



01-12-2006

TECHNICAL INFORMATION SHEET – D2.02.03

Quick reference



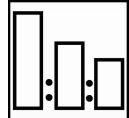
Degreaser



P180-P280



P400



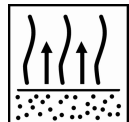
4:1:1



4



(gravity)
1.8 mm
3-4 bar



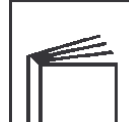
5-10 min.



30 minutes
at 60°C



All topcoats



Product Name :

Dynacoat Acrylic Filler 4+1

Description:

Two pack, high build, quick hardening filler. It has very good sanding and filling properties

Products and Additives:

Dynacoat Acrylic Filler 4+1
Dynacoat Acrylic Filler 4+1 Hardener
Dynacoat Thinner Slow/ Fast
Dynacoat Accelerator

Basic Raw Materials:

Filler : acrylic resin
Hardener : poly-isocyanate resin

Suitable Substrates:

Existing Finishes, including thermoplastic acrylic finishes
Washprimers,
Polyester Putties
Bare steel surfaces

Surface Preparation:

Existing Finishes: Degrease and sand with P180-280 grit dry or P280-400 grit wet
Polyester Putties: Sand with P180-280 grit dry
Bare Steel Surfaces: Degrease and sand with P80-180 grit dry

Mixing Ratio:

Mixture A

4 parts by volume of Dynacoat Acrylic Filler 4+1
1 part by volume of Dynacoat Acrylic Filler 4+1 Hardener
1 part by volume of Dynacoat Thinner Slow/ Fast (optional)

Mixture B

4 parts by volume of Dynacoat Acrylic Filler 4+1
1 part by volume of Dynacoat Acrylic Filler 4+1 Hardener
1 part by volume of Dynacoat Accelerator

Potlife:

Mixture A: 45 minutes at 20°C
Mixture B: 30 minutes at 20°C

Spray gun fluid tip and working pressure :

Spray gun:	Fluid tip:	Pressure :
Gravity feed:	1.8 mm	3-4 bar
Suction feed:	1.8 mm	3-4 bar

Process:

Apply 2 single coats, allowing for 5 to 10 minutes flash off time between coats. If force dried, allow for a minimum flash-off time of 5 minutes.

Film Thickness:

40 µm per coat.

Theoretical cover rate:

8.7 m² / liter of unthinned paint if applied at 40 µm.

Note: The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application



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Cleaning of equipment:	Use Guncleaner or a nitrocellulose thinner		
Drying times:	Dry to sand	20°C	60°C
	Mixture A	3 hrs.	30 min.
	Mixture B	2 hrs.	20 min.
Recommended sand paper:	P360-P400 for dry sanding P800-P1000 for wet sanding		
Recoatibility:	All Dynacoat topcoats		
Packaging:	Filler:	1 l, 3 l	
	Hardener:	250 ml, 750 ml	
	Accelerator:	1 l	
Shelf life:	12 months at temperatures between 5°C and 40°C		
Color:	Light grey		
VOC	The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC. The VOC content of this product in ready to use form is max. 503 g/liter.		

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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