

5+1 FILLER

DEFINITION

Two-component polyurethane filler, insulating and filling, for car-bodies, trucks, buses, and industrial vehicles. The two catalysts allow for modulating the drying speed based on the type of work and environmental conditions. It has a wide adhesion spectrum, excellent filling properties, and is easy to apply and sand. If used undiluted, it is suitable for situations where a high film build is desired in a single coat, while dilution allows for obtaining a smooth and uniform finish.

CHARACTERISTICS

Part A : 5+1 - Filler:

- Density: $1.52 \pm 0.03 \text{ g/cm}^3$
- Color: light grey, dark grey, white, black
- Non volatile content: $68\% \pm 2$
- Viscosity (S3, RPM12, 20°C): $4000 \pm 500 \text{ cP}$

Part B: 5+1- catalyst

- Density: $0.99 \pm 0.03 \text{ g/cm}^3$
- Color: colourless
- Non volatile content: $47\% \pm 2$

Ready-to-use product:

- Chemical nature: polyurethane
- Non volatile content: $66\% \pm 2$
- Viscosity (DIN 8, 20°C): $13 \pm 1 \text{ seconds}$
- Colour: Light grey, dark grey

SUBSTRATE PREPARATION

Surfaces to be treated must be thoroughly degreased, sanded, clean, and dry. Applicable on:

- Bare metal sheet;
- Old finishes/primers;
- Polyester and fiberglass putties;
- Galvanized sheet, after applying Fast Primer or epoxy primer (Z41/Z42)*;

Before application, it is recommended to carry out preliminary tests to check the compatibility of the product with the surface to be treated, considering the wide variety of application conditions and materials available on the market.

The effectiveness of our products is based on practical experiences and research work carried out in our laboratories; nevertheless we accept no liability for work carried out following our instructions being clear that the final result depends in all cases on a series of unforeseeable factors.

* For any information about product codes or packs, please see our catalogue, our price list or contact us.

PREPARATION OF THE MIXTURE

By volume: 5 parts of Part A + 1 part of catalyst

By weight: 100 g of Part A + 12.2 g of catalyst

Mix the two components thoroughly separately and after mixing as per defined ratios.

A second, faster component (Fast Catalyst) is available, which allows the product's curing time to be halved.

For better flow and a finer grain, thin up to 20% by volume (10% by weight). Use a thinner free of acetone and alcohol (Diluyente SP21 or Slow Thinner*). Nitro thinner must absolutely not be used.

POT-LIFE

With standard catalyst cod. 1551CG at 20°C: 60 minutes

With fast catalyst cod. 1551CGF at 20°C: 30 minutes

APPLICATION

Use only a gravity feed spray gun, nozzle Ø 1.7-1.9 mm, pressure according to the spray gun manufacturer's instructions. Up to 3 successive coats of 5+1 Filler can be applied, with an interval of approximately 8-10 minutes between each (necessary for flash-off). It is recommended to apply a dry film thickness of approximately **50-70 microns each coat**.

Do not apply at temperatures below 5°C.

SANDING

Minimum sanding time:

- Air drying at 20°C: 5/7 hours (2/3 hours with Fast Catalyst)
- With IR lamp: 30 minutes

Sequence: P400-P600

OVERPAINTING

It can be overcoated with all enamels commonly used in the bodywork sector.

Due to the variety of coating cycles and application conditions, it is highly recommended to perform preliminary tests to verify the compatibility of the chosen coating system with the applied product. Each cycle must be evaluated in advance, as variables can significantly influence the final result.

STORAGE

Store the product in a dry environment, away from direct sunlight, and at temperatures in between 5°C and 30°C.

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