

**GOLD**line

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### TROTON GOLD LINE POLYESTER SPRAY FILLER

#### PRODUCT

TROTON GOLD LINE POLYESTER SPRAY FILLER

Activator for Polyester Spray Filler.

Thinner for polyester spray fillers.

#### PRODUCT DESCRIPTION

High quality 2-pack high build spraying filler with great finishing properties for automotive repairs.

- ✓ Easy to apply.
- ✓ High build properties.
- ✓ Good anti-sagging properties.
- ✓ Isolates very well primers and top coats from polyester putties.

Color - Light Grey.

Gloss Grade – Matt.

Density – 1,63 (+/- 0,03) kg/l.

#### VOLATILE ORGANIC COMPOUNDS

VOC for the mixture = 437 [g/l]

The share of VOC is below 540 g/l. These products fulfill the EU directive (2004/42/EC) that sets the VOC value for this product category (IIIB), as 540 g/l.

#### SUBSTRATE AND SURFACE PREPARATION

The product can be applied on:

- ✓ Well-scuffed and degreased bare steel and aluminum.
- ✓ Well-flatted glass fibre (GFK/GRP), polyester putties, acrylic primers and old finishes in good condition.

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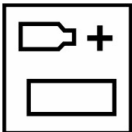
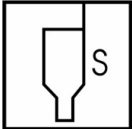
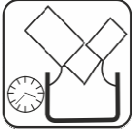
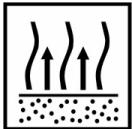
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We recommend sandpaper with gradations: P80÷P240.

**Caution:** Do not apply fillers directly on reactive primers, 1-pack acrylic and nitrocellulose products.

## APPLICATION PROCESS

|                                                                                     |                                                                                                                                                                                                                                                                                                                       |                 |           |                |                 |         |     |
|-------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|-----------|----------------|-----------------|---------|-----|
|    | <p><b>USE</b><br/>For isolating acrylic primers from polyester putties.<br/>For filling small scratches before painting.</p>                                                                                                                                                                                          |                 |           |                |                 |         |     |
|    | <p><b>Mixing ratio</b>                      <b>by volume</b></p> <table> <tr> <td>Putty</td> <td>100 parts</td> </tr> <tr> <td>Hardener</td> <td>6 parts</td> </tr> <tr> <td>Thinner</td> <td>35%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>                                      | Putty           | 100 parts | Hardener       | 6 parts         | Thinner | 35% |
| Putty                                                                               | 100 parts                                                                                                                                                                                                                                                                                                             |                 |           |                |                 |         |     |
| Hardener                                                                            | 6 parts                                                                                                                                                                                                                                                                                                               |                 |           |                |                 |         |     |
| Thinner                                                                             | 35%                                                                                                                                                                                                                                                                                                                   |                 |           |                |                 |         |     |
|   | <p><b>Spraying viscosity</b><br/>50 seconds at 20°C</p>                                                                                                                                                                                                                                                               |                 |           |                |                 |         |     |
|  | <p><b>Pot life</b><br/>approx. 20 minutes at 20°C</p>                                                                                                                                                                                                                                                                 |                 |           |                |                 |         |     |
|  | <p><b>Number of layers</b><br/>1÷3 layers<br/><b>Gun parameters</b><br/>Nozzle: 1,8÷3,0 mm<br/>Pressure: follow the gun manufacturer's instructions, usually 2,0÷2,5 bar.<br/><b>Layer thickness</b><br/>Do not exceed 200µm of thickness for each single wet layer.<br/>Do not exceed total thickness of 600 µm.</p> |                 |           |                |                 |         |     |
|  | <p><b>Flash off time</b></p> <table> <tr> <td>between layers:</td> <td>5÷10 min.</td> </tr> <tr> <td>before baking:</td> <td>approx. 10 min.</td> </tr> </table> <p>The flash off time depends on temperature and layer thickness.</p>                                                                                | between layers: | 5÷10 min. | before baking: | approx. 10 min. |         |     |
| between layers:                                                                     | 5÷10 min.                                                                                                                                                                                                                                                                                                             |                 |           |                |                 |         |     |
| before baking:                                                                      | approx. 10 min.                                                                                                                                                                                                                                                                                                       |                 |           |                |                 |         |     |

|                                                                                   |                                                                                                                                                                                                                                                                                                         |
|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p><b>Drying time</b><br/>2-3 hours at 20°C.<br/>25-30 min. at 60°C.</p> <p>Temperature below 20°C significantly increases the hardening time.</p>                                                                                                                                                      |
|  | <p><b>IR drying</b><br/>5÷7 minutes under short waves depending on the layer thickness (&lt;200µm) and type of radiator. Do not exceed the temperature of 60°C. Use in accordance with the recommendations of the equipment's manufacturer.<br/>Wait about 5 minutes before starting the IR drying.</p> |
|  | <p><b>Sanding</b></p> <p>Finishing sanding (dry): P180÷P320.</p>                                                                                                                                                                                                                                        |

#### EFFICIENCY

1 liter of Spraying Filler is enough to cover an area of approx. 8m<sup>2</sup> with a coat thickness of 100 µm of dry layer.

#### FURTHER WORKS

Polyester Spray Fillers can be over coated with:

- ✓ 2-pack acrylic primers and fillers.
- ✓ 2-pack epoxy primers.
- ✓ 2-pack varnishes.

#### GENERAL NOTES

- ✓ Minimum temperature for application is +10°C.
- ✓ The rooms should be well ventilated.
- ✓ Tools should be washed directly after application.
- ✓ Use the efficient personal protection equipment during the application of 2K products.  
Protect the eyes and air ways.

**Caution:** *To maintain safety, always follow the instructions given in the MSDS of the product.*

#### STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Caution:**

1. Close the containers immediately after application

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*2. Protect the hardener from overheating!***WARRANTY PERIOD**

Troton Gold Line POLYESTER SPRAY FILLER – 12 months from the Date of Manufacture.

Hardener for the polyester putty – 18 months from the Date of Manufacture.

**Limitation of liability:**

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information is based on meticulous laboratory tests and many years of experience. An established position on the market does not release us from continuous quality control of our products. However, we are not responsible for the final effects of improper storage or use of our products, and for work that is not in line with good craftsmanship.

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