

TECHNICAL INFORMATION

Date of preparation:
4 November 2020



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**Product name: APP AcrylFiller 501 two-component acrylic filler.
APP No.: 020407-020412.**

A two-component, high-solid acrylic filling primer with excellent adhesion to steel, galvanised steel, polyester fillers and old paint coatings, and good adhesion to aluminium. Its very high solids content allows for the application of thick coats without the risk of the coating 'sagging'.

Packaging:	Acrylfiller – 1.0L, 4.0L; hardener – 0.20L, 0.8L.
Product and additives:	APP AcrylFiller 501 – acrylic primer, APP Harter AcrylFiller 501 standard - hardener with standard curing time, APP Harter AcrylFiller 501 fast - hardener with a short setting time.
Special additives:	APP Elastic, APP Anti Silicone.
Basic components:	APP AcrylFiller 501 – acrylic resin, APP Harter AcrylFiller 501 – isocyanate hardeners.
Colour:	Black, grey, white.
Coverage:	9 m ² /l (200 µm) Note! In practice, coverage depends on factors such as: the shape of the object, the roughness of the substrate, the application method and working conditions.
<u>Application</u>	APP AcrylFiller 501 is a primer with a low VOC content (VOC < 540 g/l) and enhanced covering properties, designed for priming using the traditional method with sanding. Note! The 'wet-on-wet' method is not recommended.
<u>Substrate</u>	
Suitable substrates:	Steel. Galvanised steel sheet and aluminium primed with single- or two-component reactive primers, e.g. APP Haftgrund, APP 2K Haftgrund. Sanded-down OEM factory coatings. Surfaces pre-treated with: <ul style="list-style-type: none">• polyester products, e.g. APP Ultra• epoxy primers, e.g. APP Grund EP• adhesion primers, e.g. APP Kunststoff Primer. Note! To increase corrosion resistance, apply APP Haftgrund or APP 2K Haftgrund to the steel sheet and sanded areas down to bare metal.

Substrate preparation:

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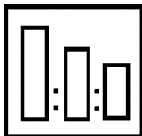


Thoroughly remove any areas of corrosion.
Sand existing finishes and polyester products dry with P240-P320 sandpaper.
Wet-sand surfaces coated with factory paints and primers using P360-P400 sandpaper.

Before spraying the filling primer, clean the surface to be treated of dust and degrease it with APP W900 or APP W911 cleaner.

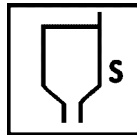
Application

Mixing ratios:



A) For large and medium-sized surfaces and temperatures from +15°C to +25°C:

5 parts	APP AcrylFiller 501
1 part	APP Harter AcrylFiller 501
0%	APP Acrylic Thinner
Spray	60 s 4 mm DIN/+20°C.
viscosity:	



B) For repairs to individual components:

5 parts by volume	APP AcrylFiller 501
1 part	APP Harter AcrylFiller 501
0%	APP Acrylic Thinner
Spray	60 s 4 mm DIN/+20°C.
viscosity:	

C) Mixing ratio by weight:

100	APP AcrylFiller 501
12	APP Harter AcrylFiller 501

Important!

Use only APP Harter AcrylFiller 501 hardeners.

Do not exceed the recommended amount of hardener.

If necessary, add up to 5% APP Acryl Verdunnung.

If necessary, add 2 to 5% APP Anti Silikon.

When tinting, add a maximum of 10% acrylic varnish.

If necessary (plastics), add according to the mixing table, before adding the hardener, add

APP Elastic.

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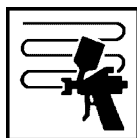
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The volume of the finished product for 0% additive APP Acryl Verdunnung	Mixing ratios by weight				
	APP AcrylFiller 501	APP Harter AcrylFiller 501	APP Acrylic Thinner		
	100	12.24	0%	5%	10%
[L]	[g]	[g]	[g]	[g]	[g]
0.1	135.3	16.55	0.00	3.63	7.26
0.2	270.5	33.10	0.00	7.26	14.52
0.3	405.8	49.65	0.00	10.89	21.78
0.4	541.0	66.20	0.00	14.52	29.03
0.5	676.3	82.75	0.00	18.15	36.29
0.6	811.5	99.30	0.00	21.78	43.55
0.7	946.8	115.9	0.00	25.40	50.81
0.8	1082	132.4	0.00	29.03	58.07
0.9	1217	149.0	0.00	32.66	65.33
1.0	1353	165.5	0.00	36.29	72.58

Application:



Apply using a spray gun fitted with a nozzle $\varnothing 1.8\text{--}\varnothing 2.0$ mm at an air pressure of 2.0 to 3.0 bar.

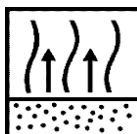


Number of coats: 2 x 1.

Coating thickness: 200- μ m.

Recommended operating conditions:

- minimum temperature: +10°C
- maximum relative humidity: 75%.



Evaporation time between coats at +20°C:

- 5 minutes.

Pot life of the ready-to-use mixture: 35-45 minutes.

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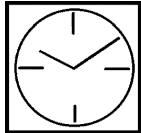


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Drying



At +20°C:
Dust-dry 25 minutes.
Handling time 50 minutes.
Full cure: 3–4 hours.



At +60°C:
Full cure: 30 minutes
IR drying: 12–15 minutes.

Sanding



Once fully cured, sand:

- wet sand with P600-P1000 sandpaper
- by machine using P360-P500 sandpaper.

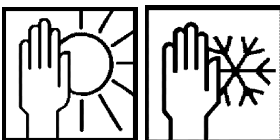
Compatibility:

Water-based and organic (conventional) base coats
e.g. APP Modular Specjal Base.
One- and two-component topcoats,
e.g. APP Modular 2K Acryl Line.

Equipment cleaning:

Nitrocellulose solvent.

Storage:



Store in sealed original containers in a dry, well-ventilated room.
Protect from freezing.

Health and safety regulations:



For professional use only.
See: text on product labels or in the

The user must comply with the health and safety regulations in force in the relevant country.

VOC:

Permissible VOC content (g/l) in the ready-to-use product.
540 g/l for APP AcrylFiller 501
Maximum VOC content (g/l) in the ready-to-use product.
< 540 g/l for APP AcrylFiller 501

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