

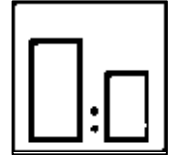
HS Filler 3011 5:1

1.856.3011

HIGH SOLIDS 2K ACRYLIC FILLER - GREY

HS Filler 3011 is a high build 2K acrylic primer-filler. In addition to exceptional filling properties, it is rapid drying, easy sanding and has a high topcoat holdout. User friendly, it is designed for full panels and spot repairs.

HS Filler 3011 is a multipurpose undercoat. It can be used either as a high solid or a medium solid primer-filler.



SUBSTRATES

Bare metal, sanded and degreased (small areas only)
 Polyester putties, sanded with P150-180, Fiberglass (GRP) sanded with P150-180
 Old finishes in sound condition, sanded.

Important:

HS Filler 3011 may be used to seal thermoplastic or solvent sensitive finishes. Test a small area first with thinner: if swelling and reaction take place, strip to bare metal. Otherwise, use HS Filler 3011 as an MS surfacer (2-3 coats) insuring minimum removal of HS Filler 3011 during sanding. Always spray complete panels. Avoid using infrared lamps or force dry on thermoplastic paints.

PREPARATION

Clean surface with mild detergent and water (warm water recommended).
 Sand old finishes with P150-180. Degrease with Antisiliconic Degreaser 3600.
 To improve corrosion resistance on bare metal, apply 1-2 coats of Ecophos.



	HS FILLER		MS SURFACER	
	VOL.	WEIGHT	VOL.	WEIGHT
HS FILLER 3011	1000	1000	1000	1000
HARDENER	200	130	200	130
THINNER	150	90	250	150
VISCOSITY DIN4, 20°C	30-35"		20-25"	
POT LIFE	45'		60'	



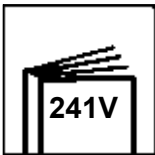
Important:

Addition of flexible additive AD1208: 10-30% on uncatalyzed material.

HARDENERS - THINNERS

HARDENER	6000	Rapid	Panel repairs and touch-ups over 25°C, and all total repairs	
	8000	Extra rapid	Panel repairs under 25°C, touch-up >25°C	
	9000	Super rapid	Touch-up repair below 25°C	
THINNERS	4305	2505	Rapid	Touch-up repair
	4310	2510	Normal	Partial repairs, total repairs below 25°C
	4320	2520	Slow	Overall repairs over 25°C
	4280		Accelerator	For best results under 20°C





APPLICATION

CYCLE	SANDING	
	<i>Conventional</i>	<i>High transfer efficiency</i>
Gun Type		
Gravity gun nozzle mm	1.6 - 2.0	1.6 - 2.0
Pressure at the gun bar	2 - 3 bar	0.3 - 0.7
Number of coats	2-3	2-3
Suggested thickness	150-200 microns	
Maximum thickness	300 microns	



DRYING

AIR DRYING		
Interval between coats		5-10 minutes
Sanding (100 microns, 20°C)		after 4-5 h.
Sanding (more than 100 microns)		overnight
OVEN DRYING		
Flash off time		5-10 minutes
Oven drying		20-30 min. 60°C
INFRARED DRYING		
medium waves		15 minutes
short waves		10 minutes



RECOATABILITY

After Sanding



SANDING

DRY SANDING	P240-280 + P320-400 + Scotch Brite Fine
WET SANDING	P600 + P800

FINISHES

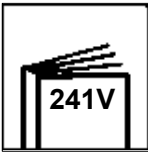
MAXICAR HS, DURALIT CAR, PREMIUM UHS DURALIT, BILUX, AQUAMAX BASECOAT



TECHNICAL DATA

Pack size	1 and 2.5 l
Storage	store in a cool dry place away from heat
Theoretical coverage	4,4 sqm/l of ready-for-use product, 100 microns thickness





VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC.

The VOC content of this product in ready to use form is max. 540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU directive code.

NOTE: Combinations of this product with 1.975.1208 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.



SAFETY AND HANDLING

These products are for professional use only and are not to be used for purposes other than those specified.

The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information, please refer to the material Safety Data Sheet, also available at :

http://www.ppg.com/Maxmeyer_MSDS

For further information please contact **PPG Industries (UK) Limited.**

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