



## TWO COMPONENT PUR FILLER

# AQUA FÜLLER 41 WV B

- certifications of ÖBB/DB/SBB
- fast drying – sandable after 90 min./60 °C
- due to colouring filler additional basecoat layer is not necessary

Waterborne 2-component PUR filler with very good adhesive and drying properties as well as excellent sandability. Especially designed for use in the rail and general industry.

## TECHNICAL DATA

<b>Colour shade:</b>	NCS 2502 B, RAL and NCS
<b>Gloss degree:</b>	silky mat
<b>Substrate:</b>	Apply a priming coat: EPOXY 41 Universalgrund EPOXY 51 Universalgrund REM PUR 81 Grund wvb EPOXY 61 S Grund

# AQUA FÜLLER 41 WVVB

<b>Shelf life:</b>	at least 18 months
<b>Solids content:</b>	67 +/- 3 % in mixture
<b>Volume-solids content:</b>	calculated 55 +/- 3 % in mixture
<b>Spec. gravity:</b>	1.37 +/- 0.05 g/ml in mixture
<b>Theor. spread rate::</b>	calculated 149 g/m <sup>2</sup> /60 µm DFT

## FURTHER PROCESSING

After air- or stove-drying grinding with sandpaper, graining 320-400 fine, straight through grinding must be avoided. Cleaning with clear water and polishing. Humidity allow to dry up complete. Before over coating surface must be absolute dry and rubbed with a duster.

### Possible subsequent coatings:

REM PUR 310 Decklack  
REM PUR 610 Basislack  
REM PUR Basislack 101  
REM PUR 310 Klarlack

## APPLICATION

### Processing:

Spraying gun, Air spraying with diaphragm pump, Airmix

### Application instructions:

Optimal processing temperature: 18–28 °C

Ideal humidity at processing: 40–60 % R.H.

Maximum humidity at drying process: 80 % R.H.

No processing below 15 °C!

### Delivery viscosity:

DIN 4 mm, 100–120 sec.

### Mixing ratio:

4 parts by weight Aqua Füller 41 wvb

1 part by weight PU-Härter 440

The hardener component has to be stirred mechanically.

### Pot life:

after stirring the hardener component viscosity must be checked by water; approx. 3 hours at 20 °C

### Thinner:

DI-water or rather drinking water quality

Immediately after processing tools have to be cleaned with water, if necessary rinse with thinner 200. The tools must be suitable for waterborne products, consider manufacturer data. Cleaning dilution has to be duly recycled, don't waste into canalisation!

## ADJUST WITH WATER TO RECOMMENDED PROCESSING VISCOSITY.

PROCESSING	NOZZLE TYPE	VISCOSITY	THINNER % BY WEIGHT	PRESSURE
Spraying gun + Diaphragm pump	1,5 mm	30 – 40 sec. DIN 4	ca. 5 – 10 %	4 – 5 bar
Airmix	0,28 mm	40 – 60 sec. DIN 4	ca. 5 %	120 bar

Viscosity data depending on equipment.

## DRYING TIME

DRYING	DEGREE	TIME
Forced drying	reworkable: or:	3 hrs/40 °C/50 µm DFT 90 min/60 °C/50 µm DFT
Drying at room temperature	dust free (TG1): reworkable (TG6):	90 min/20 °C/50 µm DFT 8 hrs/20 °C/50 µm DFT

Allow to flash-off for at least 30 min. at room temperature, before the forced drying process begins.

This data is based on experience, for its completeness we assume no liability. As we take no influence on the processing, it lies within the obligation of the customer to test, whether it is suitable for the intended purpose, before using the product. Any change in the processing procedure, the environmental conditions or the failure to comply with instructions may unfavourably influence the result.