

# RAXON

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## 540 Filler Express RAX0784-F1 RAX0951-F4 RAX0852-F8

### TECHNICAL DATA SHEET

#### APPLICATION:

High Solids Acrylic Filler- quick drying suitable for Industrial Vehicle and Car Refinishing.  
May be used on old topcoats, once degreased and sanded. (Not on Thermoplastic Acrylic Enamels). It stands out for its high thickness and its rapidity of sanding.  
It can be used as High Thicknees Filler or as Filler-Primer by modifying the dilution.

#### PHYSICAL CHARACHTERISTICS:

Density @ 20°C (g/cc)	1,60 ± 0,03
Grinding Finess (u)	25 - 30
Supply Viscosity @ 20°	100 - 105 KU (Stormer)
% age Solid Content (Weight over Volume)	68 % ± 2 weight; 48 % ± 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

#### 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:

For high build: Apply three wet coats leaving 5 mi.



4:1 Vol.  
540 Hardener Fast  
540 Hardener Medium



30-40 Mins  
Potlife



70-80°  
Ford No. 4



1.8 - 2.0 mm.  
RaxSolv



2-3 Coats



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



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



10-12 Mins.



5-10 Mins.



2 Hours @ 20°  
20 Mins @ 60°  
P-320

#### FEATURES OF DRY FILM:

Theoretical yield (m <sup>2</sup> /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.