Product name: epoxy filling putty
so-called cold tin APP Epoxy Putty.
APP No: 010440.

A coarse-grained aluminium pigmented epoxy filler with a lead-tin alloy colour popularly known as cold tin. It offers very good adhesion to: steel, galvanised steel, aluminium, polyester laminates and old OEM coatings. It is very stable over time, easy to apply and process.

Packaging.	1.0 kg - putty, 0.5 kg - hardener.
Product and accessories.	010440 - APP Epoxy Putty - epoxy putty, 010441 - APP Harter Epoxy Putty - hardener.
Basic ingredients.	APP Epoxy Putty - epoxy resin and a mixture of fillers and additives, APP Harter Epoxy Putty - hardener in paste.
Colour.	Dark gray.
Application	The two-component cold-applied epoxy product is a replacement for tin and lead solder alloys for the restoration of metal surfaces such as steel or aluminium car bodies. Developed for filling and modelling repaired cavities on hard-to-reach, rebuilt surfaces or welded joints.
Advantages	• Lead-free substitute for solder alloys. • No open flame required. • There is no need to dismantle plastic parts, upholstery, fuel tank, etc. • It does not damage the existing cataphoretic coating, painted areas or closed profile protections. • Resistant to shrinkage and settling.
Substrate Suitable substrates.	Steel, galvanised sheet steel, aluminium, polyester laminates and old OEM coatings. In order to increase resistance to corrosion, areas sanded down to a clean sheet should be primed with APP Grund EP, a two-component epoxy primer. Note! Do not apply directly on: reactive and acid-hardening primers, one-component products and thermoplastic lacquers (T.P.A.).

APP Sp. z o.o. 62-300 Września ul. Przemysłowa 10, phone + 48 61 437 00 00.

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Substrate preparation

Steel:
- dry sand with P80-P150 abrasive paper, dust off and degrease.

Galvanised steel sheet, aluminium, non-ferrous metals:
- dry sand with abrasive fleece or P150-P180 abrasive paper, dust off and degrease,
- for increased adhesion, prime with APP Grund EP, a two-component epoxy primer.
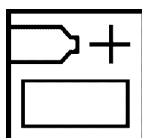
Existing finishes:
- sand down to bare metal or to a suitable surface with P80-P120 sand paper, then smooth out the transitions to the old coating with P150-P220 sand paper.

Before spreading the putty, clean the treated surface of dust and degrease it with APP W900, APP W911 or APP WB910 remover.

<u>Applications</u>
Mixing ratio.

Mixing ratio of **2:1 by** weight:
100 g	APP Epoxy Putty
50 g	APP Harter Epoxy Putty

Note!
Avoid overdosing the hardener.
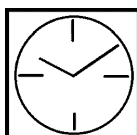Mix by kneading until a uniform colour is obtained.

Application.

Apply with a spatula in thin layers within the application time, i.e. within approx. 25-35 minutes at +20°C.
Recommended working temperature: +15°C to +25°C.
Do not apply the product at temperatures below +10°C and relative humidity above 80%.

Drying.

At +20°C, it is suitable for further processing after:
- 4-5 hours.

At +60°C, it is suitable for further processing after:
- 20–30 minutes.

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Sanding

Dry sand after complete curing:
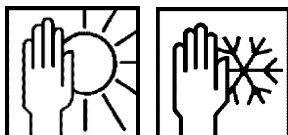- roughly with P120-P180 sand paper,
- finish with P220-P320 sand paper.

Coverage.

APP 1K S
APP SN05
APP AcrylFiller Multi Sanding
APP AcrylFiller 401
APP AcrylFiller 501
APP AcrylFiller Rapid
APP AcrylFiller Compact
APP Grund EP
APP Primer Filler
APP Haftgrund
APP 2K Haftgrund

Equipment cleaning.

Wash immediately after use with nitrocellulose solvent.

Storage

Store in closed original packaging at a temperature between +5°C and +30°C in a dry and well-ventilated room. Protect from freezing.

OHS regulations

For professional use only.
See text on product labels or in the product MSDS.
Comply with the health and safety regulations in force in the country concerned.

VOC

VOC limit g/l in the ready-to-use product.
    250 g/l for APP Epoxy Putty.
Maximum VOC content g/l in the ready-to-use product.
    65 g/l for APP Epoxy Putty.

The above information is in line with the current state of knowledge of our products and their possible applications.
This does not guarantee specific properties or suitability for use under specific conditions. The notes and warnings on the product labels and on the safety data sheet
should be adhered to. We do not bear any
responsibility if the final result of the work was influenced by factors beyond our control.

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