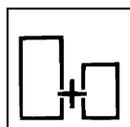
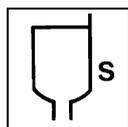


## 04109 - GREEN TI FILLER 5:1 04004 GREEN TI FILLER 5:1 GREY



1000 ml +  
 200 ml +  
 100-300 ml

Pot-life at 20°C  
 2 hours



25° DIN4  
 at 20°C



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



60-200 µ



Stoving at 60°C:  
 20-30 mins  
 Drying time at 20°C:  
 4 hours

### DESCRIPTION

Two-pack high solids polyacrylic filler, chromate-free.

### USE

Suitable as a sealer/filler 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)
- Can be tinted up to 10% of 2K acrylic lacquers (04004)

### SUBSTRATE PREPARATION

#### On knifing polyester putty:

Finish the sanding with P120 - 180 dry grit paper. Degrease with 00695 SOLVENTE ANTISILICONE 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 paintings:

Sand and degrease with 00695 SOLVENTE ANTISILICONE SLOW.

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

### APPLICATION

Spraying.

#### Mixing ratio:

	by volume	by weight
04109-04004 GREEN TI FILLER	1000 ml	1000 g
00109 INDURITORE - 00209 IND.RAPIDO (hardener)		
or	200 ml	130 g
00362 - 00327 INDURITORI HS (hardener)		
00740-1-2-3-00755 DILUENTI (thinners)	100-300 ml	50-200 g

Pot-life: 2 hours at 20°C  
Spray viscosity at 20 °C: 25" DIN 4 (filler)  
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 - 80 µ (sealer)  
180 - 200 µ (filler)  
Coverage (theoretic value): 1 l of product = 6 m<sup>2</sup> by 80 µ  
1 kg of product = 4 m<sup>2</sup> by 80 µ  
V.O.C. of the product ready for use: 465 - 530 g/l

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## **DRYING TIME**

### **Low bake at 60°C:**

20 - 30 mins.

### **Air drying at 20°C:**

dust free 10 mins.

Sand after 4 hours (depending on the thickness of the film)

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## **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.

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## **OVERCOATINGS**

- 04122 HI-GARD SEALER
- ISOAKRYL
- ISOFAN
- ISOCAR
- EXTRALUCIDO
- BSB + ACRIFAN/MACROFAN
- HYDROFAN + MACROFAN CLEARCOAT
- MACROFAN TOP COAT

**TECHNICAL DATA SHEET N° 0318-GB**

**UP DATED 05/2004**

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