

7080 M8 Acryfill, grey

Universal high build HS acrylic primer filler with its fast drying and easy sanding is suitable for all kind of repairs and different substrates.

- improved filling power
- improved drying time
- easy to sand - saves time, effort, and sanding paper
- direct to metal application, adhesion on Zinc-platted and Aluminium substrates
- possible to apply on plastic parts (in combination with 7035 4Plastic additive)
- VOC compliant
- hardener (vol. 4:1): 9082, 9085

Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner. Before application of the primer filler on bare steel/metal, sand the surface. Bare Steel should be lightly abraded and completely rust free before application. The primer can be applied directly, but a 2K Epoxy primer or Etch primer is recommended where optimum adhesion and corrosion resistance is required. It is recommended to use appropriate primer (epoxy, etch, etc.) to optimize adhesion and corrosion protection on aluminium and galvanized steel surfaces.

- New parts/panels sand with grit P360/dry or P800/wet.
- Old coatings sand with grit P280 - P320/dry or P800/wet.
- GRP or Fiberglass sand with grit P320/dry.
- Polyester Fillers sand with grit P120-P320/dry.
- Zn and Alu: Scuffing pad + matting paste

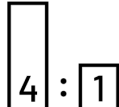
Before applying water-based basecoat clean with an appropriate water-based antsilicone cleaner as also suggested by the producer of water basecoat.

Substrate preparation


4 : 1		By volume	By weight
	7080 M8 Acryfill	4	1000
	9082/9085 2K Hardener	1	150
	7030/7050/7070 Acrylic Thinner	10 %	0 - 60

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Application on plastic

		By volume	By weight
	7080 M8 Acryfill	4	1000
9082/9085 2K Hardener	1	150	
7035 4Plastic Adhesion additive	10 %	60	
7030/7050/7070 Acrylic Thinner	0 - 5 % ⁽¹⁾	0 - 30 ⁽¹⁾	
(1) Add more thinner to adjust spray viscosity.			

Spray gun setup

		
Nozzle	1,4 - 1,8 mm	
Pressure (upper cup)	1,5 - 2 bar	
Pressure (suction cup)	Verify manufacturer's info	

Application

		
Number of coats:	1 - 2	3 - 5
Flash-off between layers:	5 - 10 min	5 - 10 min
Dry film thickness:	60 - 180 µm	240 - 350 µm

Drying

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	Normal application	High build application
Dry to sand (60°C)	10 - 15 min	20 - 25 min
Dry to sand (20°C)	2.5 - 3 h	3 - 4 h
IR shortwave	5 - 7 min	25 - 40 min
Potlife (20°C)	20 - 40 min	

Application on plastic parts

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60 °C/140 °F. Degrease the surface with Silco antisilicone degreaser. Sand/matt with matting paste. Clean again with Silco antisilicone degreaser. Allow parts to dry completely. ATTENTION: Sanded material must be removed completely! After this preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Additionally, use of Antistatic Degreasing Wipe (art.no. 2215) is recommended. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts (application and adhesion).

Complementary products

- 9082/9085 Hardener
- 7030/7050/7070 Acrylic Thinner
- 7035 4Plastic Adhesion additive

Testing of material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) has to be done at least 15 days after the application.

Packaging



Technical data sheet

2024-17

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Product number	Description	Volume/Weight	Packaging
7080-A-1	White	1 L	6
7080-B-1	Dark grey		
7080-C-1	Grey		
7080-A-3	White	3 L	2
7080-B-3	Dark grey		
7080-C-3	Grey		

Volatile organic compounds

The VOC value for this product is 540 kg/L

The product category is VOC 2004/42/IIIB (c)(540)

Physical properties

Theoretical coverage

8,5 m²/L (50 µm layer thickness)

6 m²/L (75 µm layer thickness)

4,5 m²/L (100 µm layer thickness)

3 m²/L (150 µm layer thickness)

Density: 1,65 kg/L

Shelf life

Min. 24 months from the production date under normal storage conditions and unopened can.

Additional information



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FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

All products mentioned in this data sheet are trademarks owned by Silco.

Mixing ratio by weight

Volume of RFU paint required	Weight primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
(ml)	(g)	(g)	(g)
100	122	141	148
250	306	352	370
330	403	464	489
500	611	704	741
750	917	1057	1111
1000	1222	1407	1481



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Volume of RFU paint required	Weight primer	Weight Primer + Hardener	Weight Primer + Hardener + 5Plastic	Weight Primer + Hardener + 5Plastic + Thinner
(ml)	(g)	(g)	(g)	(g)
100	122	141	148	152
250	306	352	370	380
330	403	464	489	501
500	611	704	741	759
750	917	1057	1111	1139
1000	1222	1407	1481	1519

7080 Greyscale System chart

	F1	F3	F5	F6	F7
7080-A	100%	95	75	80	35
7080-B	-	5%	-	20	50 65 100%
7080-C	-	-	25	10	50