

2K FILLER

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

2K FILLER IS 2K ACRYLIC FILLER ESPECIALLY DEVELOPED FOR USE UNDER 2K ACRYLIC PAINTS AND SOLVENT-BASED BASECOATS. IT DELIVERS EASY APPLICATION AND SANDING AND PROVIDES A GOOD FINAL FINISH

SUITABLE SUBSTRATES

2K FILLER WILL PROVIDE ADEQUATE ADHESION IF APPLIED DIRECTLY TO STEEL, HOWEVER, WE ADVISE FOR SYSTEMS WHICH SHOULD MEET THE HIGHEST STANDARDS TO APPLY 2K FILLER OVER MIDO WASHPRIMER ALLOW FOR A MINIMUM OF 15 MINUTES FLASH-OFF TIME AT 20°C AFTER WASHPRIMER APPLICATION. 2K FILLER CAN BE APPLIED ON PLASTICS PARTS WHICH HAVE BEEN PRECEDED BY; MIDO STARMAX FIBER OR 2K PLASTIC PRIMER

PRODUCT AND ADDITIVES

PDT	2K FILLER
HARDENERS	HARDENER; FOR APPLICATION AT TEMPERATURES AROUND 20°C-25°C FOR SPOT OR PANEL REPAIRS
THINNER	34% ± 2%

BASIC RAW MATERIALS

2K FILLER	ACRYLIC RESINS
MS HARDENERS	POLYISOCYANATE RESIN

SURFACE PREPARATION

SURFACE CLEANING; REMOVE ANY SURFACE CONTAMINATION PRIOR TO SANDING USING AN APPROPRIATE SURFACE CLEANER.
PRE-CLEAN THE SURFACE WITH WARM WATER AND DETERGENT, RINSE SUFFICIENTLY WITH CLEAN WATER.

SANDING; FINAL DRY SANDING STEPS; P180 – P280
RIGID OEM ELECTRO COATED PARTS; FINAL DRY SANDING STEPS; P180 – P280
MIDO POLYESTER BODYFILLERS AND POLYSURFACER; FINISHED WITH; P180 - P280
FEATHEREDGE SANDING FOR SPOT REPAIR, FINISH OUTER AREA WITH P400
FOR DETAILED SURFACE PREPARATION

STIR BEFORE USE

2K FILLER MUST BE STIRRED THOROUGHLY BEFORE USE

TINTING

IF NECESSARY, 2K FILLER CAN BE TINTED WITH UP TO 10 PARTS BY VOLUME WITH MIDO MIX, MIDOMIX PLUS OR AUTO-MIX TONERS
2K FILLER MIXED WITH ANY OF THE TOPCOAT COLOURS MUST BE STIRRED THOROUGHLY BEFORE ADDING HARDENER

FLEXIBLE PARTS

ONCE ELASTICIZED TO THE REQUIRED LEVEL, 2K FILLER CAN BE APPLIED ON PLASTIC PARTS. ALL FLEXIBLE PLASTIC PARTS SHOULD BE PRE-COATED WITH A SUITABLE PLASTIC PRIMER (IN THE CASE OF VIRGIN PLASTIC), OR OEM FINISH



2K FILLER

2K FILLER

TECHNICAL DATA SHEET

VISCOSITY

30-40 SECONDS DIN CUP 4 AT 20°C.

POT-LIFE

HARDENER	1 HOUR AT 20°C
----------	----------------

APPLICATION

APPLY ONE COAT OVER THE TOTAL SANDED AREA. NEXT APPLY THE 2ND AND 3RD COAT WITHIN EACH PRECEDING COAT.
WHERE A FULL PANEL APPLICATION IS REQUIRED APPLY 2-3 COATS OVER THE TOTAL PANEL DEPENDENT ON THE REQUIRED FILM BUILD.
ALLOW EACH COAT TO FLASH-OFF NATURALLY UNTIL THE SURFACE IS COMPLETELY MATT; THIS ALSO SUPPORTS TO ACHIEVE HIGHER FILM BUILD. DO NOT FORCE-DRY WITH AIR SUPPORT. FLASH-OFF BETWEEN THE COATS IS DEPENDENT ON AMBIENT TEMPERATURE, APPLIED LAYER THICKNESS AND AIRFLOW.
FOR MAXIMUM BUILD USE WIDEST FLUID TIP AND LOWER APPLICATION PRESSURE

FILM THICKNESS

BY USING THE RECOMMENDED APPLICATION: 3 COATS; 240-300 MM.

DRYING TIME SANDING

3 HOURS AT 20°C . 2 HOURS AT 40°C. 30 MINUTES AT 60°C.
DRYING TIMES RELATE TO RECOMMENDED APPLICATION (3 COATS) AND OBJECT TEMPERATURE. INDICATED DRYING TIMES RELATE TO THE USE OF P25 HARDENER

ALLOW 5 MINUTES FLASH OFF PRIOR TO INFRA RED CURING
THE PANEL MUST NOT REACH A TEMPERATURE ABOVE 100°C WHILE CURING

FINAL SANDING

FINAL SANDING STEP P500
O INITIAL SANDING STEPS MAY BE EXECUTED WITH A COARSER SANDING GRIT; P360 - P400
O RESPECT A MAXIMUM 100 SANDING GRIT STEP DIFFERENCE OR LESS THROUGHOUT THE SANDING PROCEDURE SINCE 1

FINAL SANDING STEP P1000
O INITIAL SANDING STEPS MAY BE EXECUTED WITH A COARSER SANDING GRIT P600 - P800
O RESPECT A MAXIMUM 200 SANDING GRIT STEP DIFFERENCE OR LESS THROUGHOUT THE SANDING PROCEDURE.
SURFACE CLEANING; REMOVE ANY SURFACE CONTAMINATION PRIOR TO THE APPLICATION OF THE TOPCOAT USING AN APPROPRIATE SURFACE CLEANER.

