

Technical Data Sheet

4M Filler 1K Black

Characteristic properties

4M Filler 1K Gray is a product based on a nitrocellulose-combination of resins providing very fast drying. The product is suitable for fine filling of small damages on car surface before topcoating with any 4M topcoat.

Viscosity	00:35 - 00:40 sec dil. 2:1 Bu.Ac cup#4 ford
Solid content	64.00 - 68.00%
Density	1.40 - 1.44 gm/cm ³

Materials for application

- 4M Filler 1K Black
- Thinner

Suitable substrate and surface preparation

- this product can be applied directly to:
 - Old paints.
 - Metal surfaces.
 - Polyester paste.
 - Nitro-cellulose paste.
- The surface is sanded using sandpaper:
 - -p600-p800 for sanding using water (automatic or manually)
 - -p360-p400 for dry sanding (automatic or manual)

Instructions for spraying viscosity

Spray 3 layers individually.

Wait (5-10) minutes for complete drying between layers.

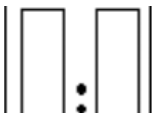







Suspended dust and defective varnish parts can be polished after completely drying for two days at 20°C or 30 minutes at 60°C.

Then crush the defective areas using a very fine sandpaper and then polish them using (polish) manually

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Application conditions

	<p>Mixing ratio by volume: 100:100 (1:1) 100% 4M Filler 1K Black 100% 4M thinner</p>																
	<p>Use mixing ruler</p>																
	<p>Spray gun tips:</p> <table border="1" data-bbox="359 817 1173 952"> <thead> <tr> <th></th> <th>Spray Nozzle</th> <th>Inlet pressure</th> <th>Atomization pressure</th> </tr> </thead> <tbody> <tr> <td>Compliant</td> <td>1.7-1.8</td> <td>2 bars (26- 29 psi)</td> <td></td> </tr> <tr> <td>HVLP</td> <td>1.7-1.8</td> <td>2 bars (26- 29 psi)</td> <td>0.7bar (8-10 psi)</td> </tr> <tr> <td>Conventional</td> <td>1.7-1.8</td> <td>3-3.5 bar (45-50 psi)</td> <td></td> </tr> </tbody> </table> <p>Refer to the spray gun manufacturer's recommendation.</p>		Spray Nozzle	Inlet pressure	Atomization pressure	Compliant	1.7-1.8	2 bars (26- 29 psi)		HVLP	1.7-1.8	2 bars (26- 29 psi)	0.7bar (8-10 psi)	Conventional	1.7-1.8	3-3.5 bar (45-50 psi)	
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	<p>Number of coats:</p> <ul style="list-style-type: none"> Apply 2 coats. Total dry film thickness 40-50 microns. 																
	<p>Flash off time:</p> <ul style="list-style-type: none"> Approximately 5 min between coats. 																
	<p>Sanding:</p> <ul style="list-style-type: none"> Wet sanding: P800-P1000 																
	<p>Machine dry sanding:</p> <ul style="list-style-type: none"> P400-P500 																
	<p>Drying time: Dry to sand: 30 min/20°C</p>																

Packaging	color	Expiry
1.250 kgm	Blck	2 years at 20°C

spray viscosity

- 15 – 1 8sec ford cup 4at

Material safety data

When using these products it is required to comply with the national regulations for health and safety

Certified in ISO 9001, ISO 14001, ISO 45001-Accredited in ISO 17025

For additional information Kindly contact us at info@4mcoatings.com