

RAXON

540 Filler F1 RAX0784

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TECHNICAL DATA SHEET

APPLICATION:

2 K Polyacrylic Filler, High Build, for wet on wet application in several coats in high quality jobs in Bodyshop, avoiding the sinkages of the Topcoat.
Suitable for Commercial Vehicle and Car Refinishing.
Used as medium thickness filler is easy to sand; as a High Build no thinner is necessary, achieving high film thickness which delays the sanding.

PHYSICAL CHARACTERISTICS:

Density @ 20°C (g/cc)	1,59 ± 0,03
Grinding Finess (u)	25 - 30
Supply Viscosity @ 20°	100 - 105 KU (Stormer)
% age Solid Content (Weight over Volume)	67 % ± 2 weight; 45 % ± 2 volume. (Mixture with hardener)
V.O.C (g/l)	492 (Ready to use) - (2004/42/CE) IIB (C) (540)
Type of Product	Acrylic-Polyurethane
Color	Grey F1, Grey F4, Grey F8

SURFACE PREPARATION:

Good adhesion on cleaned steel, though recommendable to apply on Etch Primer or on previously sanded polyester putties. Also adheres to clean aluminium and on standard and degreased GRP. Leave 3-4 minutes between coats to flash off. Recoatable with all top coats when dried and sanded.

APPLICATION INSTRUCTIONS:

Leave 3-4 mins between coats to flash off. Gravity spray gun. Nozzle 1.8-2.0 mm. 3-4 kg/cm2



4:1 Vol.
540 Hardener Fast
540 Hardener Medium



2 Hours



70-80°
Ford No. 4



1.8 - 2.0 mm.
RaxSolv



2-3 Coats



Touch Free:
45 Mins @ 20°.
Dry:
30 Mins @ 60°



12-15 Mins.



5-10 Mins.



3-4 Hours @ 20°
30 Mins @ 60°
P-320

FEATURES OF DRY FILM:

Theoretical yield (m ² /l)	9 - 10 (50 my)
Gloss 60°-60°	Satin matt
Second layer	2 - 3 h.

STORAGE:

Keep under cover in a cool and well-ventilated place avoiding direct sunlight. Temperatures between 5 and 30°C recommended. Can life: **2 years** from manufacturing in date its original unopened container. Consult our Technical Department once date has expired.