

PROFILLER BLACK

P 2435B

Variant for paintable plastics

Application:	2-component filler based on polyurethane. Very reliable in application; short drying times and very good sanding behavior.
Key Features:	Can be mixed with PROFILLER WHITE at any ratio to produce different shades of grey. Have a look at the Grey Shade Concept to select the best matching shade of grey for the respective basecoat.
Remarks:	Stir well before use.

Solid Content	76 % +/- 2
Density	1.62-1.72 g/cm ³
Storage temperature	5-45 °C
Shelf life	24 months



Cleaning

Plastic substrates:
Clean with PK 600 / PK 1000
Sanding P400>br />Cleaning PK 1000

Handling



Mixing Ratio PreMix:

400 % by volume P 2435B 2K Primerfiller (alternatively: 100g)

100 % by volume A 2420 Plasticizer for polyurethane products (alternatively: 15g)

The amount of FLEX to be added to the 2K products varies and depends on the flexibility of the plastic to be painted. See painting processes.

Safety advice:

2004/42/IIIB(cII)(540)539: The EU limit value for this product (product category: IIB.cII) in ready-for-use form is max 540 grams of VOC per liter. The VOC content of this product is 539 g/l.

It cannot be ruled out that this product contains particles < 0.1 µm.

The products are suitable for professional use only.

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions.

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Mixing Ratio

100 Parts by volume PreMix
(alternatively: 115 g)



Hardener

25 Parts by volume D 70 Undercoat hardener, fast
D 80 Undercoat hardener, medium
(alternatively: 22 g)



Thinner

25 Parts by volume FR 500 THINNER
R 2100 Thinner, fast
R 2200 Thinner, medium
R 2300 Thinner, slow
(alternatively: 13 g)



Spray viscosity at 20°C

DIN 4: 20-24 s **Potlife at 20°C** 1 h
ISO 4: 50-65 s

		HVLP spray gun	Compliant gravity-feed spray gun
Application pressure	bar		2-2.5
Nozzle pressure	bar	0.7	
Nozzle size		1.7-1.9	1.6-1.8
Number of spray coats			2
Flash off at 20°C	min	Flash-off between spraycoats until mat, no flash-off before drying.	
Film thickness	µm	50-70	

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Drying

	Drying at 20°C	4 h
	Drying at 60°C	40 min
	Infrared (short wave)	8 min
	Infrared (medium wave)	10-15 min
Drying Remark		The addition of FLEX increases the drying times of the products.

	Sanding manual, wet	P800
	Orbital sanding, dry	P400 – P500

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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