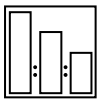
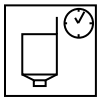
Technical data sheet
ECONOMY
Acrylic filler 5+1

PROPERTIES		
ECONOMY ACRYLIC FILLER – a highly filling primer based on acrylic resins. Thanks to a high spray viscosity, the product can be applied in very thick layers that perfectly repair even relatively large scratches and irregularities of substrate. Unlike our other primers, the product is free of active anti-corrosion additives; hence it is not recommended to be applied directly on steel sheets, since it does not provide optimum anti-corrosion protection.		
RELATED PRODUCTS		
ECONOMY Hardener 5+1	ECONOMY Hardener for acrylic filler 5+1	
THIN 850	Acrylic thinner Standard, Fast and Slow	
PLUS 770	Elasticity increasing agent	LT-04-01
PLUS 750	Acrylic accelerating agent	LT-04-02
PLUS 760	Antisilicone additive	LT-04-04
SUBSTRATES		
Old paint coatings, including thermoplastic paints	Degrease, dry sand with P220 – P280, blow off, degrease again.	
Polyester putties	Dry sand, use P240 - P320 for final sanding, blow off, degrease.	
Epoxy primers	Up to 48 hours without sanding, after 48 hours sand dry with P320, blow off, degrease.	
Steel	Degrease, dry sand with P120, blow off, degrease again.	
Wash primers	Apply after drying.	
Plastics	Degrease with the PLUS 780 degreaser, mat with an abrasive finishing pad, degrease again. Use the PLUS 700 adhesion increasing agent. Use the PLUS 770 elasticity increasing agent if necessary.	
Polyester laminates	Degrease, dry sand with P280, blow off, degrease again.	

MIXING RATIO

		Filling version		Priming version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
	Acrylic filler 5+1 ECONOMY Hardener 5+1 THIN 850	5 1 10	100 12 5	5 1 20	100 12 11

VISCOSITY

		Filling version	Priming version
	DIN 4/20°C	appox. 70 s	appox. 50 s

Apply the thinner in the amount calculated for the primer.

CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC II/B/c limit*	540 g/l
Actual VOC content	510 g/l

* For ready to use mixture acc. to EU Directive 2004/42/CE

APPLICATION CONDITIONS

It is recommended to apply the primer at a temperature above 15°C and a humidity of no more than 80 %.

APPLICATION

		Nozzle	Pressure	Distance
 CAUTION: Instructions of the equipment manufacturer must be followed.	Conventional gravity fed spray gun	1.6 — 1.8mm	3 — 4 bar	15 — 20 cm
	Low-pressure spray gun, HVLP, gravity-fed	1.6 — 1.7 mm	2 bar	10 — 15 cm
	Number of layers	2—3		
	Single dry layer thickness	50 — 60 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	4.5 m^2/l at 100 µm		
	Mixture life at 20˚C	1 h		
	Flash off between layers at 20°C	5 —10 min		

CURING TIMES		
	20°C	60°C
	3 h	30 min
CAUTION: The curing times apply to the temperatures of the individual elements.		

IR DRYING		
	Distance Time depending on the type and power of the lamp	Follow the recommendations of the equipment manufacturer 10 –20 min
CAUTION: Start IR heating no sooner than 10 mins after applying the last layer.		

SANDING		
	Dry sanding	P360 — P500
	Wet sanding	P600 — P1000

THIN 850 ACRYLIC THINNER			
Surface	**15 — 20°C**	**20 — 25°C**	**25 — 35°C**
Small 1-2 elements, spot repair	THIN 850 Fast	THIN 850 Fast	THIN 850 Standard
Medium 3-5 elements	THIN 850 Fast / Standard	THIN 850 Standard	THIN 850 Slow
Large more than 5 elements	THIN 850 Standard / Slow	THIN 850 Slow	THIN 850 Slow

COLOUR
Grey-beige, graphite.

EQUIPMENT CLEANING
THIN 850 acrylic thinner or NC solvent.

STORAGE CONDITIONS
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.

SHELF LIFE	
Acrylic filler 5+1	24 months/20°C
ECONOMY Hardener 5+1	12 months/20°C
THIN 850	24 months/20°C

SAFETY
See Safety Data Sheet.
NOTES
Use the ECONOMY acrylic filler 5+1 with the NOVOL ECONOMY hardener 5+1 only. Use of other hardeners may reduce the anti-corrosion properties and the chemical and mechanical resistance of the filler.
OTHER INFORMATION
Registration number: 000024104. The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.

ADDITIONAL INFORMATION

WEIGHT QUANTITY OF COMPONENTS:

Filling version 5+1+10%

CAUTION!

In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	ECONOMY 5+1	ECONOMY Hardener 5+1	THIN 850
0.10 l	129 g	15 g	7 g
0.15 l	193 g	22 g	10 g
0.20 l	258 g	30 g	14 g
0.25 l	322 g	37 g	17 g
0.30 l	386 g	44 g	21 g
0.40 l	515 g	59 g	27 g
0.50 l	644 g	74 g	34 g
0.75 l	966 g	111 g	51 g
1.00 l	1288 g	145 g	68 g

WEIGHT QUANTITY OF COMPONENTS:

Priming version 5+1+20%

CAUTION!

In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	ECONOMY 5+1	ECONOMY Hardener 5+1	THIN 850
0.10 l	120 g	14 g	13 g
0.15 l	179 g	21 g	19 g
0.20 l	239 g	27 g	25 g
0.25 l	299 g	34 g	32 g
0.30 l	359 g	41 g	38 g
0.40 l	478 g	55 g	51 g
0.50 l	598 g	68 g	64 g
0.75 l	897 g	103 g	95 g
1.00 l	1195 g	137 g	127 g