

# Relocryl 4 + 1 Acrylfiller

gb 1/0413

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## Product Information

Relocryl 4+1 Acrylfiller is filler of high filling power and very easy sandable which may be used either as:  
a.) compact filler or b.) for high thickness coatings.

Even Spot-repairs can be carried out without any inconvenience.

Consumption: 5 - 6 m<sup>2</sup> / l.

Colour shade	white, oxide yellow, grey, black		
Mixing ratio	4:1 by vol.		
Hardener	Relocryl Acryl-Härter Multi MS-Qualität kurz or extra kurz		
Dilution	ca. 10 % Relocryl Acryl-Verdünnung		
Spraying viscosity 20°C	a) 25 - 30 s 4 mm DIN, b) undiluted		
Application	spraying pressure	spraying nozzle	spraying operations
Air / Flowjar - Spray gun	2 - 2.5 bar	1.5 - 1.8 mm	2 - 3
Airless / Airmix	120 - 150 bar	0.33 mm	1 - 2
Pot life	approx. 1 h with hardener H 5, approx. 2 h with H 10		
Coat thickness / dry film	a) 50 - 80 µm                      b) up to 300 µm		
Curing time / Flash off time	approx. 10 - 15 min. before stoving		
Dry	sandable (dry flat with sanding paper P 400 or wet flat with P 600 by 1-coat finishing coating. When using for two pack top coats, sanding either with sanding paper P 500 dry or P 800 wet is recommended)		
Object Temp. 20°C Object Temp. 60°C	after approx. 3 - 5 h after approx. 30 - 40 min.		
VOC content	EU limiting value for the product (cat. B/c): 540 g/l This product contains max. 500 g/l VOC [ 4.17 lbs/gal]		

### Remarks :

Working conditions: from + 10 °C and up to 75 % relative air humidity

On bare substrate, the preliminary application of an adhesion promoter is essential.

Steel or iron areas smaller as the palm of the hand may be directly overcoated.

This data sheet is for information purpose only! To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant safety data sheet and precautions stated on the product label. We reserve our right to make additions, deletions, or modifications to the information at any time without prior notification.