



# Axalta A-1827™ 2K Aerosol Fill-In Can



## GENERAL

### DESCRIPTION

A two-component aerosol pre-filled with activator and propellant. It is designed for OEM's as an aerosol fill-in can for Tufcote™ Plus 2K urethane topcoat. A filled A-1827™ aerosol can allows painters to apply color from the convenience of an aerosol container.

Only the E-5208 Aerosol Filling Station may be used for filling.

### SPECIAL NOTES

- The user's manual of the filling device is to be followed.
- Install the filling device in accordance with the manufacturer's instructions in a well-ventilated area.
- Observe the maximum capacity when filling the aerosol can (to avoid risk of explosion).
- Never fill toxic or carcinogenic substances or halogenated hydrocarbons into the can.
- Caution: electrostatic charge. Clean plastic surfaces with a wet cloth only. Consult the filling device manufacturer's guidance related to static charge and explosion resistance.
- For use by a professional, trained painter only.
- Paint residue on the device shall be removed in a manner consistent with the device manufacturer's instructions.
- Check the mode of operation of the compressed-air supply tubes regularly to ensure there are no leaks or cracks in tubing.

### FILL-IN CLEAN FILLING PROCESS

1. Place filling pad on indenter.
2. Place E-5208 Aerosol Filling Station filling cylinder on aerosol can.
3. Put on and push down the E-5208 Aerosol Filling Station cap.
4. Fill with paint.
5. Place Axalta 2K can with filled filling cylinder in the E-5208 Aerosol Filling Station
6. Close the cover by pushing the lever to the right to trigger the filling process. Filling takes about 10 seconds.
7. After filling, remove the cap from the filling cylinder. The pad remains in the cap and shows color.



## MIXING

### COMPONENTS

Tufcote Plus 2K Urethane Enamel Single Stage Topcoat  
Axalta A-1827 Fill-In can (empty)

### MIX RATIO

Ensure Tufcote Plus 2K topcoat is properly stirred before use.

<u>Component</u>	<u>Volume</u>
Tufcote Plus 2K	100 ml
A-1827	1 can



## FILLING

Remove spray nozzle and fill aerosol can with unactivated Tufcote Plus 2K urethane topcoat using E-5208 Aerosol Filling Station.

## ACTIVATING THE AEROSOL

1. Shake the aerosol for two minutes **BEFORE** activating.
2. Take the red button from the cap and turn aerosol 180° and attach button to pin on the bottom of the aerosol.
3. Place the aerosol upside down on a firm surface. Then press the red button until the stop is reached.
4. After activating, shake aerosol for two minutes in order to mix activator with topcoat.

### POT LIFE @ 70°F (21°C)

36-48 hours



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## APPLICATION

Apply Tufcote Plus 2K topcoat over Axalta undercoat or properly sanded and cleaned primed or topcoated surface.

Apply 2-3 coats or until hiding is achieved. Allow 5 minutes of flash time between coats.

Replace cap after use to prevent potential misuse.



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## DRY TIMES

Cure Time At Recommended Thickness – 77°F (25°C) and 50% RH

Air dry: 8 hours

Force dry: 30 minutes at 140°F

## TIPS FOR SUCCESS

### **Avoid damaging the spray can valve.**

Twist the spray head while removing and replacing the part on the spray can. The twisting action will reduce the chances of damaging the valve on the spray can. A damaged valve will result in poor application results.

### **Advise the user to clear the pick-up tube and test for application before use.**

Concentrated color will be in the pick-up tube as a result of the filling operation. This will cause the paint to spit during initial spray. A test spray will clear the tube.

### **The spray head can clog with paint if it is not cleared after every application.**

The user can clear the spray head between applications by inverting the can and purging the pick-up tube with short bursts from the spray head until the spray fan is clear.

### **Do not remove the spray head other than during the filling operation.**

Storing the can without the spray head in place may result in the valve sealing shut, rendering the can useless.

### **Do not store the can above 120°F (49°C) at any time.**

The can may deform or rupture at temperatures above 120°F (49°C).

### **Always point the spray head nozzle away from your face and body.**

This will help reduce the chances of injury due to accidental discharge.



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## PHYSICAL PROPERTIES

All Values Ready To Spray

PWMIR Category:	Exact Match Finish (EMA)
PWMIR Category Limit:	1.50
Maximum MIR:	1.05
Maximum VOC (AP):	623 g/L (5.2 lbs./gal)
Avg. Gallon Weight:	832 g/L (6.95 lbs./gal)
Avg. Weight % Volatiles:	76.2%
Avg. Weight % Water:	0.0%
Avg. Weight % Exempt Solvent:	2.5%
Avg. Volume % Water:	0.0%
Avg. Volume % Exempt Solvent:	2.7%
Flash Point:	See SDS

MIR value when filled with 100 ml of Tufcote mixed color, meets maximum MIR value of 1.50 for Exact Match Finish (automotive) and maximum VOC of 88%.

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## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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