2K FILLER

TECHNICAL DATA SHEET

RECOATABLED WITH

ALL MIDO TOPCOATS

MATERIAL USAGE

BY USING THE RECOMMENDED APPLICATION, THE THEORETICAL MATERIAL USAGE IS $\pm 4 \text{ M}^2/\text{LITER}$ RTS MIXTURE. THE PRACTICAL MATERIAL USAGE DEPENDS ON MANY FACTORS I.E. SHAPE OF THE OBJECT, ROUGHNESS OF THE SURFACE, APPLICATION TECHNIQUES, PRESSURE AND APPLICATION CIRCUMSTANCES

CLEANING OF EQUIPMENT

MIDO SOLVENTS OR SOLVENT BORNE GUNCLEANERS

VOC

2004/42/II(B)(C)(540)518
THE EU LIMIT VALUE FOR THIS PRODUCT (PRODUCT CATEGORY: IIB. C) IN READY TO USE FORM IS MAX. 540 G/LITER OF VOC. THE VOC CONTENT OF THIS PRODUCT IN READY TO USE FORM IS MAX. 507 G/LITER.

PRODUCT STORAGE

PRODUCT SHELF-LIFE IS DETERMINED WHEN PRODUCTS ARE STORED UNOPENED AT 20°C. AVOID EXTREME TEMPERATURE FLUCTUATION.

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE THE INFORMATION IN THIS DATA SHEET IS NOT INTENDED TO BE EXHAUSTIVE AND IS BASED ON THE PRESENT STATE OF OUR KNOWLEDGE AND ON CURRENT LAWS: ANY PERSON USING THE PRODUCT FOR ANY PURPOSE OTHER THAN THAT SPECIFICALLY RECOMMENDED IN THE TECHNICAL DATA SHEET WITHOUT FIRST OBTAINING WRITTEN CONFIRMATION FROM US AS TO THE SUITABILITY OF THE PRODUCT FOR THE INTENDED PURPOSE DOES SO AT HIS OWN RISK. IT IS ALWAYS THE RESPONSIBILITY OF THE USER TO TAKE ALL NECESSARY STEPS TO FULFILL THE DEMANDS SET OUT IN THE LOCAL RULES AND LEGISLATION. ALWAYS READ THE MATERIAL DATA SHEET AND THE TECHNICAL DATA SHEET FOR THIS PRODUCT IF AVAILABLE. ALL ADVICE WE GIVE OR ANY STATEMENT MADE ABOUT THE PRODUCT BY US (WHETHER IN THIS DATA SHEET OR OTHERWISE) IS CORRECT TO THE BEST OF OUR KNOWLEDGE BUT WE HAVE NO CONTROL OVER THE QUALITY OR THE CONDITION OF THE SUBSTRATE OR THE MANY FACTORS AFFECTING THE USE AND APPLICATION OF THE PRODUCT. THEREFORE, UNLESS WE SPECIFICALLY AGREE IN WRITING OTHERWISE, WE DO NOT ACCEPT ANY LIABILITY WHATSOEVER FOR THE PERFORMANCE OF THE PRODUCT OR FOR ANY LOSS OR DAMAGE ARISING OUT OF THE USE OF THE PRODUCT. ALL PRODUCTS SUPPLIED AND TECHNICAL ADVICES GIVEN ARE SUBJECT TO OUR STANDARD TERMS AND CONDITIONS OF SALE. YOU SHOULD REQUEST A COPY OF THIS DOCUMENT AND REVIEW IT CAREFULLY. THE INFORMATION CONTAINED IN THIS DATA SHEET IS SUBJECT TO MODIFICATION FROM TIME TO TIME IN THE LIGHT OF EXPERIENCE AND OUR POLICY OF CONTINUOUS DEVELOPMENT
IT IS THE USER'S RESPONSIBILITY TO VERIFY THAT
THIS DATA SHEET IS CURRENT PRIOR TO USING THE PRODUCT
BRAND NAMES MENTIONED IN THIS DATA SHEET ARE TRADEMARKS OF OR ARE LICENSED TO INTERNATIONAL GROUP FOR MODERN COATING
HEAD OFFICE

MIDO CAR REFINISHES
INTERNATIONAL GROUP FOR MODERN COATINGS
NEW BORG EL-ARAB CITY 2ND INDUSTRIAL ZONE ALEXANDRIA, EGYPT
WWW.MIDOCOATINGS.COM

INTERNATIONAL GROUP FOR MODERN COATINGS
NEW BORG EL-ARAB CITY, 2ND INDUSTRIAL ZONE
ALEXANDRIA, EGYPT
TEL.: (+203) 4625042/3
FAX: (+203) 4625045