

**Dynacoat Filler 4100 (Sanding version)**

A white, black and grey colored 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

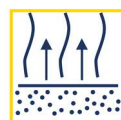
**EQUIPMENT**

Spray gun set-up: 1.6 - 1.8 mm  
Application pressure: 1.6 - 2.0 bar at the air inlet\*

\*See user manual spray gun

**APPLICATION**

1 - 3 Single coats

**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.

**PRODUCT AND  
ADDITIVES**

Dynacoat Filler 4100  
 Dynacoat Filler 4100 Hardener  
 Dynacoat Thinner Fast / Medium

**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  
 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

**VISCOSITY**

**Sanding:** 20-24 seconds at 20°C

**POTLIFE**

**Sanding:** 60 minutes at 20°C

**SPRAY GUN FLUID  
TIP AND WORKING  
PRESSURE**

**Sanding**  
**Spray gun:** Gravity feed  
**Fluid tip:** 1.6 – 1.8 mm  
**Pressure:** 1.7 – 2.2 bar (see user manual spray gun)  
 HVLP max 0.7 at aircap

<b>APPLICATION</b>	<b>Sanding</b> 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.		
<b>CLEANING OF EQUIPMENT</b>	Use Dynacoat Guncleaner		
<b>FILM THICKNESS</b>	<b>Sanding:</b>	40-50 µm per coat	
<b>DRYING</b>	<b>Dry to sand</b>	<b>20°C</b>	<b>60°C</b>
	Sanding	3-4 hours	30-40 minutes
	De-nibbing	20 min	
	<b>Infra-red (Short wave)</b>	<b>Half Power</b>	<b>Full Power</b>
		4 min	15 min
<b>RECOMMENDED SANDING GRADE</b>	P400-P500 for dry sanding		
<b>RECOATABILITY</b>	Dynacoat basecoats and topcoats		
<b>PRODUCT STORAGE</b>	Product shelf-life is determined when products are stored unopened at 20°C. Avoid extreme temperature fluctuation.		
<b>SHELF LIFE</b>	2 years at 20°C		
<b>VOC</b>	<b>Sanding version</b> <b>2004/42/II B(c)(540)540</b> The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/litre VOC. The VOC content of this product (sanding version) in ready to use form is max. 540 g/litre		

**Akzo Nobel Coatings LTD**

**Address:** Unit 2B, Didcot Park  
Churchward, Southmead Industrial Estate  
Didcot, Oxfordshire, OX11 7HB  
**Tel:** +44 (0)1235 862226

**FOR PROFESSIONAL USE ONLY**

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.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3, 2170 BA Sassenheim, The Netherlands. [www.dynacoat.com](http://www.dynacoat.com)