

GOLDline

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

TROTON GOLD LINE HI FIL MAXI FILLER SPEED 4:1



PRODUCT

HI FIL MAXI FILLER SPEED 4:1 - Acrylic Filler HS
Hardener 1:4 for HI FIL MAXI FILLER SPEED
Thinner for acrylic systems.

PRODUCT DESCRIPTION

The highest quality 2K acrylic primer with excellent adhesion to steel, aluminum, galvanized steel, polyester putties and old finishes. Destined for automotive repair.

- ✓ Excellent adhesion to difficult surfaces.
- ✓ Short time drying
- ✓ Easy to mix and apply.
- ✓ Exceptional vertical stability.
- ✓ Good filling properties.

Colour – White, Grey, Black.

Gloss – Matt.

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 420 [g/l]

These products meet the EU directive (2004/42/EC) that sets the VOC value for its category (IIB), at 540 g/l.

SUBSTRATE PREPARATION

Acrylic Primer can be applied over:

- ✓ Steel and aluminum after flatting and degreased.
- ✓ Galvanized steel after flatting and degreased.

TROTON Sp. z o.o.

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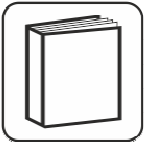
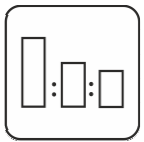
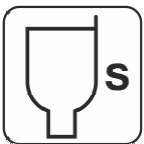
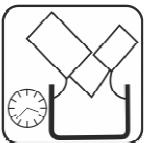

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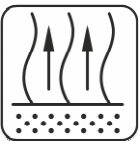




- ✓ Sanded polyester glass laminates (GFK/GRP).
- ✓ 2K polyester putties, polyester spraying fillers.
- ✓ Wash primers.
- ✓ 2K acrylic primers.
- ✓ 2K epoxy primers.
- ✓ Old finishes in good condition after sanding and degreasing.

Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended:

- by hand (dry or wet): P280÷P320 (GRP P400),
- by machine (dry): P180÷P220.

APPLICATION PROCESS

	<p>USE For car repairs as a filling primer.</p>						
	<p>Mixing Ratio by volume</p> <table> <tr> <td>Filler</td> <td>4</td> </tr> <tr> <td>Hardener</td> <td>1</td> </tr> <tr> <td>Thinner</td> <td>0÷5%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>	Filler	4	Hardener	1	Thinner	0÷5%
Filler	4						
Hardener	1						
Thinner	0÷5%						
	<p>Spraying viscosity 30÷50 seconds at 20°C</p>						
	<p>Pot life approx. 60 minutes at 20°C</p>						
	<p>Number of layers 2÷3 layers; Approximately 70÷90µm for one layer.</p> <p>Parameters for RP spray gun Nozzle: 1,6÷2,0 mm; Pressure: 2,0-2,2 bar.</p> <p>Parameters for HVLP spray gun</p>						

	Nozzle: 1,5÷1,9 mm; pressure: 2,0 bar.
	<p>Evaporation Time</p> <p>Between coats: 5÷10 minutes Before baking: approximately 10 minutes</p> <p>Evaporation time depends on temperature and film thickness.</p>
	<p>Curing time for thick layer 150÷180 µm</p> <p>Approx 1hour in 20°C. Approx 10min in 60°C</p> <p>Curing time for thick layer 180÷250 µm</p> <p>Approx 2 hours in 20°C.</p> <p>Temperature below 20°C significantly increases the hardening time.</p>
	<p>IR drying</p> <p>10÷15 minutes under short waves depending on the layer thickness (150÷180µm) and type of radiator. Do not exceed the temperature of 60°C.</p> <p>Use in accordance with the recommendations of the equipment's manufacturer.</p> <p>Wait about 10 minutes before starting the IR drying.</p>
	<p>Dry Sanding:</p> <p>Grinding Machine: P360÷P500. Hand Sanding: P280÷P360.</p>
	<p>Wet Sanding:</p> <p>Grinding Machine: P600÷P1000. Hand Sanding: P800÷P1000.</p>

FURTHER WORK

2K acryl fillers can be directly over coated with:

- ✓ 2-pack acryl topcoats.
- ✓ 1-pack basecoats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- ✓ Clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components between 15 to 25 °C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note:

1. *Close the container after use.*
2. *Protect the hardener from frost and dampness*

WARRANTY PERIOD

HI FIL MAXI FILLER SPEED 4:1 - 12 month from the date of Manufacture.

Hardener 1:4 for HI FIL MAXI FILLER SPEED – 12 months from the date of Manufacture.

Limitation of liability:

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information is based on meticulous laboratory tests and many years of experience. An established position on the market does not release us from continuous quality control of our products. However, we are not responsible for the final effects of improper storage or use of our products, and for work that is not in line with good craftsmanship.

