

## Technical Datasheet



## TDS 20-1-2 Cardea<sup>®</sup> 4+1 High-Build Filler

Description		Cardea <sup>®</sup> 4+1 High-Build filler is a quick drying 2K acrylic filler with good filling properties. It provides thicker film thicknesses to fill in deep surface defects.			
Related Products		Cardea <sup>®</sup> 4+1 High-Build Filler Cardea <sup>®</sup> 4+1 Primer Hardener TDS no: 40-1-1 Cardea <sup>®</sup> Universal Thinners TDS no: 50-2-1			
Substrate		Sanded CED or old painted surfaces, PE putties, steel surfaces, washprimers, epoxy primers.			
Surface Preparation		Degrease with Cardea <sup>®</sup> U-Clean 300 by clean cloth. Genuine parts : fiber cloth or dry sanding - P320 sanding paper Steel : dry sanding - P120 → P220 sanding papers Polyester putty : dry sanding - P180 → P280 sanding papers Old paint : dry sanding - P220 → P320 sanding papers Clean with Cardea <sup>®</sup> U-Clean 300 by clean cloth.			
Mixing		By Volume By Weight			
		Cardea® 4+1 High-Build Filler100100Cardea® 4+1 Primer Hardener2515Cardea® Universal Thinners15 - 3510 - 15			
Viscosity	s	25 – 30 s/20°C (DIN 4)			
Pot Life		30 min (at 20°C)			



The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.





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Spray Gun Parameters	»••••	Gun Type Suction feed spray gun Gravity feed spray gun HVLP Suction feed spray gun	Nozzle size 1,8-2,0 mm 1,6-1,8 mm 1,8-2,0 mm	Air pressure 2 - 4 bars 2 - 4 bars 2 - 2,2 bars		
		HVLP Gravity feed spray gun	1,7-1,9 mm	2 - 2,2 bars 2 - 2,2 bars		
			±,, ±,3 mm	,_ 0015		
Application		2 - 3 coats				
Flash-off Time	<u>)</u> 	Approximately 10 minutes (at 20 °C) until touch-dry.				
		<b>Note:</b> The flash-off time between two coats depends on the application temperature, film thickness and air circulation.				
Drying		60°C / 30 min 20°C / 3 hr				
Dry Film Thickness		70 – 80 μm / coat				
Theoretical Coverage		12 - 12,5 m²/l at 50 μm				
Next Coat		First sanding : P320 F	inish sanding : P80			
		Clean with Cardea <sup>®</sup> U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.				
		Cardea <sup>®</sup> 2K Topcoats and Basecoats. See TDS No: 30-3-1, 30-1-1				
Equipment Cleaning		Use acrylic or cellulosic thinners.				
Package		Cardea <sup>®</sup> 4+1 High-Build Filler : 1 L; 3 L Cardea <sup>®</sup> 4+1 Primer Hardener : 0,25 L; 0,75 L				
Color		Grey				
Safety		Professional use only. See Material Safety Data Sheet.				



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