PENTA FILLER UHS MF

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2004/42/IIB
c(540)525

New technology 2K acrylic filler, low VOC compliant with 2004/42/CE standard for CAR – REFINISH branch.

Thanks to its different features it is suitable for the following purposes:

- adhesion primer on aluminium, zinc plated sheets, iron and steel

- anticorrosive

- primer to be applied directly on cataphoresis

- filler to be sanded

- wet on wet cycles (excellent)

- available colors: WHITE - BLACK - GREY

substrate pre-treatment

SANDING IS RECOMMENDED;
degrease with ANTISIL X 29R

application

mixing ratio	4 : 1 by volume – 18% by weight
	ACRYDUR ST UHS QA 2070
pot – life	1 hour
thinner	ACRYTHINNER X 16

application

	thinning	40%
	application viscosity	17 seconds DIN4
	spray nozzle	1,2 – 1,3 mm
	spraying pressure	2 – 3 bar
	number of coats	* ½ + 1 if used as primer and for wet on wet * ½ + 1 + 1 as filler to be sanded
	flash off between the coats	when the coat is matt
	film thickness	40 micron dry for primer and for wet on wet 100 – 110 micron dry for filler to be sanded (DO NOT EXCEED THE RECOMMENDED THICKNESS)

drying

application

air drying at 25°C

wet on wet | as filler to be sanded

OVERCOATING
30 – 40 min Room Temp

baking

	flash off time	10 – 20 minutes
	drying	30 minutes at 60°C on the piece

infra red drying short waves

	flash off time	15 – 20 minutes
	drying	4 – 5 min at 50° C. 7 – 10 min at 80° C.

sanding

	sand with sand paper P360 – P500
	wet hand sanding with sand paper P800

* **CYCLES WET ON WET, ADHESION PRIMER (FOR WET ON WET RESPECT THICKNESS AND TIMES), ANTICORROSIVE PRIMER, ZINC PLATED SHEETS, ALUMINIUM, CATAPHORESIS.**
* **FILLER TO BE SANDED**

�PICTUREGRAPH LEGENDA

2004/42	Reference to the CE law
IIBc	Annex,Table and Category of product
(540)	Limit value of VOC with reference to the category of product
525	Maximum VOC content of the product ready for the use

180327

The information given in this technical data sheet is based on present scientific and technical knowledge and thus do not exempt the customer to test the suitability of our products for the use and for the intended purposes.

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