COODE FILLER

Description
COODE FILLER is state of the art primer surfacer with excellent sanding property and high build ability. Besides it has multi function to make the working time shorten. Especially, suitable for water borne basecoat.

Products

<table>
<thead>
<tr>
<th>Code</th>
<th>Name</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>478-794</td>
<td>COODE FILLER WHITE (L90) BASE</td>
<td>4kg</td>
</tr>
<tr>
<td>478-795</td>
<td>COODE FILLER GLAY (L55) BASE</td>
<td>4kg</td>
</tr>
<tr>
<td>478-796</td>
<td>COODE FILLER DARK GLAY (L20) BASE</td>
<td>4kg</td>
</tr>
<tr>
<td>478-741</td>
<td>COODE HARDENER</td>
<td>0.8kg</td>
</tr>
<tr>
<td>478-742</td>
<td>COODE HARDENER (QUICK)</td>
<td>0.8kg</td>
</tr>
</tbody>
</table>

Feature
- Achieved excellent high build ability without sacrificing wettability to sanding mark by new viscosity control technology.
- Moreover, good high build ability under low temperature due to quick hardener.
- Smooth feather edge due to excellent sanding property and wettability of mist.
- Excellent surface smoothness
- Reduce spray times of the top coat and working time by choosing appropriate lightness of the primer surfacer. L90, L70 (L90/L55 = 50/50), L55, L40 (L55/L20 = 50/50), L20
- Not only general primer surfacer application, but also "Wet on wet", "Non sanding*", "Spray putty" applications are available. (* The process without sanding after applying the primer)

Substrate
- Steel
- Galvanize
- Aluminum (A5052P)
- Urethane surface
- OEM surface
- E-coat
- Plastics
- Putty
- *Apply KAR plastic primer(NE) on PP substrate.

Surface preparation
Sand by P240 or finer paper
Degrease by a degreaser

Hardener selection

<table>
<thead>
<tr>
<th>Hardener</th>
<th>Temperature °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>COODE HARDENER</td>
<td></td>
</tr>
<tr>
<td>COODE HARDENER (QUICK)</td>
<td></td>
</tr>
</tbody>
</table>

* Select hardener in consideration of spray area.

Gun setting

<table>
<thead>
<tr>
<th>Gun</th>
<th>W-101 146KPG</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tip φ</td>
<td>1.4 mm</td>
</tr>
<tr>
<td>Gun distance</td>
<td>15 cm</td>
</tr>
<tr>
<td>Air pressure (Mpa)</td>
<td>0.2</td>
</tr>
<tr>
<td>Fluid flow (turns)</td>
<td>3</td>
</tr>
<tr>
<td>Fan pattern</td>
<td>20-25 cm</td>
</tr>
<tr>
<td>Over lap</td>
<td>2/3-3/4</td>
</tr>
<tr>
<td>Spray times</td>
<td>2-3</td>
</tr>
</tbody>
</table>
1. General application

Mixing ratio; COODE FILLER : Hardener : thinner*1
(by weight)  100 : 20 : 10-20

*1; RETAN PG ECO THINNER, RETAN PG ECO HS THINNER

Drying; 15 min / 60℃, More than 1 hr / 20℃

Pot life; 40 min / 10℃, 30 min / 20℃, 10 min / 30℃ Film thickness; 50-70μ

2. Spray putty application

Mixing ratio; COODE FILLER : Hardener : thinner*1
(by weight)  100 : 20 : 5-10

Drying; 15 min / 60℃, More than 1 hr / 20℃

Pot life; 30 min / 10℃, 10 min / 20℃, 5 min / 30℃ Film thickness; 150-250μ

3. For plastics

Mixing ratio; COODE FILLER : Hardener *2 : Hardener *3 : Thinner*1
(by weight)  100 : 20 : 20-40 : 10 : 30-50

*2; 64-381-005 ECO CLEAR HX PLASTIC HARDENER
*3; 381-013 ECO HS CLEAR PLASTIC HARDENER

Drying; 40 min / 60℃

Pot life; 40 min / 10℃, 30 min / 20℃, 10 min / 30℃ Film thickness; 50-70μ

* Available to add RETAN PG HYBRID ECO up to 10% in COODE FILLER.
* At that time, the hardener needs to be added to mixed paint.

4. Non sanding*4, Wet on Wet*5 application

*4 The process without sanding after drying the primer surfacer
*5 The process applying top coat after touch dry of primer surfacer.

Mixing ratio; COODE FILLER : Binder*6 : Hardener : thinner*1
(by weight)  100 : 50 : 100 : 30 : 30-50

Add 30% of hardener and 30-50% of thinner to COODE FILLER with Binder.

Drying; Non sanding application Wet on wet application
20 min / 60℃, 1 hr - 48 hr / 20℃ 5 min - 1 hr after touch dry

Pot life; 120 min / 10℃, 90 min / 20℃, 30 min / 30℃ Film thickness; 30-50μ
5. For plastics

Mixing ratio; COODE FILLER \( \times \) Binder*6 \( \times \) Hardener *2 \( \times \) Hardener *3 \( \times \) Thinner*1

<table>
<thead>
<tr>
<th></th>
<th>COODE FILLER</th>
<th>Binder*6</th>
<th>Hardener *2</th>
<th>Hardener *3</th>
<th>Thinner*1</th>
</tr>
</thead>
<tbody>
<tr>
<td>100</td>
<td>100</td>
<td>50</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>100</td>
<td>30</td>
<td>15</td>
<td></td>
<td></td>
<td>40-60</td>
</tr>
<tr>
<td>100</td>
<td>50</td>
<td>15</td>
<td></td>
<td></td>
<td>50-70</td>
</tr>
</tbody>
</table>

Add appropriate amount of hardener and thinner to COODE FILLER with Binder.

Pot life; 120 min / 10°C, 90 min / 20°C, 30 min / 30°C  
Film thickness; 30-50μ

*6: 478-797 COODE FILLER CLEAR BINDER is recommended to L55 and L20 primer surfacer.  
478-798 COODE FILLER WHITE BINDER is recommended to L90 primer surfacer.  
Available to use RETAN PG HYBRID ECO tinters too.

- In case of dirt treatment on wet on wet application, sand after drying for 30 min at 20°C or 10 min at 60°C.
- Avoid excess film thickness and take enough flash time between each coat with wet on wet process. Also, take enough setting time before forced dry after applying top coat.

Remarks

- Recommend SU WASH COMPOUND for sanding of plastic substrates.
- Use it immediately after mixing hardener
- Use the degreaser during surface preparation.
- Lacquer thinner or Urethane thinner may cause dissolving the film or substrate.
- When apply on OEM or refinished surfaces, sand off all defect portion such as crack or blister.
- Exceeding film thickness at once may cause foaming, especially under high temperature and high humidity condition.
- Recommend NON CROME PRIMER to ensure the adhesion for galvanize, aluminum or stainless steel.

Safety and health

Before use, read SDS precautions.

The data may fluctuate under various conditions,  
All portion of this information may change at any time without notice.