



MULTYFILLER EXPRESS DTM

C19

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ACRYLIC 2K 4:1 PRIMER

DEFINITION

MULTYFILLER EXPRESS DTM is a two-component acrylic primer filler for bodywork repair. In the development of the product, two characteristics have been carefully enhanced: its quality and ease of application in the workshop.

MULTYFILLER EXPRESS DTM possesses a high isolating quality and an excellent adhesion to putties, fillers, properly sanded hardened paints, steel and aluminum.

PHYSICAL CHARACTERISTICS

Nature: Acrylic 2k
Color: ME0 - white
ME1 - light grey
ME3 - medium grey
ME6 - black
Specific weight: 13 lb/gal @ 68°F

	<i>High build filler</i>	<i>Primer Surfacer</i>	<i>Non sanding</i>	
Dry film thickness:	2.8-3.5 mils	2.0 mils	1.2 mils	Per coat
Solids content:	73%	64%	64%	Mixing application
VOC:	3.65 lb/gal Multyfiller Express DTM 4.13 lb/gal	4.46 lb/gal	4.44 b/gal	Mixing application
Yield:	367 f ² /gal	489 - 734 f ² /gal	650 - 734 f ² /gal	Per coat

AUXILIARY PRODUCTS

P4000 Slow hardener
P5000 Standard hardener
P6000 Fast hardener
S322 Standard thinner
NS21 Non sanding convertor

SURFACE PREPARATION

SANDING PROCESS		Putty	Paints OEM	Cataphoresis	Steel	Aluminum
	P240	✓	✓	✓	✓	✓
	DA93	✓	✓	✓	✓	✓

NON SANDING PROCESS		Putty	Paints OEM	Cataphoresis	Steel	Aluminum
	P400	✓	✓	✓	✓	✓
	DA93	✓	✓	✓	✓	✓

MIXING RATIO

		High build filler		Primer Surfacer		Non sanding	
		Vol	Weight	Vol	Weight	Vol	Weight
	Multyfiller Express DTM	4	100	4	100	3	100
	Hardener	1	15	1	15	1,5	30
	NS21	-	-	-	-	1	19
	S322	0 / 10%	0	1	14	-	-
	F/4 @ 68°F	50 sec		19 sec		16 sec	
	P4000	20 - 40 min (*)		20 - 40 min		20 min	
	P5000	20 - 40 min (*)		20 - 40 min		15 min	
	P6000	15 - 35 min (*)		15 - 35 min		10 min	

(*) Pot life data adding 5% of thinner.

APPLICATION METHOD

		<i>High build filler</i>	<i>Primer Surfacer</i>	<i>Non Sanding</i>
	HVLP	0,07 – 0,08 in.	0,06 – 0,07 in.	0,05 – 0,06 in.
		29 - 44 psi	29 - 36 psi	29 - 36 psi
	Coats	2	2	1 - 2
	68°F	5 min	5 min	3 min

DRYING TIMES

		<i>High build filler</i>	<i>Primer Surfacer</i>	<i>Non sanding</i>
 68°F	P4000 - P5000	-	-	Min 15 min Max 60 min
 68°F	P4000	2 hrs	1,5 hrs	-
	P5000	2 hrs	1,5 hrs	> 1 hrs *
	P6000	1,5 hrs	1 hrs	-
 140°F	P4000 - P5000	30 min	30 min	-
 OC 315 in.	FLASH OFF	5 min	5 min	-
	FULL BAKE	7 min	7 min	-

(*) In case of superficial imperfections, it can be sanded after 15 min @ 68°F.

SANDING

		<i>High build filler</i>	<i>Primer Surfacer</i>	<i>Non sanding</i>
 ORBIT 3 - 5	INITIAL	P360	P400	-
	FINAL	P600	P600	SANDING PAD MICROFINE
	INITIAL	P600	P600	-
	FINAL	P800	P800	P1000

COLOR TABLE

<i>Grey Choice</i>	<i>Colors</i>	<i>Mixing ratio % weight</i>				<i>Recommended finishes</i>
R1		100:0 (ME0:ME6)	100:0:0 (ME0:ME3:ME6)	-	-	White Yellow Orange
R2		94:6 (ME0:ME6)	90:10:0 (ME0:ME3:ME6)	100:0 (ME1:ME6)	100:0:0 (ME1:ME3:ME6)	Red
R3		60:40 (ME0:ME6)	0:100:0 (ME0:ME3:ME6)	70:30 (ME1:ME6)	0:100:0 (ME1:ME3:ME6)	Light Green, light blue and light grey. Metallic light green, blue, red and grey. Metallic yellow, beige and orange
R4		35:65 (ME0:ME6)	0:60:40 (ME0:ME3:ME6)	40:60 (ME1:ME6)	0:60:40 (ME1:ME3:ME6)	Dark green, blue and grey. Metallic dark green, blue and grey
R5		0:100 (ME0:ME6)	0:0:100 (ME0:ME3:ME6)	0:100 (ME1:ME6)	0:0:100 (ME1:ME3:ME6)	Black Metallic black

EQUIPMENT CLEANING

Clean with a cleaning thinner before the product hardens.

SAFETY

Follow instructions of product label. For more information check the Material Safety Data Sheets. Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

STORAGE

Store the product in a ventilated place far from direct exposure to sunlight. Keep between +40°F and +90°F.

GUARANTEE

One year in unopened original packaging.

These products are for professional use only. The Safety Data Sheet should be consulted before use and the precautionary warnings on the product packaging should be observed. Its correct use, according to its purpose and respecting its technical and security data, provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U declines any liability due to the incorrect use of any product.

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