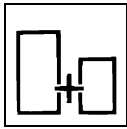




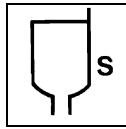
FILLERS



**04001-04004-04007-04109
GREEN TI FILLER**



HS/MH100 Line:
1000 ml +
200 ml +
150-250 ml



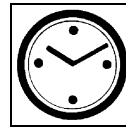
22-25" DIN 4
a 20°C



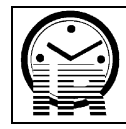
Ø 1,4-1,8 mm
HVLP:
1,5-1,7 mm
N° of coats: 2-3



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.

ULTRA HS Hardeners: Pot life at 20°C:
1000 g + 45-120 min.
100 g +
100-200 g

DESCRIPTION

Two-pack chromate-free polyacrylic filler, with high filling power. Available in 4 coloured versions: 04001 White, 04004 Light Grey, 04007 Dark Grey and 04109 Green.

USE

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

CHARACTERISTICS

- Easy to apply
- Quick drying
- Excellent filling power
- Easy dry sanding
- High coverage (high solids product)
- Possibility of obtaining any grey shade to improve the finishing coat covering and to reproduce the original grey colours of the O.E.M. fillers.
- "Pilot" effect by sanding (04109)

SUBSTRATE PREPARATION

On knifing polyester putty:

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

On bare metal:

Excellent adhesion on bare metal, anyway it is recommended to apply 1-2 coats of 04318 FIX-O-DUR EC or 05720 MONOPRIMER as anticorrosive primer.

On old 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

By mixing the fillers in different ratios, you can obtain the whole shade of grey.

Ex.: by mixing according to the suggested ratios, you can obtain approx. the following grey shade:

04007	100	70	30			
04004		30		100	50	
04001			70		50	100

By spray.

Mixing ratio:

Filler	HS/UHS Hardeners		ULTRA HS Hardeners	Mixture by volume not recommended
04001-04004-04007-04109 GREEN TI FILLER	1000 g	1000 ml	1000 g	
00362-00109-00209 HARDENER or	130 g	200 ml		
MH100-MH110 MACROFAN UHS HARDENER or	130 g	200 ml		
MH400 MACROFAN ULTRA HS HARDENER			100 g	
00740-00741-00742-00755 AUTOREF. THINNERS	100-200 g	150-250 ml	100-200 g	

For spot repairs	HS/UHS Hardeners		ULTRA HS Hardeners	Mixture by volume not recommended
04001-04004-04007-04109 GREEN TI FILLER	1000 g	1000 ml	1000 g	
00174 HS HARDENER EXTRA SPEEDY or	130 g	200 ml		
MH115-MH120 MACROFAN UHS HARDENER or	130 g	200 ml		
MH415 MACROFAN ULTRA HS SPOT REPAIRS			100 g	
00740-00741-00742-00755 AUTOREF. THINNERS	100-200 g	150-250 ml	100-200 g	

	T: 15-35°C			T: 15-25°C	Spot Repairs T: 15-25°C		
HARDENERS	00362-00209	MH400	MH100-MH110	MH115	00174-00109	MH415	MH120
Pot-life at 20 °C	120 min.	120 min.	90 min.	60 min.	60 min.	45 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: according to the gun producer's instructions

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

Air drying at 20°C (substrate temp):	00362 00209-00109 MH400 MH100-MH110		00174 MH415 MH115-MH120	
	Sealer	Filler	Sealer	Filler
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.	
IR Lamps (short waves):				
Flash-off	5-6 min.		Not recommended	
Max. power	10-15 min.			
Distance	60-80 cm.			

SANDING

One-coat finishes:

Dry sanding with P320 (rotorbital)

Wet sanding with P500

Two-coat finishes:

Dry sanding with P400 (rotorbital)

Wet sanding with P600-800

OVERCOAT WITH

- 04122 HI-GARD SEALER
- HYDROFAN / BSB+ Refinish clearcoats from the Lechler range or MACROFAN TOPCOAT

TECHNICAL DATA SHEET N° 0318-GB

UPDATED 01/2015

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