

# Technical information

Marz 2008

**THE PRODUCT IS SUITABLE FOR  
PROFESSIONAL USE ONLY**

## **MASTER ACRYL FILLER MF 560 5:1**

ACRYL FILLER MF 560 5:1

HARDENER TO ACRYL FILLER MF 560 1:5

THINNER TO ACRYL PRODUCTS

### **PRODUCT DESCRIPTION**

Top quality two-component product with low content of volatile organic components. It provides good fluidity and ensures excellent. It`s good for all repair require fulfill , cure dray and ensure excellent. It cures quickly, even in case of a thick layer. It has very good filling properties, even in dilution. It is a perfect priming material that ensures excellent appearance of the lacquer coating.

Colour: dark grey

Glass grade: semi matt

### **VOLATILE COMPONENTS CONTENT**

VOC for mixture =480 [g/l] ,

The product fulfils the requirements of the European Directive (2004/42/WE), which defines the volatile components content for that products category (cat. B/3) at the level of 540[g/l] for the ready product.

\*ISO 3251:2008

### **SUBSTRATE AND PREPARING THE SURFACE**

Product has good adherence to the surfaces of all kind. It can be applied on:

- metal surface, also not-grounded,
- steel or aluminium surface,
- polyester putties

- old lacquer layers.


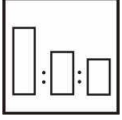
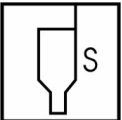


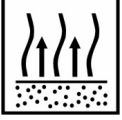

Metal surface should be first grinded and cleaned.

Steel surface should be degreased, dry ground (P80-P120) and degreased again .

The aluminium surface should be degreased, dulled with the abrasive cloth and degreased again.

The old coatings should be degreased, dry ground (P220-P280) and degreased again.

## APPLICATION PROCESS

	<p><b>USE</b> For the repairs of all kind, as a filling or grounding undercoat.</p>	
	<p><b>Proporcja mieszania składników</b></p> <p>Filler Hardener Thinner</p>	<p>Parts of capacity</p> <p>5 parts 1 part 25-30%</p> <p>Mix ingredients to obtain unified color</p>
	<p><b>Spraying viscosity</b> 20÷22 s., DIN 4/20°C,</p> <p><b>Pot life of the prepared mixture</b> 2 hours in 21°C</p>	
	<p><b>Fed:</b> <b>Nozzle:</b> 1,6-1,9mm <b>Pressure:</b> like in the recommendations of the manufacturer</p>	
	<p><b>Number of layers</b> 2-3 layers, (leaving time for evaporation)</p> <p><b>Dry film thickness</b> = circa 130 µm (2-3 layers max.400 µm)</p>	
	<p><b>Evaporation time</b> Between layers 5-10 minutes Before soaking circa 15 minutes</p>	
	<p><b>Hardening time</b></p> <ul style="list-style-type: none"> <li>- Specific dryness in 20°C – after 3 hours</li> <li>- Specific dryness in 60°C – after 30-40 min..</li> </ul> <p>Temperature below 20°C significantly increases the hardening time.</p>	

## GRINDING

When cured, the surface needs to be ground :

- dry mechanic grinding –with sanding paper with P320-P500 grain
- dry manual grinding- with sanding paper with P280-P320 grain
- wet mechanic grinding -with sanding paper with P600-P1000 grain
- wet manual grinding- with sanding paper with P600-P800 grain

## GENERAL NOTES

- When working with 2K products one must use operating personal protective gear. One shall protect eyes and breathing system.
- Rooms shall be well ventilated.
- Spraying guns and tools shall be washed directly after use.
- **One must not exceed recommended doses of hardener!**

Caution: To maintain safety, always follow the instructions given in the Safety Data Sheet for the given product.

## STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: After each use the container with acryl filler and another container with hardeners shall be immediately closed! Protect against freeze and humidity!

## WARRANTY PERIOD

Master Acryl filler MF 560 5:1-12 months from the production date

Master Hardener to Acryl filler MF 560 1:5 – 9 months from the production date

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practices.

TROTON sp. z o.o. Ząbrowo