

# SPECIFICATIONS

Prepared on:  
February 26, 2007



Updated on:  
December 21, 2007

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## Product name: APP 2K HS Acrylfiller 4:1

Acrylic, binary filling primer, HIGH SOLID class. The product adheres perfectly to polyester products and old coats of lacquer. The formula guarantees very good adhesion to steel, zinc-coated steel and aluminium, and improved anticorrosive properties. 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 - 0.25 l, 1.0 l.

Product and additives: APP 2K HS Acrylfiller 4:1;  
APP 2K Harter F HN - standard setting time;  
APP 2K Harter F HS - short setting time;  
APP 2K Acryl Verdunnung AVN/ AVS;  
APP 2K Acryl Harter LHS100 - equivalent hardener.

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

Basic components: APP 2K HS Acrylfiller 4:1 - acrylic resin;  
APP 2K HS Harter F HN/HS - isocyanate hardeners.

Colour: Black, grey, white.

Output: 5-6 m<sup>2</sup>/l.  
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 4:1 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;  
- work in the “wet on wet” system;  
- hydrodynamic spraying.

### Base

Proper base types: 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 final result of work.

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### Base preparation:



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



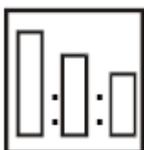
Surfaces covered with factory-made lacquer coats and primers - polish wet using P360-P400 abrasive paper.



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:

4 volumes: APP 2K HS Acrylfiller

1 volume: APP 2K HS Harter F HN

10: APP 2K Acryl Verdunnung AVN

Spraying viscosity: 25-30 s 4mm DIN/+20°C

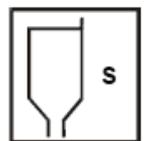
B) For repairs of single elements:

4 volumes: APP 2K HS Acrylfiller

1 volume: APP 2K HS Harter F HS

10: APP 2K Acryl Verdunnung AVS

Spraying viscosity: 25-30 s 4mm DIN/+20°C



C) For work using the “wet on wet” method:

Add 20% of the APP 2K Acryl Verdunnung thinner for acrylic products to obtain the mixture spraying viscosity of 15-20 s 4mm DIN/20°C. Do not start the finishing paint application before the product

has

evaporated, that is after a minimum of 15 minutes at a temperature of +20°C.

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### Mixing ratios:

#### D) Hydrodynamic spraying:

When applying the prime coat using the hydrodynamic spraying method, use a mixture with a viscosity of 30-35 s (without thinner) and a 0.33 mm nozzle with a pressure ranging from 120 to 150 bar.

#### Caution!

Use APP 2K HS Harter F HN/HS hardener only.

Never exceed the recommended hardener dose.

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

In case of colouring, add up to 20% of acrylic lacquer (15 s 4mm DIN/+20°C).

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

### Applying:



Apply using a spray gun equipped with a  $\phi 1.5$ - $\phi 1.8$  mm nozzle at an air pressure ranging from 3.0 to 5.0 bar.

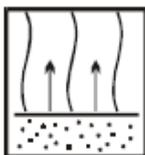


Number of layers: 2-3.

Coat thickness: 120-180  $\mu\text{m}$  (up to 300  $\mu\text{m}$  without thinner).

Recommended working conditions:

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



Evaporation time between successive layers at a temperature of +20°C: 15 minutes.

Usability time for a ready-to-use mixture:

3 hours.

### Drying:



At a temperature of +20°C:

Full hardening: 3-5 hours.

At a temperature of +60°C:

Full hardening: 30-40 minutes.

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### Polishing:



After complete hardening:

- wet polish with P600-P1000 abrasive paper;
- dry machine polish with P360-P400 abrasive paper.

### Coverage:

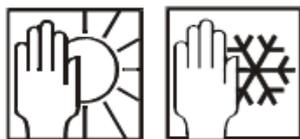
Water-thinned and conventional base paints.

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 4:1

Maximum VOC content [g/l] in a ready-to-use product.

506 g/l for APP 2K HS Acrylfiller 4:1

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