

## 2K-Derocryl Füller HS

Two component high solid filler on acrylic resin basis, chemical cured with poly-isocyanate (polyurethane)

### Field of application

- Protection against corrosion for iron and steel
- Filler for aluminium and zinc surfaces (grind or sweep)
- Fulfills the deco paint directive for the field of car repairs.

### Product properties

- High Solid
- Resistance to chemicals (on request)
- Resistance to mineral oils
- Fast recoatability
- Recoatability: with polyurethane paints (2K Derocryl)

### Technical Specification

|   |   |  |
|---|---|--|
| Colours   | <b>light grey</b> , redbrown, light beige.  |  |
| Flash point   | >23 °C  |  |
| Temperature stability                               | Up to 120 °C  |  |
| Gloss   | Silky mat   |  |
| Potential dry film thickness in one working process | Up to 80 µm   |  |
| Mixing ratio  | <b>Hardener HL 115</b>  | <b>Hardener HL 401</b>   |
| (Basis:hardener) by weight                          | 7,5:1   | 10:1   |
| (Basis:hardener) by volume                          | 4,8:1   | 6:1  |
| Pot life in hours                                   | 3,5   | 3  |
| Viscosity   | Thixotrope  | Thixotrope   |
| Density in kg/l                                     | 1,6   | 1,61   |
| Solid content in %                                  | 76  | 78   |
| Solid volume in %                                   | 58  | 61   |
| Theoretical spreading capacity                      | <ul style="list-style-type: none"> <li>• 7,25 m²/l at 80 µm DFT</li> <li>• 4,53 m²/kg at 80 µm DFT</li> </ul>   | <ul style="list-style-type: none"> <li>• 7,63 m²/l at 80 µm DFT</li> <li>• 4,74 m²/kg at 80 µm DFT</li> </ul>  |
| Recommended film thickness                          | 125 µm WFT corresponds to 70 µm DFT   | 125 µm WFT corresponds to 80 µm DFT  |
| Drying (DIN EN ISO 1517)                            | 80 µm DFT   | 80 µm DFT  |
| Dust-dry (Tg1)                                      | After 45 min  | After 45 min   |
| Touch-dry (Tg4)                                     | After 5 h   | After 5 h  |
| Dry (Tg6)   | After 8 h   | After 8 h  |
| Cured chemically                                    | After 7 days  | After 7 days   |
| Interval for overcoating                            | <ul style="list-style-type: none"> <li>• after 3 h with two component Derocryl topcoats</li> <li>• Max. after 4 days without slightly sanding</li> </ul>  | <ul style="list-style-type: none"> <li>• after 3 h with two component Derocryl topcoats</li> <li>• Max. after 4 days without slightly sanding</li> </ul> |
| Note  | <ul style="list-style-type: none"> <li>• The specifications are related to the prepared mixture and are based on standard atmospheric conditions 23/50, DIN 50014.</li> <li>• Lower temperatures and/or higher humidity will prolong drying and hardening.</li> <li>• Application below +5 °C is not possible.</li> </ul> |  |

### Safety information (See Security Data Sheet)

|                 |                      |                      |
|-----------------|----------------------|----------------------|
| VOC-level       | Appr. 352 g/l        |                      |
| Solvent content | Appr. 24 % by weight | Appr. 22 % by weight |

## 2K-Derocryl Füller HS

|                               |   |
|-------------------------------|---|
| Aromatic content              | Appr. 7 % by weight   |
| <b>Storage</b>                |   |
| Storage                       | <ul style="list-style-type: none"> <li>• In dry, cool rooms, if possible frost-proof</li> <li>• Ensure good ventilation</li> </ul>  |
| Shelf life                    | <ul style="list-style-type: none"> <li>• 6 month from date of delivery when in unopened original containers in cool and dry conditions</li> </ul>   |
| <b>Application methods</b>    |   |
| Mixing ratio                  | <ul style="list-style-type: none"> <li>• Stirr homogeneous, preferably with mechanical stirrer</li> <li>• Mix base paint and hardener according to the mixing ratio as specified</li> </ul>   |
| Airless spraying              | <ul style="list-style-type: none"> <li>• Flow pressure 180 bar</li> <li>• Nozzle size 0,009 - 0,011 inch (0,23 - 0,28 mm)</li> <li>• Spraying angle according to the geometry and size of the object to be laquered</li> </ul>  |
| Compressed air spraying       | <ul style="list-style-type: none"> <li>• Spraying pressure 4 - 6 bar</li> <li>• Nozzle size 1,5 - 2 mm</li> <li>• Adjust to spraying viscosity (appr. 30 s DIN 4 mm) adding appr. 10 % Derocryl-Verdünnung (two component products: after mixing)</li> </ul>  |
| Electrostatic application     | <ul style="list-style-type: none"> <li>• Application is possible, provided that the material is set to the appropriate conductance for the system concerned</li> </ul>  |
| Dipping                       | <ul style="list-style-type: none"> <li>• Can not be applied as delivered</li> </ul>   |
| Other methods                 | <ul style="list-style-type: none"> <li>• Roller and brush application for repair work is possible</li> </ul>  |
| Thinner                       | <ul style="list-style-type: none"> <li>• Max. 15% Derocryl-Verdünnung</li> </ul>  |
| Cleaning                      | <ul style="list-style-type: none"> <li>• Rinse immediately with Derocryl-Verdünnung</li> </ul>  |
| <b>Preparation of support</b> | <ul style="list-style-type: none"> <li>• Shot blasting to a purity according to SA 2½</li> <li>• If necessary clean with high pressure-cleaner and turbo-cleaner-solution</li> <li>• Sweeping for zinned supports</li> <li>• Mill scale, welding residues, dust, soluble residues from chemical pretreatments and zinc reaction products which might reduce adhesion have to be carefully and thoroughly removed</li> </ul> |
| <b>General remarks</b>        | <ul style="list-style-type: none"> <li>• During coating and drying the humidity should be min. 30 % / max. 85 %</li> <li>• During coating and drying the environmental temperature should be min. 5°C / max. 30°C</li> <li>• Object temperature at least 3° C above dew point.</li> </ul>   |
| <b>Example for a system</b>   | <ul style="list-style-type: none"> <li>• Primer coat: 2K-Derocryl Füller HS</li> <li>• Finish coat: 2K-Derocryl finish GL</li> </ul>  |

*The general information and descriptions contained in this specification are provided to the best of our knowledge. Our information and specifications do not constitute warranted characteristics in the legal sense. Any advice for preparation and application which may be provided verbally, in writing or by means of experiments is of general nature only, and any property rights of third parties are also to be regarded in this context. Our general instructions do not release you from your obligation to check the suitability of the products supplied by our company for the intended methods and purposes of application. Particular in those cases when our supplied material will be applied with products from other sources. The products are prepared, applied and used outside of our sphere of control and thus fall solely within the user's scope of responsibility.*

*Our general terms of sale and delivery apply as agreed.*

Product group: PG0199750000