

## Dynacoat Filler 4100 – D2.02.11



Degreaser

**Product Name :**

### Dynacoat Filler 4100



P220-P320

**Description:**

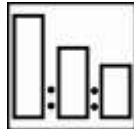
Two pack, white, black and grey colored high build filler with very good sanding and filling properties



P400-P600

**Products and Additives:**

Dynacoat Filler 4100  
Dynacoat Filler 4100 Hardener  
Dynacoat Thinners Fast / Medium / Slow



4:1: (10%)

**Basic Raw Materials:**

Filler : acrylic resin  
Hardener : poly-isocyanate resin



4

**Suitable Substrates:**

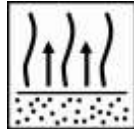
Existing Finishes, including thermoplastic acrylic finishes  
Washprimers,  
Polyester Putties  
Bare steel surfaces  
Dynacoat 2K Epoxy Primer



(gravity)  
1.6-1.8 mm  
2-3 bar

**Surface Preparation:**

**Existing Finishes:** Degrease and sand with P180-P280 grit dry or P400-P600 grit wet  
**Polyester Putties:** Sand with P180-P280 grit dry  
**Bare Steel Surfaces:** Degrease and sand with P80-P180 grit dry



5-10 min.

**Mixing Ratio:**

4 parts by volume of Dynacoat Filler 4100  
1 part by volume of Dynacoat Filler 4100 Hardener  
10% by volume of Dynacoat Thinner (optional)



30 minutes  
at 60°C

**Spraying viscosity**

20-24 seconds at 20°C

**Potlife:**

60 minutes at 20°C



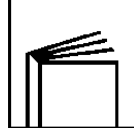
All topcoats

**Spray gun fluid tip and working pressure :**

<b>Spray gun:</b>	<b>Fluid tip:</b>	<b>Pressure :</b>
Gravity feed:	1.6 - 1.8 mm	2-3 bar

**Process:**

Apply 1-3 single coats, allowing for 5 to 10 minutes flash off time between coats. If force dried, allow for a minimum flash-off time of 5-7 minutes before bake.



**Film Thickness:**

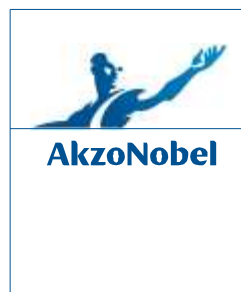
40-50 µm per coat.



**Theoretical cover rate:**

10 m<sup>2</sup> / liter of unthinned paint if applied at 50 µm.

**Note:** The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application



**TECHNICAL INFORMATION**

<b>Cleaning of equipment:</b>	Use Guncleaner or a nitrocellulose thinner						
<b>Drying times:</b>	<table><thead><tr><th></th><th><b>20°C</b></th><th><b>60°C</b></th></tr></thead><tbody><tr><td>Dry to sand*</td><td>3 hrs.</td><td>30-40 min.</td></tr></tbody></table> <p>*Depending on environmental circumstances</p>		<b>20°C</b>	<b>60°C</b>	Dry to sand*	3 hrs.	30-40 min.
	<b>20°C</b>	<b>60°C</b>					
Dry to sand*	3 hrs.	30-40 min.					
<b>Recommended sand paper:</b>	P360-P400 for dry sanding P800-P1000 for wet sanding						
<b>Recoatibility:</b>	All Dynacoat topcoats						
<b>Shelf life:</b>	24 months at temperatures between 5°C and 40°C						
<b>Color:</b>	White, Grey, Black						
<b>VOC</b>	<b>2004/42/IIB(c)(540)526</b> The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC. The VOC content of this product in ready to use form is max. 526 g/liter.						

