

TECHNICAL INFORMATION DYNACOAT FILLER 6100 DUO — D2.02.13 UK & Ireland

Dynacoat Filler 6100 DUO (Sanding version)

A white, black and grey colored two pack, VOC compliant medium build fast drying sanding filler with very good sanding and filling properties.



MIXING RATIO

5 Dynacoat Filler 6100 DUO
1 Dynacoat Flexi Hardener
1 Dynacoat Thinner



MIXING STICK

Use Dynacoat mixing stick D15



EQUIPMENT

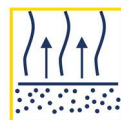
Spray gun set-up: 1.6 - 2.0 mm
Application pressure: 1.7 - 2.0 bar at the air inlet*

*See user manual spray gun



APPLICATION

1 – 3 Single coats



FLASH-OFF

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



DRYING

3 hrs at 20°C
25 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.

Dynacoat Filler 6100 DUO (Non-Sanding, VOC compliant)**MIXING RATIO**

- 6 Dynacoat Filler 6100 DUO
- 1 Dynacoat 420 Hardener
- 3 Dynacoat Thinner 6100 Non-Sanding

**MIXING STICK**

Use Dynacoat mixing stick D16

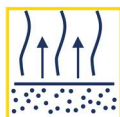
**EQUIPMENT**

Spray gun set-up: 1.2 - 1.4 mm
Application pressure: 1.7 - 2.0 bar at the air inlet*

*See user manual spray gun

**APPLICATION**

1 – 2 Single flowing coats

**FLASH-OFF**

5 - 10 min. between coats
15 - 20 min before recoating

**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 6100 DUO

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PRODUCT AND ADDITIVES

Dynacoat Filler 6100 DUO
 Dynacoat Flexi Hardener Fast / Medium
 Dynacoat 420 Hardener
 Dynacoat Thinner Fast / Medium

BASIC RAW MATERIALS

Filler: acrylic resins
 Hardener: poly-isocyanate resins

SUITABLE SUBSTRATES

Existing finishes, including thermoplastic acrylic finishes
 Steel
 Aluminium (First apply 1K Etch Primer)
 Galvanized steel (First apply 1K Etch Primer)
 1K Etch Primer
 1K Plastics Primer
 Polyester Putties
 2K Epoxy Primer
 Thoroughly cleaned un-sanded OEM Electrocoat

SURFACE PREPARATION

Existing Finishes: Degrease and sand with P280-P320 dry
 Polyester Putties: Sand with P220-P320 dry
 Bare Steel Surfaces: Degrease and sand with P280-P320 dry

MIXING

Sanding

5 Dynacoat Filler 6100 DUO
 1 Dynacoat Flexi Hardener Fast / Medium / Slow
 1 Dynacoat Thinner Fast / Medium / Slow
 Use mixing stick D15

Non-Sanding, VOC compliant

6 Dynacoat Filler 6100 DUO
 1 Dynacoat 420 Hardener
 3 Dynacoat Thinner
 Use mixing stick D16

VISCOSITY

Sanding: 23 - 25 seconds DIN Cup 4 at 20°C
Non sanding: 15 - 18 seconds DIN Cup 4 at 20°C

POTLIFE

Sanding: 60 minutes at 20°C
Non-Sanding, VOC compliant: 90 minutes at 20°C

SPRAY GUN FLUID TIP AND WORKING PRESSURE

Sanding
Spray gun: Gravity feed: **Fluid tip:** 1.6 – 2.0 mm **Pressure:** 1.7 – 2.0 bar (see user manual spray gun)
 HVLP max 0.7 at aircap

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Non-sanding

Spray gun: Gravity feed: 1.2 – 1.4 mm

Fluid tip:

Pressure:

1.7 – 2.0 bar (see user manual spray gun)
HVLP max 0.7 at aircap

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.

Non-sanding

Apply 1-2 single flowing coats, allow 5 - 10 minutes flash off between coats

CLEANING OF EQUIPMENT

Use Dynacoat Guncleaner

FILM THICKNESS

Sanding: 50-60 µm per coat

Non-Sanding: 15-20 µm per coat

DRYING

Dry to sand

Sanding

Non-Sanding

20°C

3 hours

6 hours

60°C

25 minutes

30 minutes

De-nibbing

20 min

Infra-red (Short wave)

Half Power

4 min

Full Power

15 min

THEORETICAL COVER RATE

Ready for use mixture at 1µm dry film thickness sanding

± 400 m²/litre

Ready for use mixture at 1µm dry film thickness non-sanding

± 366 m²/litre

The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

RECOMMENDED SAND GRADE P400-P500 for dry sanding

RECOAT TIME **Non-Sanding**
Allow for a minimum of 20 minutes flash-off time at 20°C before recoating.
Apply topcoat within 6 hours at 20°C

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

COLOR White, Grey, Black

VOC **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.

The VOC content of the (non-sanding) VOC compliant version in ready to use form is max. 540 g/litre.

**TECHNICAL INFORMATION
DYNACOAT FILLER 6100 DUO
— D2.02.13 UK & Ireland****Akzo Nobel Coatings LTD**

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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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