











Product description	
Description	Water-dilutable filler with white pigments. Optionally applicable as one-pack or as two-pack product.
Range of application	
Description	Variofill one-pack: Common wood with low content of extractives and wood-based materials (also MDF) for residential environments with normal load. Variofill two-pack: Almost all wooden furniture in the interior. For priming of all common woods and wood-based materials. Ideally suited for the isolation of wood extractives and for the isolation of MDF in wet rooms. The product can also be used as adhesion promoter on many common plastics and metals in the interior.
Product data	
Product code	VF
Packaging size	25 kg 4kg
Viscosity at delivery DIN 4 mm (sec.)	140 ± 5
VOC Directive EC limit value for this product (cat. A/d): 130 g/l (2010)	The unhardened product contains max. 50 g/l VOC. The hardened product contains max. 82 g/l VOC.
Shelf life – Original container unopened	at least 1 year


Preparation of substrates		
	Raw wooden surfaces. Graduated sanding of wood Carefully remove the sanding dust Coarse-pore wood must be brushed out.	P120, P150, P180
	Plastic foil boards (e.g., HPL or melamine resin) must be thoroughly sanded. Priming foil boards must be clean and free from grease and silicone.	P320, P400
	Metals must first be degreased with Zweihorn® Universal Cleanser and carefully sanded. Plastics must be cleaned and slightly sanded with an abrasive sponge or a sanding pad. As adhesion promoter, the product may only be applied hardened as a two-pack product. In general, the applicator has to test the adhesion properties.	P400 P600
Processing		
	Stir thoroughly!	
	Mix and apply the product as described under "Hardener Thinner Additives".	
	On priming or plastic foil boards, the product may only be applied hardened as a two-pack product. As adhesion promoter, the product may only be applied hardened as a two-pack product. Due to many different substrates, we cannot assume warranty for sufficient adhesion in any case. In general, the applicator has to test the adhesion properties. When used as two-pack product, proper hardening (see Hardener Thinner Additives) must be ensured in order to ensure a sufficient insulating effect.	
Hardener - Thinner - Additives		
	Hardening optional	10 % PWH 3200 by weight 15 % PWH 3200 by volume
	Dilution	Variocryl® Optimizer VO or tap water
	Pot life 20°C, 65% rel. humidity	as two-pack product up to 4 hours

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Application		
		
Spray pressure (bar)	1.5-3.0	110-130
Nozzle size (mm)	2.0-2.5	0.33-0.38
Processing viscosity DIN 4mm (sec.)	100-140	120-140
Coverage per application (g/m <sup>2</sup> )	120-300	120-300
Coverage (m <sup>2</sup> /l)	3-6	3-6
Thinner to be added (%)		
Variofill one-pack:	0-55-10	-5-10
Variofill two-pack:		

Drying time @ 20°C	
Dust dry	at least 30 minutes
Ready for transport	at least 2 hours
Sandable	at least 6 hours

Aftertreatment
After sanding with P280-320 grit paper, the surface can be retreated with the same product at any time. When the desired filling result is obtained, further coating is possible with the waterborne Zweihorn® paint system Variocryl® Color VCC. As a two-pack product, the product can also be coated with the solvent-based Zweihorn® paint systems WNC or WNCH.

Test standards	
	General Appraisal Certificate for low flammability according to DIN 4102/B1 in compositions with Variocryl® Color and Variocryl® Varnish on B1-tested wooden particle boards and on hardly inflammable MDF, also veneered. All coats of lacquer must be applied with hardener.
	Hardly inflammable according to EN 13501 in compositions with Variocryl® Color and Variocryl® Varnish on MDF materials approved according to EN 13501. All coats of lacquer must be applied with hardener.
	Requirement for furniture surfaces in regards to their resistance to temperature changes

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