

MEGACOLOR 2-COMPONENT SPECIAL FILLER

PRODUCT INFORMATION



Designation of type	⇒ AC 721	State of 4/18
Product description	⇒ Fast drying 2-component high solid primer filler ⇒ Very good adhesion to steel, cast iron, aluminium, hot dip galvanized steel ⇒ High content of anticorrosion pigments ⇒ Spray dust free processing on large substrates ⇒ Wet in wet-application possible ⇒ Very high filling capacity and high stability on vertical surfaces ⇒ Recoatable with all 1- and 2-component top coats	
Application area	⇒ General industry, heavy protection against corrosion, construction of vehicles	
Binder	⇒ Isocyanate-curing hydroxyacrylic resin	
Substrate/Preparation	⇒ Steel: at least degrease, better hand or eccentric sanding St 2-3 (P80-P220) or sand blasted to Sa 2 ½ DIN EN ISO 12944, part 4 ⇒ Cast iron: sand blasted to Sa 2½ DIN EN ISO 12944, part 4 ⇒ Aluminium: sweeping or hand sanding ⇒ Hot dip galvanized steel: sweeping, hand sanding or wetting agent washing DIN EN ISO 12944, part 4 ⇒ Plywood: without sanding ⇒ All surfaces dry, free of fat, oil, grease and dirt	
Processing	⇒ Gravity feed gun: 1.6-2.0 mm nozzle, 3-4 bar atomizer pressure, 15-20 % thinner VS 15 or VS 40 ⇒ HVLP: 1.7-2.2 mm nozzle, 1.5-2.0 bar atomisation pressure, 10-15 % thinner VS 15 or VS 40 ⇒ Double-diaphragm-pump: 1.0-1.2 mm nozzle, 2-4 bar atomisation pressure, material pressure 0.8-2.0 bar, 10-15 % thinner VS 15 or VS 40 ⇒ Airmix: 0.28-0.33 mm nozzle, 3-4 bar atomisation pressure, material pressure from 70 bar up, 5-15 % thinner VS 15 or VS 40 ⇒ Airless: from 0.28 mm nozzle up, material pressure from 120 bar up, 0-10 % thinner VS 15 or VS 40 ⇒ Electrostatic: optional adjustable ⇒ Dependent on film thickness 1-2 spraying cycles, 3-6 minutes intermediate flash off time ⇒ Ambient temperature: at least + 15° C, relative air humidity: max. 75 % ⇒ Object temperature: at least + 10° C and at least 3° C above the dew point	
Viscosities	⇒ Viscosity at delivery: thixotropic ⇒ Compressed-air spraying: 22- 30 sec. 4 mm / DIN hardened and undiluted ⇒ Double-diaphragm-pump: 30- 40 sec. 4 mm / DIN hardened and undiluted ⇒ Airmix: 40- 60 sec. 4 mm / DIN hardened and undiluted ⇒ Airless: 80-150 sec. 4 mm / DIN hardened and undiluted	
Mixing ratio	⇒ 10 : 1 by weight	
Hardener	⇒ AHP 0030, thoroughly mix filler and hardener, then thin if necessary	

MEGACOLOR 2-COMPONENT SPECIAL FILLER

PRODUCT INFORMATION



Pot life	⇒	Approx. 12 hours at 23° C, use not under + 15° C
Thinner	⇒	VS 15 or VS 40
Drying time at 20° C	⇒	Tack-free after approx. 30 minutes ⇒ Ready for installation after 1-2 hours ⇒ Complete drying after 1-2 days
Recoatability	⇒	Wet in wet after 10-15 min (stripped off matt) or after no sticking ⇒ With all 1- and 2-component top coats ⇒ In case of doubt, check the recoatability before coating
Colour	⇒	Light grey
Degree of gloss	⇒	Flat
Specific weight	⇒	Approx. 1.4 g/cm ³
Solid matter content	⇒	Approx. 68 % (percent by weight)
Solvent content	⇒	Approx. 32 % (percent by weight)
Film thickness	⇒	50-120 µm dry film thickness / 120-290 µm wet film thickness ⇒ At sand blasted to Sa 2½ (roughness depth 45 µm) at least 60 µm dry film thickness
Theoretical coverage	⇒	Approx. 7.0 m ² /kg at 50 µm dry film thickness
Practical consumption	⇒	Compressed-air spraying: approx. 0.20 kg/m ² or 4.9 m ² /kg at 50 µm dry film thickness ⇒ Airless: approx. 0.29 kg/m ² or 3.5 m ² /kg at 80 µm dry film thickness
VOC-value ready for use	⇒	490 g/l ⇒ Limiting value paint material for buildings: 500 g/l 2004/42/IIA(j)(500)490 ⇒ Limiting value car repair coating: 540 g/l 2004/42/IIA(c)(540)490 ⇒ Limiting value industrial coating: no specification Coat of other metal and plastic surfaces
Standard packaging	⇒	Filler 10.0 kg / 25.0 kg ⇒ Hardener 1.0 kg / 2.5 kg
Shelf life	⇒	Filler at + 10 to + 30° C and unopened packaging 1 year, hardener ½ year
Material safety data sheet	⇒	Filler No. 007, hardener No. 050
Flash point	⇒	> + 23° C