airo-chemie
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chemisch-technische Produkte
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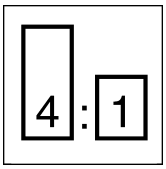
TÜVRheinland CERT ISO 9001

DA 1401 EN

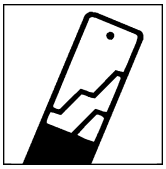
Technical Data Sheet - Product Information

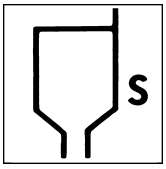
Product: UNICRYL ACRYL-FÜLLER 4:1

Characteristics:
Universal 2c acrylic filler
Excellent filling properties, quick drying and easy to sand.
Depending on the degree of dilution UNICRYL ACRYL-FÜLLER can be used as primer, high build filler or non-sanding-sealer (wet on wet).
Adhesion on zinc-galvanised sheets, hot dip galvanised sheets, sheet steel, sanded old paint and glass-fibre reinforced body parts based on polyester resin.



Range of application:
Car-refinishing, heavy vehicles and industry



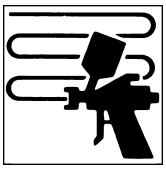


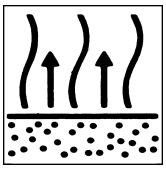
Instructions for use:
Clean surface from dirt and grease. Remove rust and lacquer coat.
Rough up surface with abrasive paper or sand blast.

Thoroughly stir up and mix
4 parts base UNICRYL ACRYL-FÜLLER 4:1 with
1 part acrylic hardener for airo acrylic fillers.

Allow for a 5 minute pre-reaction time before application.

Please close the product packages thoroughly and protect against humidity.





Mixing ratio:

A: as high build filler:
Unicryl Acryl-Füller 4:1: 4 parts
Härter für Unicryl: 1 part
airo Acryl-Verdünnung: none

B: as primer:
Unicryl Acryl-Füller 4:1: 4 parts
Härter für Unicryl: 1 part
airo Acryl-Verdünnung: 5 %

C: as Non Sanding Sealer (wet on wet):
Unicryl Acryl-Füller 4:1: 4 parts
Härter für Unicryl: 1 part
airo Acryl-Verdünnung: 20 - 25 %
(with reference to the total quantity = 5,5-6 part by volume)

Spray viscosity: approx. 14-45 seconds (flow-cup / 4 mm at + 20 °C)
Nozzle-size: 1.5 - 1.8 mm
Spray pressure: 4 - 5 bar

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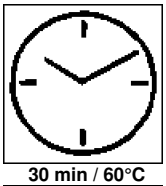
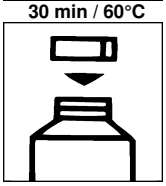
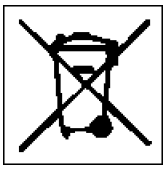
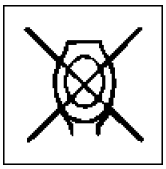
Product: UNICRYL ACRYL-FÜLLER 4:1



30 min / 60°C







Drying time:

With hardener **airo ACRYL-Härter (normal)** for all acrylic fillers 4:1:

a)	Air-drying:	+20 °C:	3 - 4 hours
b)	Oven drying:	+60 °C:	30-35 minutes (after a setting time of 10-15 minutes)
		+80 °C:	20-25 minutes (after a setting time of 10-15 minutes)
c)	IR-drying:		10-15 minutes

With hardener **airo ACRYL-HÄRTER (kurz / rapid)** for all acrylic fillers 4:1:

a)	Air-drying:	+20 °C:	x - x hours
b)	Oven drying:	+60 °C:	xx-xx minutes (after a setting time of 10-15 minutes)
		+80 °C:	xx-xx minutes (after a setting time of 10-15 minutes)
c)	IR-drying:		xx - xx minutes

Chemical basis:

UNICRYL ACRYL-FÜLLER :
acrylic resins, anticorrosion pigments, filling material and solvents

Temperature conditions:
Maerial and surrounding temperatures should range between +18 °C and +25 °C.
Do not apply at temperatures below +15 °C

Storage stability:
12 months in tightly closed tins when kept at + 20 °C.

