



TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

TROTON GOLD LINE HI FIL 5:1



PRODUCT

Troton Gold Line Hi Fil 5:1 – HS high-build acrylic primer
Hardener 1:5 for Troton Gold Line Hi Fil
Thinner for acrylic systems

PRODUCT DESCRIPTION

High quality 2-pack acrylic undercoat for car repairs with low content of volatile compounds:

- ✓ Easy to mix and apply.
- ✓ Very good vertical stability.
- ✓ Excellent filling properties.

Color - 1.Light Grey, 2.Gray, 3.Dark Gray, 4.Black
Gloss Grade – Semi matt.
Density – 1,62 kg/l

VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 494 [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 (B/3), as 540 g/l.

SUBSTRATE PREPARATION

Hi Fil primer can be applied over:

- ✓ Bare steel and aluminum.
- ✓ Polyester laminates (GFK/GRP).
- ✓ 2-pack polyester putties, polyester spraying fillers.
- ✓ Wash primers.

TROTON Sp. z o.o.

Ząbrowo 14A; 78-120 Gościno; Poland

Tel/Fax: +48 94 35 126 22; Tel: +48 94 35 123 94; Website: www.troton.com.pl; Email: troton@troton.com.pl

- ✓ 2-pack acryl fillers.
- ✓ 2-pack epoxy fillers.
- ✓ Old finishes in good condition.

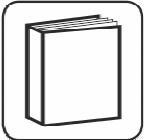
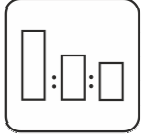
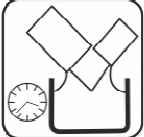
Steel surfaces should be first degreased, dry sanded and degreased again.

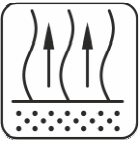
Aluminum and galvanized steel should be degreased, dulled with the abrasive cloth and degreased again.

Old coatings should be degreased, dry sanded and degreased again.

Good preparation is necessary for achieving the best results.

APPLICATION PROCESS

	USE For car repairs as a filling primer.						
	Mixing ratio by volume <table> <tr> <td>Primer</td> <td>5</td> </tr> <tr> <td>Hardener</td> <td>1</td> </tr> <tr> <td>Thinner</td> <td>10 ÷ 15%</td> </tr> </table> Stir well.	Primer	5	Hardener	1	Thinner	10 ÷ 15%
Primer	5						
Hardener	1						
Thinner	10 ÷ 15%						
	Spraying viscosity 30 ÷ 50 seconds at 20°C						
	Pot life approx. 45 minutes at 20°C						
	Number of layers 2 ÷ 3 layers, approx. 200 ÷ 300 µm of dried film thickness. Gun Parameters Gravity: 1,6 ÷ 2,0 mm, Pressure: according to the gun's producer recommendations, usually 2 ÷ 4 bar.						

	Evaporation time Between layers: 5÷10 minutes Before baking: 10÷15 minutes
	Hardening time for 180 µm of dried film thickness Specific dryness at 20°C: after 3-4 hours Specific dryness at 60°C : after 30 minutes Temperature below 20°C significantly decreases the hardening time.
	IR drying 15÷20 minutes under short waves depending on the layer thickness (150÷200µm) and type of radiator. Do not exceed the temperature of 60°C. Use in accordance with the recommendations of the equipment's manufacturer. Wait about 10 minutes before starting the IR drying.
	Dry Sanding By machine P360÷P500. By hand: P280÷P320.
	Wet Sanding By hand: P800÷P1000.

Component quantity by weigh while adding 10% of thinner by volume :

Mixture quantity [ml]	Primer [g]	Hardener [g]	Thinner [g]
100	123	16	8
150	185	24	12
200	247	31	16
300	370	47	24
400	494	63	32
500	617	78	40
1000	1235	157	81
1500	1852	235	121
2000	2470	314	162

Component quantity by weight while adding 15% of thinner by volume:

Mixture quantity [ml]	Primer [g]	Hardener [g]	Thinner [g]
100	118	15	12
150	177	23	17

TROTON Sp. z o.o.

Ząbrowo 14A; 78-120 Gościno; Poland

Tel/Fax: +48 94 35 126 22; Tel: +48 94 35 123 94; Website: www.troton.com.pl; Email: troton@troton.com.pl

200	236	30	23
300	354	45	35
400	472	60	46
500	591	75	58
1000	1181	150	116
1500	1772	225	174
2000	2362	300	232

FURTHER WORKS

2K acrylic primers can be directly over coated with:

- ✓ 2-pack acrylic topcoats.
- ✓ 1-pack basecoats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results you can achieve at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.

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

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.

Note: *After each use the container with products should be immediately closed! Protect hardener against freeze and humidity!*

WARRANTY PERIOD

Troton Gold Line Hi Fil 5:1 - 12 months from the date of Manufacture.

Hardener 1:5 for Troton Gold Line Hi Fil – 12 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.

TROTON Sp. z o.o.
Ząbrowo, Poland.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

TROTON Sp. z o.o.

Ząbrowo 14A; 78-120 Gościno; Poland

TROTON Sp. z o.o.
Ząbrowo, Poland.

Tel/Fax: +48 94 35 126 22; Tel: +48 94 35 123 94; Website: www.troton.com.pl; Email: troton@troton.com.pl