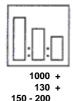
# TECHNICAL DATA SHEET

# 794.91100

# **HS EUROFILLER – ACRYLIC PRIMER 5:1 BLACK**







Ø 1.4 – 1.8 m 4-5 Atm N° 2 coats



Drying at 25 °C: 15'- 20' At 60°C-70°C : 30' – 40'

# **TYPE OF PRODUCT:**

The 5:1 794.91100 bicomponent acrylic base coat is an insulating and highly filling primer, easy and versatile to use. It stands out for application and chalking resistance, fast hardening and easy sanding. In absence of losses and/or contour mappings, it can be used both for final touches and total makeovers. Applicable on duly prepared fillers, polyesters, fiberglass, old bicomponent paints (still tight and intact).

# FIELDS OF APPLICATION:

It can be used as insulating base coat, filler and extra-filler according to the needs and the application pattern. To complete the product, there are 3 different hardeners: Standard, Slow and Fast to be used according to working temperature and / or the size of the piece to be painted.

### PREPARATION OF THE SUPPORT:

The EUROFILLER acrylic base-coat features an excellent adhesion on degreased and sanded metal sheets, on primers, on well-hardened or rubbed old paints, on fillers, polyesters and fiberglass.

# **PRODUCT PREPARATION:**

Thoroughly mix the A component until getting uniform color and consistency. Then blend with the B component as per the following ratio.

| Component                    | Mix in volume | Mix in weight |
|------------------------------|---------------|---------------|
| <b>794.91100</b> primer      | 5             | 100           |
| CZ.711 hardener (*) Standard | 1             | 13            |
| D.737 thinner (*) Standard   | 1-1,3         | 15-20         |

<sup>(\*)</sup> Hardener and thinner shall be chosen according to the environmental conditions and the size of the piece.

Thin the perfectly mixed blend with 15-20% of our thinners for polyacrylics until getting the best viscosity for the desired effect.



# TECHNICAL DATA SHEET

#### Room temperature +15°C +25°C

This is the case of most of the applications. Use Standard hardener and thinner.

### Room temperature +5°C +15°C

In this case, and in particular for small pieces and finishes, use CZ.720 fast hardener and Standard thinner.

### Room temperature +25°C +35°C

Avoid drying the product too fast as this could cause bad application and too many spray fumes. Slow down the drying time of the film by using the **D.727** slow thinner. In case the piece is particularly large (e.g. complete vehicle painting) use the **CZ.700** hardener as well.

In this event we advise against the use of the product as extra-filler.

### **Application patterns**

(ref. to 20 °C room temperature)

| Application Data           | Insulator         | Filler            | Extra-filler    |
|----------------------------|-------------------|-------------------|-----------------|
| Thinning (in weight)       | 15-20             | 13-15             | 13              |
| Nozzle Cup fall            | 1.5-1.7           | 1.5-1.7           | 1.7             |
| No. of coats               | 2-3               | 2-3               | 3-4             |
| Waiting time between coats | 8-10 minutes      | 8-10 minutes      | 10 minutes      |
| Recommended thickness      | 100-125 μm        | 125-150 μm        | 150-200 μm      |
| Pot life                   | 50 minutes        | 50 minutes        | 45 minutes      |
| Hardening at room temp.    | 5 hours           | 5-6 hours         | 6 -8 hours      |
| Oven hardening             | 45 minute at 60°C | 50 minute at 60°C | Not recommended |
| IR medium wave hardening   | 10 minutes        | 10 minutes        | Not recommended |

### **TECHINCAL DATA:**

PRODUCT TYPE : Bicomponent

FILM ASPECT : Matt
COLORS : Black

**SPECIFIC WEIGHT Comp.** (# : 1.50 Kg/l (± 0.05) **DELIVERED VISCOSITY** : Thyrotrophic product

SOLID CONTENTS (A) : 78% (± 2)

DRYING : - Dust free

**'ING** : - Dust free : 10' at 20°C – 25°C

: - Forced drying : 30' - 40' at 60°C – 70°C.

SUGGESTED LAYERS : Two coats SUGGESTED THICKNESS :  $100 - 125 \mu m^{(1)}$ 

**POT- LIFE AT 20° C** : 60'. At higher temperature, pot-life decreases.

# **SAFETY STANDARDS:**

Strictly comply with the prescriptions on the label and the safety sheet.

The data and information included in this sheet are based on our experience and accurate laboratory tests. However the painting process includes a set of operations which go beyond our control, thus they do not represent any guarantee whatsoever as to the final performances of the cycle itself.

<sup>(1)</sup> Do not exceed the suggested max. thickness!