

Dynacoat Filler 4100 (Sanding version)

A white, black and grey colored two pack, voc compliant high build sanding filler with very good sanding and filling properties.

**MIXING RATIO**

4 Dynacoat Filler 4100
1 Dynacoat Filler 4100 Hardener
10% Dynacoat Thinner (optional)

**MIXING STICK**

Use Dynacoat mixing stick D13

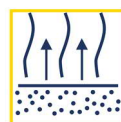
**EQUIPMENT**

Spray gun set-up: 1.6 - 1.8 mm
Application pressure: 1.6 - 2.0 bar at the air inlet*

*See user manual spray gun

**APPLICATION**

1 - 3 Single coats

**FLASH-OFF**

5 - 10 minutes between coats
5 - 10 minutes before bake

**DRYING**

3 - 4 hours at 20°C
30 - 40 minutes at 60°C

**RECOATABLE WITH**

All topcoats

**PROTECTION**

Use suitable respiratory protection. AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

TECHNICAL INFORMATION

DYNACOAT FILLER 4100

— D2.02.11 UK & Ireland

PRODUCT AND ADDITIVES

Dynacoat Filler 4100
 Dynacoat Filler 4100 Hardener
 Dynacoat Thinner Fast / Medium

BASIC RAW MATERIALS

Filler: acrylic resin
 Hardener: poly-isocyanate resin

SUITABLE SUBSTRATES

Existing finishes, including thermoplastic acrylic finishes
 Steel
 Washprimer
 1K Plastics Primer
 Polyester Putties
 2K Epoxy Primer

SURFACE PREPARATION

Existing finishes: Degrease and sand with P220-P320 dry
 Polyester Putties: Sand with P220-P320 dry
 Steel surfaces: Degrease and sand with P220-P320 dry

MIXING

Sanding version
 4 Dynacoat Filler 4100
 1 Dynacoat Filler 4100 Hardener
 10% Dynacoat Thinner (optional)
 Use mixing stick D13

VISCOSITY

Sanding: 20-24 seconds at 20°C

POTLIFE

Sanding: 60 minutes at 20°C

SPRAY GUN FLUID TIP AND WORKING PRESSURE

Sanding
Spray gun: Gravity feed: **Fluid tip:** 1.6 – 1.8 mm **Pressure:** 1.7 – 2.2 bar (see user manual spray gun)
 HVLP max 0.7 at aircap

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APPLICATION	Sanding Apply 1-3 single coats, allowing for 5 to 10 minutes flash off time between coats. If force dried, allow for a minimum flash-off time of 5-10 minutes before bake.		
CLEANING OF EQUIPMENT	Use Dynacoat Guncleaner		
FILM THICKNESS	Sanding:	40-50 µm per coat	
DRYING	Dry to sand	20°C	60°C
	Sanding	3-4 hours	30-40 minutes
	De-nibbing	20 min	
	Infra-red (Short wave)	Half Power	Full Power
		4 min	15 min
RECOMMENDED SANDING GRADE	P400-P500 for dry sanding		
RECOATABILITY	Dynacoat basecoats and topcoats		
PRODUCT STORAGE	Product shelf-life is determined when products are stored unopened at 20°C. Avoid extreme temperature fluctuation.		
SHELF LIFE	2 years at 20°C		
VOC	Sanding version 2004/42/II B(c)(540)540 The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/litre VOC. The VOC content of this product (sanding version) in ready to use form is max. 540 g/litre		

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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 fulfil 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.

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