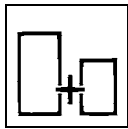




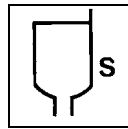
04109 - GREEN TI FILLER

04004 GREEN TI FILLER GREY



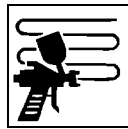
HS Hardeners:
1000 ml +
200 ml +
100-250 ml

UHS Hardeners:
1000 g +
100 g +
100-200 g

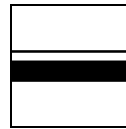


22-25" DIN 4
a 20°C

Pot-life at 20°C:
HS = 120-60 min.
UHS = 120-45 min.



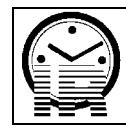
Ø 1,4-1,8 mm
HVLP:
1,5-1,7 mm
4 bar
HVLP: 2-2,5 bar
N. of coats: 2-3



Sealer: 60-100 µ
Filler: 160-200 µ



Sanding: after
2-5 h at 20° C
or
20-30 min. at 60° C



Flash off : 5-6 min.
Max. power : 10-15 min.

DESCRIPTION

Two-pack chromate-free polyacrylic filler, with high filling power.

USE

Suitable as a filler or sealer in the car refinishing field. Specific for complete panels repairs.

CHARACTERISTICS

- Easy to apply
- Quick drying
- Easy dry sanding
- Excellent body
- Low absorption
- High coverage (high solids product)
- "Pilot" effect by sanding (04109)

SUBSTRATE PREPARATION

On knifing polyester putty:

Finish the sanding with P120-180 dry grit paper. Degrease with 00695 SILICONE REMOVER SLOW.

On bare metal:

Excellent adhesion on bare metal, but for better corrosion resistance apply 1-2 coats of FIX-O-DUR (as anti-corrosive primer)

On old well dried coatings:

Sand and degrease with 00665 HYDROCLEANER SLOW / 00699 HYDROCLEANER.

On solvent sensitive and TPA coatings make preliminary tests in order to avoid the risk of lifting, cracking etc.

APPLICATION

Spraying.

Mixing ratio:

Filler	HS Hardeners		UHS Hardeners	Mixture by volume not recommended
04109-04004 GREEN TI FILLER	1000 g	1000 ml	1000 g	
00362 -00109-00209 HARDENER	130 g	200 ml		
MH400 MACROFAN UHS HARDENER			100 g	
00740-00741-00742-00755 AUTOREF. THINNERS	100-200 g	150-250 ml	100-200 g	

For spot repairs	HS Hardeners		UHS Hardeners	
04109-04004 GREEN TI FILLER	1000 g	1000 ml	1000 g	Mixture by volume not recommended
00174 HS HARDENER EXTRA SPEEDY	130 g	200 ml		
MH415 MACROFAN UHS SPOT REPAIRS			100 g	
00740-00741-00742-00755 AUTOREF. THINNERS	100-200 g	150-250 ml	100-200 g	

	T: 15-35°C		Spot Repairs	
HARDENERS	00362-00209	MH400	00174-00109	MH415
Pot-life at 20 °C	120 min.	120 min.	60 min.	45 min.

Spray viscosity at 20 °C: 22-25" DIN 4

Air cap Ø: 1.4 - 1.8 mm; HVLP: 1.5 - 1.7 mm

Air pressure: 4 bar; HVLP: 2 bar

Number of coats: 2 - 3

Recommended film thickness: 60 - 100 µ (sealer); 160 - 200 µ (filler)

Coverage (theoretic value): 1 l of product = 6 m² at 80 µ

1 kg of product = 4 m² at 80 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l

This product ready for use contains at most 540 g/l VOC

DRYING TIME

HARDENERS	00362-00209-00109- MH400		00174 or MH415	
	Sealer	Filler	Sealer	Filler
Air drying at 20°C (substrate temp):				
Handling	40-50 min.		20 min.	Not recommended
Sanding	4 h	5 h	2 h	

Low bake at 60 °C (substrate temp.):

Sanding	30 min.	20 min.
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IR Lamps (short waves):

Flash-off	5-6 min.	Not recommended
Max. power	10-15 min.	
Distance	60-80 cm.	

SANDING

Dry sanding with P240 - P280 grit paper and finish with P360 - 400 grit paper

Wet sanding with P320 - 360 grit paper and finish with P500 - 600 grit paper

By machine sanding, a disk sander of 152 mm diameter and sanding dust suction are recommended.

OVERCOATINGS

- 04122 HI-GARD SEALER
- HYDROFAN / BSB+ Refinish clearcoats of Lechler range
- MACROFAN TOPCOAT

TECHNICAL DATA SHEET N° 0318-GB

UPDATED 09/2008

The information shown in these sheets is given in good faith as being true and although every effort of verification has been made before use, we cannot accept responsibility for any inaccuracy. THIS PRODUCT IS FOR THE PROFESSIONAL PAINTING OF ROAD VEHICLES BY QUALIFIED PERSONNEL