

Dynacoat Filler 4100 (Sanding version)

A white, black and grey coloured 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

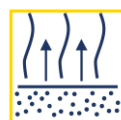
**EQUIPMENT**

Spray gun set-up: 1.6-2.0 mm
Application pressure: 1.7-2.2 bar at the air inlet*

*See user manual spray gun

**APPLICATION**

1-3 x 1 coat

**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.

Dynacoat Filler 4100 (non sanding version)

A white, black and grey coloured two pack filler with good filling properties.

This product is not for sale to vehicle refinishers in the EU, who need to comply with the Directive 2004/42/EC

**MIXING RATIO**

- 4 Dynacoat Filler 4100
- 1 Dynacoat Filler 4100 Hardener
- 1 Dynacoat Thinner

**MIXING STICK**

Use Dynacoat mixing stick D14

**EQUIPMENT**

Spray gun set-up: 1.2-1.4 mm
Application pressure: 1.7-2.2 bar at the air inlet*

*See user manual spray gun

**APPLICATION**

1-2 x 1 coat

**FLASH-OFF**

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

**RECOATABLE**

All topcoats

**PROTECTION**

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

**PRODUCT AND
ADDITIVES**

Dynacoat Filler 4100
 Dynacoat Filler 4100 Hardener
 Dynacoat Thinner Fast
 Dynacoat Thinner Medium
 Dynacoat Thinner Slow

**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 or P400-P600 wet
 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

Non sanding version

4 Dynacoat Filler 4100
 1 Dynacoat Filler 4100 Hardener
 1 Dynacoat Thinners Fast / Medium / Slow

VISCOSITY

Sanding: 20-24 seconds at 20°C
Non sanding: 16-18 seconds at 20°C

POTLIFE

Sanding: 60 minutes at 20°C
Non sanding: 90 minutes at 20°C

**SPRAY GUN FLUID
TIP AND WORKING
PRESSURE**
Sanding

Spray gun: Fluid tip:
 Gravity feed: 1.6 – 2.0 mm

Pressure:
 1.7 – 2.2 bar (see user manual spray gun)
 HVLP max 0.7 at aircap

Non sanding

Spray gun: Fluid tip:
 Gravity feed: 1.2 – 1.4 mm

Pressure:
 1.7 – 2.2 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 10-15 minutes flash off between coats

CLEANING OF EQUIPMENT

Use Dynacoat Guncleaner

FILM THICKNESS

Sanding: 40-50 µm per coat

Non sanding: 20-25 µm per coat

DRYING**Dry to sand**

Sanding

Non sanding

Denibbing

Infra red short wave**20°C**

3-4 hours

1.5 hours

20 min

Half power

4 minutes

60°C

30-40 minutes

30 minutes

Full power

15 minutes

RECOMMENDED SAND PAPER

P400-P500 for dry sanding

P800-P1000 for wet 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

VOC**Sanding version****2004/42/IIB(c)(540)540**

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC.

The VOC content of this product (sanding version) in ready to use form is max. 540 g/liter.

Non sanding version

The VOC content of the non-sanding version in ready to use form is max. 601 g/liter.

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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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