



### TDS 20-1-2

## Cardea® 4+1 High-Build Filler

<b>Description</b>	Cardea® 4+1 High-Build filler is a quick drying 2K acrylic filler with good filling properties. It provides thicker film thicknesses to fill in deep surface defects.												
<b>Related Products</b>	Cardea® 4+1 High-Build Filler Cardea® 4+1 Primer Hardener TDS no: 40-1-1 Cardea® Universal Thinners TDS no: 50-2-1												
<b>Substrate</b>	Sanded CED or old painted surfaces, PE putties, steel surfaces, washprimers, epoxy primers.												
<b>Surface Preparation</b>	<div style="display: flex; align-items: flex-start;"> <div style="margin-right: 20px;">    </div> <div> <p>Degrease with Cardea® U-Clean 300 by clean cloth.</p> <p>Genuine parts : fiber cloth or dry sanding - P320 sanding paper Steel : dry sanding - P120 → P220 sanding papers Polyester putty : dry sanding - P180 → P280 sanding papers Old paint : dry sanding - P220 → P320 sanding papers</p> <p>Clean with Cardea® U-Clean 300 by clean cloth.</p> </div> </div>												
<b>Mixing</b>	<div style="display: flex; align-items: center;"> <div style="margin-right: 20px;">  </div> <table border="1" style="border-collapse: collapse; text-align: center;"> <thead> <tr> <th></th> <th>By Volume</th> <th>By Weight</th> </tr> </thead> <tbody> <tr> <td>Cardea® 4+1 High-Build Filler</td> <td>100</td> <td>100</td> </tr> <tr> <td>Cardea® 4+1 Primer Hardener</td> <td>25</td> <td>15</td> </tr> <tr> <td>Cardea® Universal Thinners</td> <td>15 - 35</td> <td>10 - 15</td> </tr> </tbody> </table> </div>		By Volume	By Weight	Cardea® 4+1 High-Build Filler	100	100	Cardea® 4+1 Primer Hardener	25	15	Cardea® Universal Thinners	15 - 35	10 - 15
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<b>Viscosity</b>	<div style="display: flex; align-items: center;"> <div style="margin-right: 20px;">  </div> <p>25 – 30 s/20°C (DIN 4)</p> </div>												
<b>Pot Life</b>	30 min (at 20°C)												



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Spray Gun Parameters		Gun Type	Nozzle size	Air pressure
		Suction feed spray gun	1,8-2,0 mm	2 - 4 bars
		Gravity feed spray gun	1,6-1,8 mm	2 - 4 bars
		HVLP Suction feed spray gun	1,8-2,0 mm	2 - 2,2 bars
		HVLP Gravity feed spray gun	1,7-1,9 mm	2 - 2,2 bars
Application		2 - 3 coats		
Flash-off Time		Approximately 10 minutes (at 20 °C) until touch-dry.		
Drying		60°C / 30 min 20°C / 3 hr		
Dry Film Thickness		70 – 80 µm / coat		
Theoretical Coverage		12 - 12,5 m <sup>2</sup> /l at 50 µm		
Next Coat		<b>Dry sanding</b>	<b>Wet sanding</b>	
		First sanding : P320	First sanding : P500/P600	
		Finish sanding : P400/P500	Finish sanding : P800/P1000	
		<b>Note:</b> If wet sanding will be done, let the surface dry before next coat application.		
		Clean with Cardea® U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.		
		Cardea® 2K Topcoats and Basecoats. See TDS No: 30-3-1, 30-1-1		
Equipment Cleaning		Use acrylic or cellulosic thinners.		
Package		Cardea® 4+1 High-Build Filler : 1 L; 3 L Cardea® 4+1 Primer Hardener : 0,25 L; 0,75 L		
Color		Grey		
Safety		Professional use only. See Material Safety Data Sheet.		