



DESCRIPTION

HS 540 filler 4:1 that has extremely good filling properties because of the high solid content. Due to good flow, application of even 1 - 3 thick coats provides good sanding behavior. Runs resistant even with application with nozzle diameter 1,5 - 2,2 mm. Filler 4:1 is extremely safe to handle even with thicker layers and gives excellent corrosion protection and optimum adhesion.

APPLICATION SURFACE

Suitable for large panels covered with polyesters body fillers. Manual / machine sanding dry.

APPLICATION METHOD

The surface must be cleaned, dry, degreased and matted. Mixing ratio: 4:1 by volume, add thinner for acrylic products 10 - 20 %. Mix thoroughly. Apply with a spray gun with nozzle diameter 1,5 - 2,2 mm in 1 - 3 normal coats with 10 min. flash off at 20°C between the coats. Drying 20 - 45 min. at 60°C (depend on hardener). Sand dry with P320 - P500 or wet with P600 - P1000.

TECHNICAL DATA

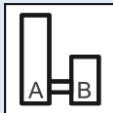
Filler

- Shelf-life: 12 months

- Density: 1,4-1,6 g/cm³
- Efficiency: 5 m²/l
- Colour: blanco, gris y negro
- VOC < 540 g/l

Hardener

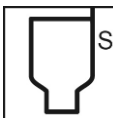
- Mixing ratio: 4:1
- Basecoat: HS Filler 540.
- Pot life: 1-2 hours at 20°C (Pot Life)
- Shelf life 9 months at 20°C unopened container
- Flash point > +23°C



Mixing ratio:

- Filler (A) 100
- Hardener (B) 25

Pot life 20°C: 1 - 2 h. at 20°C



Spray viscosity at 20°C:

25 - 30 sec., Ford no 4 mm



Spray gun:

Nozzle: 1,5 - 2,2 mm

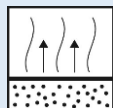
Air pressure as recommended by the spray gun manufacturer.



Application:

Number of coats: 1 - 3

Drying thickness: 60 - 180 µm



Flash-off:
10 min a 20º



Drying time:
20 - 30 min. en 60ºC (VERY FAST HARDENER HS 541)
35 - 45 min. en 60ºC (STANDARD HS 541)



Infrared drying: short and médium wave: 12 - 15 min.

WARNINGS

Application is not recommended at temperatures below 18ºC.

SAFETY INFORMATION

See Safety Data Sheet.

AVAILABLE PACKAGINGS:

Code	Description	Packaging
5009-001146	HS FILLER 540 WHITE	3,6L
5009-001147	HS FILLER 540 GREY	3,6L
5009-001150	HS FILLER 540 BLACK	3,6L

5009-001154	VERY FAST 540 HARDENER	900ML
5009-001159	STANDARD 540 HARDENER	900ML
5009-001160	HS FILLER 540 GREY+ HARDENER 4:1	1L + 250ML
5009-001161	HS FILLER 540 BLACK + HARDENER 4:1	1L + 250ML
5009-001163	HS FILLER 540 WHITE + HARDENER 4:1	1L + 250ML

*For more information about our products or means of application, please visit our website www.carrepairsystem.eu or send us an e-mail to info@carrepairsystem.eu

The technical information and instructions provided in this sheet are based on our own working experience. The company ensures the quality of the product. However, as the uses terms and conditions are out of our control, we decline any responsibility as the final result is concerned.