

SPECIFICATIONS

Prepared on:
March 29, 2007



Updated on:
December 21, 2007

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Product name: APP 2K HS Acrylfiller 5:1

Acrylic, binary filling primer, HIGH SOLID class. The product has perfect adhesion to steel, zinc-coated steel, polyester fillers and old lacquer coats, and very good adhesion to aluminium. The very high content of solid substances allows the application of thick layers without the risk of coat “flowing”.

Container: Acrylfiller - 1.0 l, 4.0 l; hardener - 0.2 l, 0.8 l.

Product and additives: APP 2K HS Acrylfiller 5:1;
APP 2K Harter XF HN - standard setting time;
APP 2K Harter XF HS - short setting time.

Special components: APP 2K Elastic;
APP Anti-Silikon.

Basic components: APP 2K HS Acrylfiller 5:1 - acrylic resin;
APP 2K HS Harter XF HN/HS - isocyanate hardeners.

Colour: Black, grey, white.

Output: 9 m²/l (200 µm).

Caution!

In practice the output depends on certain factors including: object shape, roughness of the base, method of application and working conditions.

Usage:
particles

APP 2K HS Acrylfiller 5:1 is a primer with a low content of organic

VOC < 540 g/l and improved covering properties, intended for priming using the conventional method with polishing:

Caution!

It is not recommended to work in the “wet on wet” system.

Base

Proper base types:

Steel.

Zinc-coated steel sheet and aluminium, primed with unary or binary reacting primers, e.g. APP 1K Haftgrund, APP 2K Haftgrund.

Polished factory-made coats.

Surfaces precoated with:

- polyester products, e.g. PE Poly-Plast;
- epoxy primers, e.g. APP 2K Grund EP;
- unary fillers, e.g. APP 1K Filler.
- adhesive primers, e.g. APP 1K Kunststoff-Primer.

Caution!

In order to improve resistance to corrosion, first apply APP 1K Haftgrund or APP 2K Haftgrund onto the steel sheet and areas polished to bare metal.

The above information complies with current knowledge on our products and their possible applications.

This guarantees no specific properties or usability in particular conditions. Users should observe guidelines and warnings provided on product labels and specified in material safety data sheets. We hold no responsibility if conditions beyond our control affect the final result of work.

**Auto Plast Produkt Sp. z o.o. [Ltd.] 62-300 Września, ul. Przemysłowa 10, Poland
tel. + 48(prf)61 437 00 00**

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Base preparation:



Thoroughly remove all corrosion centres.
Existing finish and polyester products - even up dry using P240-P320 abrasive paper.



Surfaces covered with factory-made lacquer coats and primers - polish wet using P360-P400 abrasive paper.



Before spraying the filling primer, remove any dust from the treated surface and degrease it using W900 or WB900 remover.

Application

Mixing ratio(s):



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

5 volumes: APP 2K HS Acrylfiller

1 volume: APP 2K HS Harter XF HN

0%: APP 2K Acryl Verdunnung AVN

Spraying viscosity: 60 s 4mm DIN/+20°C

B) For repairs of single elements:

5 volumes: APP 2K HS Acrylfiller

1 volume: APP 2K HS Harter XF HS

0%: APP 2K Acryl Verdunnung AVS

Spraying viscosity: 60 s 4mm DIN/+20°C

C) Mixing ratio by weight:

100 APP 2K HS Acrylfiller

12 APP 2K HS Harter XF HN/HS



Caution!

Use APP 2K HS Harter XF HN/HS hardeners only.

Never exceed the recommended hardener dose.

If necessary, add up to 5% of the APP 2K Acryl Verdunnung.

If necessary, add from 2 to 5% of the APP Anti-Silikon.

In case of colouring, add up to 10% of acrylic lacquer.

If needed (plastics), add APP 2K Elastic elasticity improving agent before admixing the hardener. Proceed according to the mixing chart.

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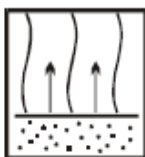
Applying:



Apply using a spray gun equipped with a $\phi 1.8\text{-}\phi 2.0$ mm nozzle at an air pressure ranging from 3.0 to 4.0 bar.



Number of layers: 2.
Coat thickness: 200 μm .
Recommended working conditions:
- minimum temperature: $+10^{\circ}\text{C}$;
- maximum relative humidity: 75%.



Evaporation time between successive layers at the temperature of $+20^{\circ}\text{C}$: 5 minutes.
Usability time for a ready-to-use mixture:
35-45 minutes.

Drying:



At a temperature of $+20^{\circ}\text{C}$:
Dust dryness: 25 minutes.
Handling possible: 50 minutes.
Full hardening: 3-4 hours.

At a temperature of $+60^{\circ}\text{C}$:
Full hardening: 30 minutes.

Polishing:



After complete hardening and cooling:
- wet polishing with P600-P1000 abrasive paper;
- dry machine polishing with P360-P500 abrasive paper.

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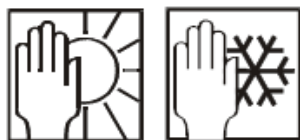
Coverage:

Water-thinned and conventional base paints.
Unary and binary top coat lacquers,
e.g.: APP Color MIX 2:1, APP 2K Acryl-Lack MS 2:1.

Equipment cleaning:

Nitrocellulose solvent.

Storage:



Store in original, closed containers in a dry and well-ventilated room.
Protect against freezing.

Industrial safety regulations:



For professional use only.
See: information on product labels and/or in Hazardous Material Safety
Data Sheet.
Users should observe all industrial safety regulations applicable in their
countries.

VOC:

Permissible VOC content [g/l] in a ready-to-use product.
540 g/l for APP 2K HS Acrylfiller 5:1
Maximum VOC content [g/l] in a ready-to-use product.
418 g/l for APP 2K HS Acrylfiller 5:1

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