied base coat), and then mix with hardener.

APPLICATION


The surface must be clean, dry, degreased and matted. Mixing ratio 5:1 by volume, if necessary use a thinner for acrylic products to good spray viscosity. Apply with a spray gun with nozzle diameter 1,6 - 1,8 mm in 2 -3 normal coats with 8 - 10 min. flash off at 20°C between the coats. Drying time by the application of max 3 coats 5 - 7 h at 20°C or 30 min. at 60°C.


Sand dry with P320 - P400 or wet with P800 - P1200.


RELATED PRODUCTS


XF3012/1.2	Premium 2K Filler 5:1	
XF3012/3.5	Premium 2K Filler 5:1	
XFH3012/0.7	Hardener for Premium 2K Filler 5:1	
XM0002/1	Acryl thinner	
XM0002/5	Acryl thinner	
XM0004/1	Accelerator Additive	
XM0012/0.5	Pigment Paste Black	




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

MIXING RATIO			
	Premium 2K Filler 5:1 XF3012 Hardener XFH3012 Thinner XM0002	by volume	by weight at 1L
		100	1083,33g
		20 25-30	133,34g 180g

SPRAY VISCOSITY		
	DIN4 at 20°C	30-35 seconds

SPRAYGUN SETTING			
	Spray gun gravity feed	nozzle	pressure
		1,6 – 1,8 mm	as recommended by the manufacturer of the spray gun

APPLICATION					
	Application process	coats number	flash off time		dry film thickness
		2-3	between coats	before baking	
		8 -10 min.	8-10 min.	60–80 µm	
Process conditions		temperature > 15°C, relative air humidity up to 75%			
Theoretical efficiency		5,5 m ² /l			
Pot life at 20°C		Up to 2 hours			



DRYING TIMES

		20°C	60°C
	Dry	5-7 hours	30 min
IR drying		7 – 15 min.	

TECHNICAL DATA

Product	Packing	Density (20°C)	Colour	Shelf-life
Premium 2K Filler 5:1 XF3012	1.2L 3.5L	1,60 – 1,65 g/cm ³	Light grey	12 months
Hardener XFH3012	0.7L	1,00 g/cm ³	colourless	12 months
Acryl thinner XM0002	1L 5L	0,89 – 0,90 g/cm ³	colourless	12 months

MIXING RATIO BY WEIGHT (100:20:30)

The required volume of the mixture, ready to use	Weight for weight in grams	Density	The cumulative weight in grams	Density	The cumulative weight in grams	Density
	XF3012	1625 g/l	XFH3012	1000 g/l	XM0002	900 g/l
0,1l	108,33		121,67		139,67	
0,2l	216,67		243,33		279,33	
0,3l	325,00		365,00		419,00	
0,4l	433,33		486,67		558,67	
0,5l	541,67		608,33		698,33	
0,6l	650,00		730,00		838,00	
0,75l	812,50		912,50		1047,50	
0,9l	975,00		1095,00		1257,00	
1l	1083,33		1216,67		1396,67	
1,5l	1625,00		1825,00		2095,00	
2l	2166,67		2433,33		2793,33	
2,5l	2708,33		3041,67		3491,67	

**VOC INFORMATION**

VOC limit 2004/42/II B(c):540 g/l
VOC content: <540 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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