

7080 M8 Acryfill Universal HS Primer Filler

Ver.: 2020-10

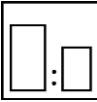
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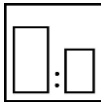
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	7080 M8 Acryfill	4	1000
	7083 2K h Ę	1	167
	7030/7050/7070 Z v b v]	0 t 10 %	0 t 65
	7050/7070	K i Ĩ	t P Ĩ
	7080 M8 Acryfill	4	1000
7083 2K h Ę	1	167	
7050/7070 Z v b v]	0 t 10 %	0 t 65	

APLIKACJA NA ELEMENTACH Z TWORZYWA SZTUCZNEGO / Patrz tabela 1.2

	Proporcje mieszania	Objętościowo	Wagowo
	7080 M8 Acryfill	4	1000
	7083 2K Utwardzacz	1	167
	7035 4Plastic Dodatek adhezyjny do tworzyw sztucznych	10 %	66
	7030/7050/7070 Rozcieńczalnik	0 – 5 % *	0 – 35 % *

* W razie potrzeby dodaj rozcieńczalnik, aby zmniejszyć lepkość.

Application and drying time

	Spray gun set /air inlet		
	Gravity feed 1.4 – 1.8 mm	1.5 – 2.0 bar	
	Suction feed	Verify manufacturer's info	
	Application	<u>Standard application</u>	<u>“high-build” application</u>
	Number of coats	1 – 2	3 – 5
	Flash off	5 – 10 min	5 – 10 min
	Total dry film build	60 – 180 microns	240 – 350 microns
	Drying	<u>Standard application</u>	<u>“high-build” application</u>
	Sanding dry 60°C/140°F	10 – 15 min	20 – 25 min
	Infrared shortwave	5 – 7 min	25 – 40 min
	Sanding dry (20°C/68°F)	3 – 4 h	5 – 7 h
	Potlife at (20°C/68°F)	20 – 40 min	20 – 40 min

Complementary products

- 7083 fast 2K Hardener (shelf life 12 months)
- 7030 Maxx Thinner Fast, 7050 Maxx Thinner Standard, 7070 Maxx Thinner Slow
- 7035 4Plastic Adhesion additive (Plastic primer additive)

Prod. Nr.	Description	Volume	Packaging Box
7080-A-3	White	3 L	2
7080-C-1	Light Grey	1 L	6
7080-C-3	Light Grey	3 L	2
7080-B-3	Dark Grey	3 L	2

Testing of the material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) has to be done at least 15 days after the application.

Additional information

Theoretical coverage:

8,5 m²/L (50 µm layer thickness)

6 m²/L (75 µm layer thickness)

4,5 m²/L (100 µm layer thickness)

3 m²/L (150 µm layer thickness)

Specific weight: 1,46 – 1,49 kg/L

Processing instructions

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60 °C/140 °F. Degrease the surface with Silco antisilicone degreaser. Sand/matt with matting paste. Clean again with Silco antisilicone degreaser. Allow parts to dry completely. ATTENTION: Sanded material must be removed completely! After this preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Additionally, use of Antistatic Degreasing Wipe (art.no. 2215) is recommended. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts (application and adhesion).

VOC

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Shelf life

Min. 24 months from the production date under normal storage conditions and unopened can.

Additional Information

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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Table 1.1 – Mixing ratio by weight (7083 Hardener)

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
100	111	130	137
250	278	324	343
330	367	428	452
500	556	648	685
750	833	972	1028
1000	1111	1296	1370

Table 1.2 – Mixing ratio by weight (Application on plastic)

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + 5Plastic	Weight Primer + Hardener + 5Plastic + Thinner
100	111	130	137	141
250	278	324	343	352
330	367	428	452	464
500	556	648	685	704
750	833	972	1028	1056
1000	1111	1296	1370	1407

7080 Greyscale System chart

	F1	F3		F5		F6		F7
7080-A	100 %	95 %	75 %	-	80 %	-	35 %	-
7080-B	-	5 %	-	-	20 %	50 %	65 %	100 %
7080-C	-	-	25 %	100 %	-	50 %	-	-

* values are in weight %