

# TECHNICAL DATA SHEET



Review 005, 04/2016

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## PRODUCT

BLU FILLER styrene-free (C4116, C4124, C4125, C4126)

## CHARACTERISTICS

Bicomponent filler composed of high-boiling acrylic and methacrylic solvents and quick drying unsaturated polyester resins. BLU filler contains less than 250g/l of volatile organic compounds, in accordance with the Italian Legislative Decree 161 of 27/03/2006 and the relative European Directive 1004/42/EC. Ideal for all car bodywork repair, it can be applied using a spatula and has good adhesion and sanding properties. It can be directly overpainted using any kind of product thanks to its light colour. It is completely odorless and can be applied to bare sheet metal, new sheet metal parts and galvanised sheet metal, inox, aluminium, wood, plastic and directly on polystyrene.

## TECHNICAL DATA

Specific weight	1610 ± 20 g/l	(MI 001)
V.O.C.	30 ± 2 g/l	(ASTM 2369)
Viscosity	980 ± 50 Pas	(MI 002B, 25°C)
Consistency	910 ± 50 Pas	(MI 002B, 25°C)
Colour	Light blu, white, grey	

## STORAGE

Keep the container well closed and stored in a cool (temperature below 25°C) and ventilated environment for a maximum period of 12 months from the date of production marked on the tin. Avoid direct sun exposure.

## SAFETY RULES

Make sure the room is well-ventilated during the application and drying processes. Appropriate PPE must be used when applying the product. Read the safety data sheet carefully before using the product.

## APPLICATION







- Check that the surfaces to be filled are perfectly dry and clean. When applying to bare sheet metal, sand it down first using P 80 and P 150 grit sandpaper;
- Take the desired amount of product from the tin using clean tools, adding 1 - 3 grams of hardening agent for every 100 grams of product;
- Mix well ensuring that the two components are blended together properly;
- Apply the filler on the surface to be treated, taking into account that the product can be sanded down (P 80 – P 120 grit from dry) after around forty minutes; hardening times may vary depending on the room temperature: shorter at temperatures above 25 °C and longer at temperatures below;
- Do not put cured and/or unused filler into the tin as it could damage the entire content;
- Close the tin after use in order to prevent the hardening of the product due to exposure to air.

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	Application	Putty knife
	Hardener	Hardener paste (DBP) 1 - 3 %
	Gel time	10 - 15 min  (MI 003; 25 °C)
	Dry to touch	1 h  (MI 012; 25 °C)
	Full dry	3 h  (MI 012; 25 °C)
	Sanding	After 40 min P 80 – P 120  (MI 012; 25 °C)

## ADDITIONAL INFORMATION

### DRYING (MI 003, MI 012; 3 % of benzoyl peroxide)

TEMPERATURE (°C)	GEL TIME	FULL DRY	SANDING
25	10 - 15 min	3 h	40 min
40	< 10 min	< 1 h	15 min
IR LAMP	/	10 min	10 min

**Note:** depending on the environmental working conditions, the product may appear slightly sticky even 3 hours after application, dried after 24 hours indeed, however this will not effect the above-mentioned characteristics in any way. Adhesion, strength and sanding properties have been proved by laboratory tests performed in extreme environmental conditions (when sanding damp surfaces it is best to use a piece of used sandpaper first, then sand again using new sandpaper). Using an infrared lamp (2000 W) 50-60 cm distance from treated surface, hardening time will be reduced and sanding will be possible after 10-15 min.

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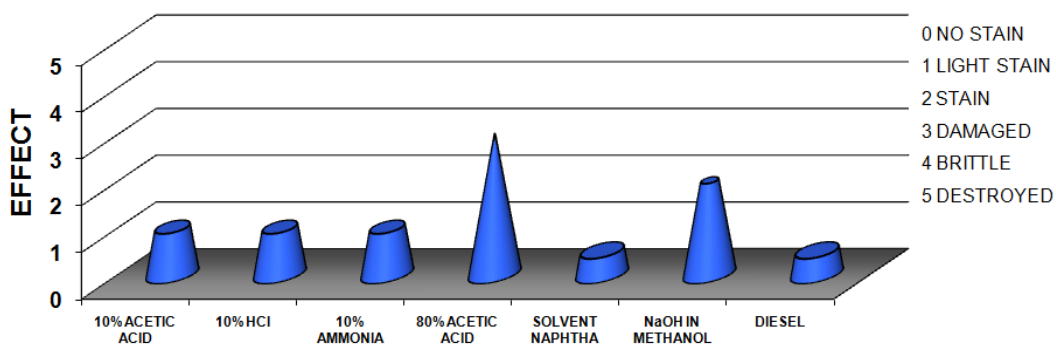
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BLU filler adheres well to various metal substrates: iron, steel, stainless steel, glass, aluminium and galvanised sheet metal. BLU filler can be used also on very elastic substrates like wood, fiberglass, plastic, and directly on polystyrene maintaining a very good adhesion. If it is applied on material not mentioned, you should test its performance before.

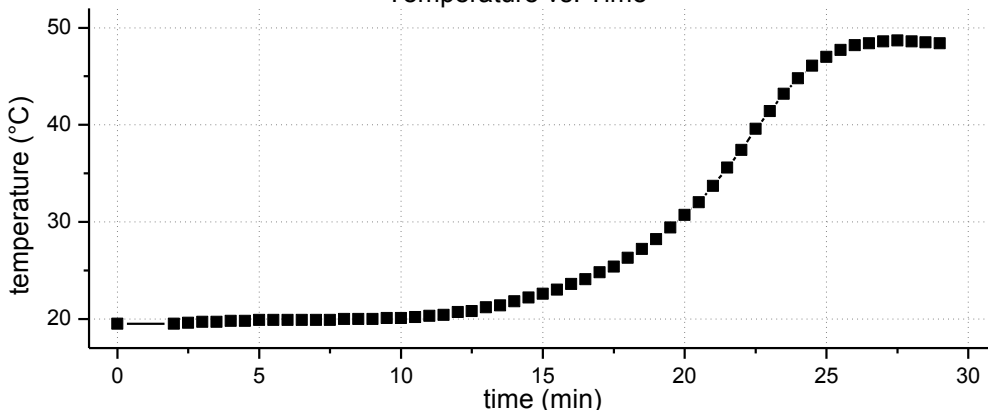
The BLU filler has a very low volume shrinkage. It remains practically unchanged in contact with basic and acidic chemical agents and offers good resistance against organic solvents such as solvent naphtha, lead-free petrol and diesel.

BLU filler has excellent sanding properties even 48 hours after application. In addition to its good hardening time, it has a low volume shrinkage and a low exothermic peak, so it is the ideal filler for molds.

### CHEMICAL RESISTANCE (MI 004)



### Temperature vs. Time



Catalysis (MI 003) has been performed with 2% of benzoyl peroxide