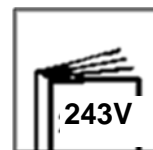




EXPRESS EXPRESS TOPFILLER HS GREY

HIGH SOLIDS 2K ACRYLIC FILLER - GREY



Express Topfiller 3404 is a high build 2K acrylic primer-filler. In addition to exceptional filling properties, it is rapid drying, easy sanding and has a high topcoat holdout. User friendly, it is designed for full panels and spot repairs.

Express Topfiller 3404 is a multipurpose undercoat. It can be used either as a high solid or a medium solid primer-filler.

SUBSTRATES

Bare metal, sanded and degreased (small areas only)

Polyester putties, sanded with P150-180, Fiberglass (GRP) sanded with P150-180

Old finishes in sound condition, sanded.

Important:

Express Express Topfiller 3404 may be used to seal thermoplastic or solvent sensitive finishes. Test a small area first with thinner: if swelling and reaction take place, strip to bare metal. Otherwise, use **Express Topfiller 3404** as an MS surfacer (2-3 coats) insuring minimum removal of **Express Topfiller 3404** during sanding.

Always spray complete panels. Avoid using infrared lamps or force dry on thermoplastic paints.

PREPARATION

Clean surface with mild detergent and water (warm water recommended).

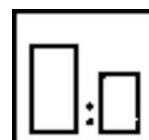
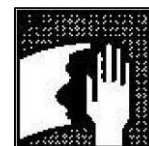
Sand old finishes with P150-180. Degrease with Antisiliconic Degreaser 3600.

To improve corrosion resistance to bare metal, apply an etch primer.

	HS FILLER		HS PRIMER SURFACER	
	VOLUME	WEIGHT	VOLUME	WEIGHT
HS FILLER 3404	5	1000	5	1000
HARDENER	1	130	1	130
THINNER	0.75	90	1.25	150
VISCOSITY DIN4, 20°C	30-35"		20-25"	
POT LIFE	45 minutes @ 20°C		1 hour @ 20°C	

Important:

Addition of flexible additive AD1208: 10-30% on uncatalysed material.

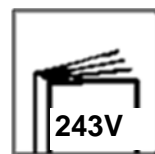




EXPRESS TOPFILLER HS

GREY 1.856.3404

HARDENERS - THINNERS



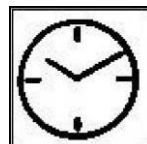
HARDENER	6000		Rapid	Panel repairs and touch-ups over 25°C, and all total repairs
	8000		Extra rapid	Panel repairs under 25°C, touch-up >25°C
	9000		Super rapid	Touch-up repair below 25°C
THINNERS	4305	2505	Rapid	Touch-up repair
	4310	2510	Normal	Partial repairs, total repairs below 25°C
	4320	2520	Slow	Overall repairs over 25°C
	4280		Accelerator	For best results below 20°C

APPLICATION



CYCLE		<u>SANDING</u>	
Gun Type		<i>Conventional</i>	<i>High transfer efficiency</i>
Gravity gun nozzle (mm)		1.6 - 2.0	1.6 - 2.0
Pressure at the gun (bar)		2 - 3	0.3 - 0.7
Number of coats		2 - 3	
Suggested thickness		150-200 microns	
Maximum thickness		300 microns	

DRYING

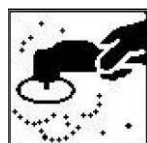


AIR DRY		
Interval between coats		5-10 minutes
Sanding (100 microns, 20°C)		after 4-5 hours
Sanding (more than 100 microns)		overnight
OVEN DRYING		
Flash off time		5-10 minutes
Oven drying		20-30 minutes @ 60°C
INFRARED DRYING		
medium waves		15 minutes
short waves		10 minutes

RECOATABILITY

After sanding

SANDING



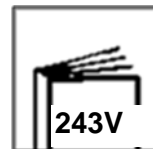
DRY SANDING	240-280 + P320-400 + Scotch-Brite Fine
WET SANDING	P600 + P800



EXPRESS TOPFILLER HS GREY 1.856.3404

FINISHES

2K and Waterborne Topcoats in the MaxMeyer Car Refinish range



TECHNICAL DATA

Pack size	2.5 Ltr
Storage	Store in a cool dry place away from heat
Theoretical coverage	4,4 sqm/l of ready-for-use product, 100 microns thickness



VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU directive code.

NOTE: Combinations of this product with 1.975.1208 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

SAFETY AND HANDLING

These products are for professional use only and are not to be used for purposes other than those specified.

The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information, please refer to the material Safety Data Sheet, also available at:
www.maxmeyer.com



For further information please contact:

PPG Industries (UK) Limited. MaxMeyer Division Customer Service & Sales Group, Needham Road, Stowmarket, Suffolk. IP14 2AD, England. Tel: 01449 771779 Fax: 01449 773495

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