

# ACRYLIC FILLER 4:1

## OSCCAR 741 HS

### Characteristics:

Filler 4:1 has extremely good filling properties because of the high solid content. Due to good flow, application of even 1 - 3 thick coats provides good sanding behavior. Runs resistant even with application with nozzle diameter 1,5 - 2,2 mm. Filler 4:1 is extremely safe to handle even with thicker layers and gives excellent corrosion protection and optimum adhesion. Suitable for large panels covered with polyesters body fillers. Manual / machine sanding dry.

### Application:

The surface must be cleaned, dry, degreased and matted. Mixing ratio: 4:1 by volume, add thinner for acrylic products 10 - 20 %. Mix thoroughly. Apply with a spray gun with nozzle diameter 1,5 - 2,2 mm in 1 - 3 normal coats with 10 min. flash off at 20°C between the coats.

Drying 20 - 45 min. at 60°C (depend on hardener).

Sand dry with P320 - P500 or wet with P600 - P1000.

### Technical data:

**VOC content:** 2004/42/II B(c)(540) max. 520

#### Filler 741HS (white) :

Shelf-life: 12 months      Density: 1,58 g/cm<sup>3</sup>      Colour: white      Efficiency: 5,5 m<sup>2</sup>/l

#### Filler 741HS (black) :

Shelf-life: 12 months      Density: 1,48 g/cm<sup>3</sup>      Colour: black      Efficiency: 5,5 m<sup>2</sup>/l

#### Filler 741HS (grey) :

Shelf-life: 12 months      Density: 1,55 g/cm<sup>3</sup>      Colour: grey      Efficiency: 5,5 m<sup>2</sup>/l

#### Hardener H741(very fast) :

Shelf-life: 12 months      Density: 1,00 g/cm<sup>3</sup>      Colour: colourless

#### Hardener H741(standard) :

Shelf-life: 12 months      Density: 1,00 g/cm<sup>3</sup>      Colour: colourless

#### Hardener H741(slow) :

Shelf-life: 12 months      Density: 1,00 g/cm<sup>3</sup>      Colour: colourless

#### Hardener H741(universal) :

Shelf-life: 12 months      Density: 1,00 g/cm<sup>3</sup>      Colour: colourless/slightly yellow



#### Mixing ratio 4:1

Filler (A)      100 vol.  
Hardener (B)      25 vol.  
Thinner (C)      10 - 20 vol.



#### Spray viscosity Pot life

25 - 30 sec. at 20°C, Ford cup 4 mm  
up to 1 - 2 hours at 20°C



#### Spray gun

Nozzle diameter: 1,5 - 2,2 mm  
Air pressure as recommended by the spray gun manufacturer



#### Application

1 - 3 normal coats  
Layer thickness: 60 - 80 µm  
Film thickness: 60 - 240 µm



#### Flash – off

10-15 min. at 20°C  
15 - 20 min. at 20°C (with slow hardener)

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### Drying time

20 - 30 min. at 60°C or 3 - 5 h at 20°C (with very fast hardener)  
35 - 45 min. at 60°C or 5 - 8 h at 20°C (with standard hardener)  
60 min. at 60°C or 10 - 12 h at 20°C (with slow hardener)  
35 - 45 min. at 60°C or 5 - 8 h at 20°C (with universal hardener)



### Infrared drying

Short and medium wave: 12 - 15 min.  
Short and medium wave: 12 - 20 min. (with slow hardener)