

## TECHNICAL DATA SHEET

### ACRYLIC FILLER

### NOBEL AF5500 ACRYLIC FILLER 2K

#### PRODUCT DESCRIPTION

Nobel AF5500 Acrylic filler 2k is a 2K filler specially developed under Nobel 2K acrylic topcoats and Nobel basecoat colors. It delivers easy application, sanding, good color holds out, and finishes.

#### Uses

Nobel af5500 filler can be applied over PE putties  
body fillers  
original OEM primers  
over well-sanded old finishes in solid conditions.

#### product features

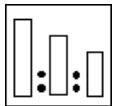

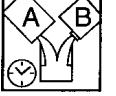


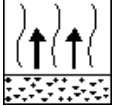




- Made of clear acrylic compound.
- Strong adhesion.
- Excellent hardness.
- Easy application.
- Easy sanding.

#### Substrate and surface preparation

Nobel AF5500 filler can be applied over PE putties/body fillers, 2K Epoxy Primers, 2K Wash Primers, 1K Etch Primers, original OEM primers, GRP, and over well-sanded old finishes in solid conditions. To reach optimum performance, the surface should be properly cleaned



## Application

	<p><b>Mixing ratio by volume</b></p> <table border="1"> <tr> <td><b>NOBEL FILER</b></td> <td><b>HARDENER</b></td> <td><b>2K THINNER</b></td> </tr> <tr> <td>100%</td> <td>25%</td> <td>25%</td> </tr> </table>	<b>NOBEL FILER</b>	<b>HARDENER</b>	<b>2K THINNER</b>	100%	25%	25%	<p><b>Mixing ratio by Weight</b> 100:14:13 For Non- VOC Complaint</p>											
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	<p><b>Application viscosity:</b> 16-20 sec (DIN4 at 20°C)</p>																		
	<p><b>Pot life:</b> 4h at 20°C</p>																		
	<p><b>Spray gun tips:</b></p> <table border="1"> <thead> <tr> <th></th> <th>Spray Nozzle</th> <th>Inlet pressure</th> <th>Atomization pressure</th> </tr> </thead> <tbody> <tr> <td>Compliant</td> <td>1.7-1.8mm</td> <td>2 bars (26- 29 psi)</td> <td></td> </tr> <tr> <td>HVLP</td> <td>1.7-1.8mm</td> <td>2 bars (26- 29 psi)</td> <td>0.7bar (8-10 psi)</td> </tr> <tr> <td>Conventional</td> <td>1.7-1.8mm</td> <td>3-3.5 bar (45-50 psi)</td> <td></td> </tr> </tbody> </table>				Spray Nozzle	Inlet pressure	Atomization pressure	Compliant	1.7-1.8mm	2 bars (26- 29 psi)		HVLP	1.7-1.8mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)	Conventional	1.7-1.8mm	3-3.5 bar (45-50 psi)	
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<p>For best overall results, refer to the spray gun manufacturer's recommendation.</p>																			
	<p>Apply 2 normal coats. Total dry film thickness 80-100 microns.</p>																		
	<p><b>Flash off time:</b> Between coats: 5-7 minutes at 20°C Before baking: 20 min at 20°C</p>																		
	<p><b>Drying time:</b> 3.5-4 h at 20°C 30 min at 60°C</p>																		
	<p><b>IR Drying:</b> Short wave*: 10-15 min *Guideline for IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.</p>																		
	<p><b>Machine dry sanding:</b> P320-P400/P500</p>																		
	<p>P800 or P1000</p>																		

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## General notes

### Recoating

Nobel AF 5500 2K filler can be overcoated after sanding. It is overcoated with 2K topcoats Nobel acrylic and with basecoat colors

### Choice of thinners

Choice of hardener and thinner	Size of repair and temperature			
	Spot and partial repair		Whole car repair	
Temperature	Up to 20°C	Up to 25°C	Up to 30°C	More than 30°C
Hardener	350 h	350/355		360
Thinner	Af800 F	Af800 F		Af 820 more than 30 Af 830 more than 35

Generally, use a slower thinner in fast air movement booths, for large repairs, and high-temperature applications. Use a faster thinner in slow-air movement booths, for small repairs and applications at lower temperatures. For detailed information, please refer to the TDS Nobel Thinners".

### Other tips

1. For optimum application ensure that both spray booth temperature and paint temperature are between 20°C and 25°C.
2. Clean the spray gun thoroughly immediately after the use of 2K products.

### Health and Safety

1. For full Health and Safety information refer to Material Safety Data Sheet (MSDS).
2. Observe the precautionary notices displayed on the container.
3. Goggles and suitable protective equipment must be worn while using these products.
4. Good ventilation must be provided in the working environment.