# TECHNICAL INFORMATION



## Product name: APP AcrylFiller 401 two-component acrylic filler. APP No.: 020415-020420.

A two-component, high-solid acrylic filler primer with excellent adhesion to polyester products and old paint coatings. The formulation guarantees very good adhesion to steel and aluminium, as well as enhanced anti-corrosion properties. The high solids content allows for the application of thick coats without the risk of the coating 'sagging'.

| | |
|---|---|
| Packaging: | Acrylfiller – 1.0L, 4.0L; hardener – 0.25L, 1.0L. |
| Product and additives: | APP AcrylFiller 401 – acrylic primer,<br>APP Harter AcrylFiller 401 standard – hardener with standard setting time,<br>APP Harter AcrylFiller 401 fast - hardener with a short setting time,<br>APP Acryl Verdunnung normal – acrylic thinner with standard evaporation time. |
| Special additives: | APP Elastic,<br>APP Anti Silicone. |
| Basic components: | APP AcrylFiller 401 – acrylic resin,<br>APP Harter AcrylFiller 401 – isocyanate hardeners. |
| Colour: | Black, grey, white. |
| Coverage: | 5–6 m²/l<br>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. |
| Application | APP AcrylFiller 401 is a primer with a low VOC content (VOC < 540 g/l) and enhanced covering properties, intended for:<br>• priming using the traditional method with sanding,<br>• work in a 'wet-on-wet' system,<br>• hydrodynamic spraying. |
| Substrate<br>Suitable substrates: | Galvanised steel sheet and aluminium primed with one- or two-component reactive primers, e.g. APP Haftgrund,<br>APP 2K Haftgrund.<br>Steel and sanded OEM factory coatings.<br>Surfaces pre-treated with:<br>• with polyester products, e.g. APP Ultra,<br>• epoxy primers, e.g. APP Grund EP,<br>• adhesion primers, e.g. APP Kunststoff Primer.<br>Note! To increase corrosion resistance, apply APP Haftgrund or APP 2K Haftgrund to the steel sheet and sanded areas down to bare metal. |

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Substrate preparation:

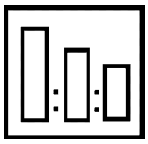
Thoroughly remove any areas of corrosion.
Sand existing finishes and polyester products dry with P240-P320 sandpaper.

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.

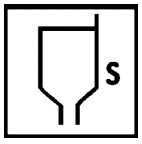
Application

Mixing ratios:



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

| | |
|---|---|
| 4 parts | APP AcrylFiller 401 |
| 1 part | APP Harter AcrylFiller 401 normal |
| 10% | APP Acrylic Thinner |
| Spray viscosity: | 25–30 s at 4 mm DIN/+20°C. |




B) For repairs to individual components:

| | |
|---|---|
| 4 parts by volume | APP AcrylFiller 401 |
| 1 part | APP Harter AcrylFiller 401 fast |
| 10% | APP Acrylic Thinner |
| Spray viscosity: | 25–30 s at 4 mm DIN/+20°C. |

C) Mixing ratio by weight:

| | |
|---|---|
| 100 | APP AcrylFiller 401 |
| 15 | APP Harter AcrylFiller 401 |
| 9 | APP Acrylic Thinner |

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| The volume of the finished product for 0% additive APP Acrylic Thinner | Mixing ratios by weight | | | | | | |
|---|---|---|---|---|---|---|---|
| | APP AcrylFiller 401 | APP Harter AcrylFiller 401 | APP Acrylic Thinner | | | | |
| | 100 | 14.67 | 0% | 5% | 10% | 15% | 25% |
| [ L ] | [ g ] | [ g ] | [ g ] | [ g ] | [ g ] | [ g ] | [ g ] |
| 0.1 | 132.8 | 19.48 | 0.00 | 3.48 | 6.97 | 10.45 | 17.42 |
| 0.2 | 265.6 | 38.96 | 0.00 | 6.97 | 13.94 | 20.90 | 34.84 |
| 0.3 | 398.4 | 58.44 | 0.00 | 10.45 | 20.90 | 31.36 | 52.26 |
| 0.4 | 531.2 | 77.92 | 0.00 | 13.94 | 27.87 | 41.81 | 69.68 |
| 0.5 | 664.0 | 97.40 | 0.00 | 17.42 | 34.84 | 52.26 | 87.10 |
| 0.6 | 796.8 | 116.9 | 0.00 | 20.90 | 41.81 | 62.71 | 104.5 |
| 0.7 | 929.6 | 136.4 | 0.00 | 24.39 | 48.78 | 73.16 | 121.9 |
| 0.8 | 1062 | 155.8 | 0.00 | 27.87 | 55.74 | 83.62 | 139.4 |
| 0.9 | 1195 | 175.3 | 0.00 | 31.36 | 62.71 | 94.07 | 156.8 |
| 1.0 | 1328 | 194.8 | 0.00 | 34.84 | 69.68 | 104.5 | 174.2 |

Mixing ratios:

D) For use with the ‘wet-on-wet’ method.
A spray viscosity of 15–20 seconds at 4 mm DIN/+20°C is achieved by adding 25% of the APP Acryl Verdunnung acrylic thinner. Application of the topcoat should not begin until the evaporation period has elapsed, i.e. after a minimum of 15 minutes at +20°C.

E) Hydrodynamic spraying.
For priming using the hydrodynamic spraying method, use a mixture with a viscosity of 30–35 s (without thinner) and a 0.33 mm (0.013”) nozzle at a pressure of 120–150 bar.

Note!
Use only APP Harter AcrylFiller 401 hardener.
Do not exceed the recommended hardener dosage. If necessary, add 2 to 5% APP Anti Silikon. When colouring, add up to 20% acrylic varnish (15 s 4 mm DIN/+20°C).
If necessary (plastics), add APP Elastic plasticiser in accordance with the mixing table before adding the hardener.

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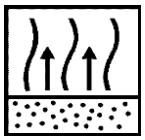
Application:

Apply using a spray gun fitted with a nozzle ø1.5–ø1.8 mm at an air pressure of 2.0 to 3.0 bar.

Number of coats: 2–3 x 1.
Coating thickness: 120–180µ m (with a spread rate > 300µ m).
Recommended operating conditions:

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

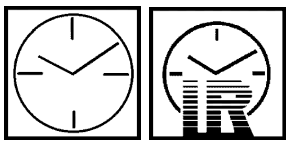


Flash-off time between coats at +20°C:

- 15 minutes.

Pot life of the ready-to-use mixture: 3 hours.

Drying

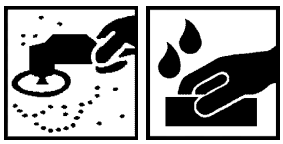


At +20°C:
Full cure: 3–5 hours.

At +60°C:
Full cure: 30–40 minutes

IR drying: 15–17 minutes.

Sanding



Once fully cured, sand:

- wet sand with P600-P1000 abrasive,
- dry machine sanding with P360-P500 abrasive.

Coverage:

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

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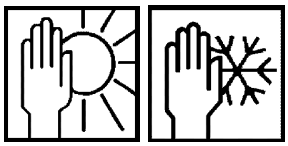
Equipment cleaning: Nitrocellulose solvent.

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 401
Maximum VOC content (g/l) in the ready-to-use product.
< 540 g/l for APP AcrylFiller 401