Disposal consideration:
Disposal according to local regulations.

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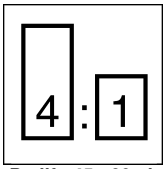
D3 1401 EN

Technical Data Sheet - Product Information

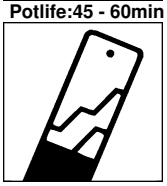
Product: ACRYL-HÄRTER (NORMAL)

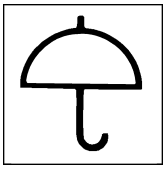
Acrylic Hardener

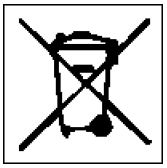
for Premium-Füller HS 4:1 / for Formel S2000 Acryl-Füller HS 4:1

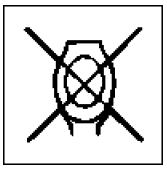


Potlife:45 - 60min









Characteristics:
High speed hardener for all airo acrylic fillers 4:1

Range of application:
Car-refinishing, large vehicles and industry

Instructions for use:
Clean surface from dirt and grease. Remove rust and old lacquer paints.
Rough up surface with abrasive paper or sand blast.

Mix

4 parts	acrylic filler 4:1 with
1 part	hardener the hardener airo ACRYL-HÄRTER **(normal)**

Depending on the desired application dilute with our thinner airo Acryl-Verdünnung.
Allow for a 5 minute pre-reaction time before you apply the mixture.

After use close the product package thoroughly and protect against humidity.

Potlife:
45-120 minutes depending on amount of filler

Chemical basis:
Hardener for Filler HS 4:1: Polyisocyanate in solvents

Temperature conditions:
Material and surrounding temperature should range between +18 °C and +25 °C.
Do not apply at temperatures below +15 °C.

Storage stability:
6 months in tightly closed tins when kept at +20 °C.

Disposal consideration:
Disposal according to local regulations.

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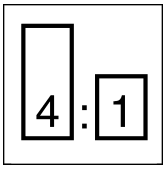
D2 1401 EN

Technical Data Sheet - Product Information

Product: ACRYL-HÄRTER (RAPID)

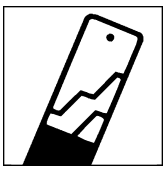
Acrylic Hardener

for Premium-Füller HS 4:1 / for Formel S2000 Acryl-Füller HS 4:1



Characteristics:
High speed hardener for all airo acrylic fillers 4:1

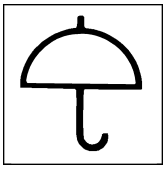
Range of application:
Car-refinishing, large vehicles and industry



Instructions for use:
Clean surface from dirt and grease. Remove rust and old lacquer paints.
Rough up surface with abrasive paper or sand blast.

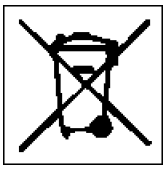
Mix
4 parts acrylic filler 4:1 with
1 part hardener the hardener airo ACRYL-HÄRTER **(rapid)**

Depending on the desired application dilute with our thinner airo Acryl-Verdünnung.
Allow for a 5 minute pre-reaction time before you apply the mixture.

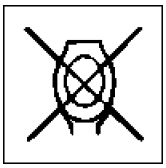


Please thoroughly close the packages after use and protect against humidity.

Potlife:
20-60 minutes depending on amount of filler



Chemical basis:
Hardener for Filler HS 4:1: Polyisocyanate in solvents



Temperature conditions:
Material and surrounding temperature should range between +18 °C and +25 °C.
Do not apply at temperatures below +15 °C.

Storage stability:
6 months in tightly closed tins when kept at +20 °C.

Disposal consideration:
Disposal according to local regulations.

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