

TECHNICAL INFORMATION

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Product Name: APP 2K HS Rapid Acrylfiller 4:1. APP No.: 020425-020430.

Two-component HIGH SOLID Class fast filler features with perfect adhesion to Polyester surface filler, prime coats and fillers, as well as old top coats. Additionally easy sanding ensures maximum adhesion of top coat, gloss and stability.

- Package: APP 2K HS Rapid Acrylfiller – 1.0L and 4.0L;
APP 2K HS Rapid Härter XRFH – 0.25L and 1.0L.
- Product and additives: APP 2K HS Rapid Acrylfiller 4:1
APP 2K HS Rapid Härter XRFH standard
APP 2K HS Rapid Härter XRFH quick
APP 2K Acryl Verdunnung AVN.
- Special additives: APP 2K Elastic
APP Anti-Silikon.
- Basic components: APP 2K HS Rapid Acrylfiller 4:1- Acrylic resin
APP 2K HS Rapid Härter XRFH- Isocyanate hardeners.
- Colour: White, grey and black.
- Coverage: 9 m²/L (200 µm) - 18 m²/L (100 µm)
Caution! In practice coverage depends on different factors including: shape, substrate roughness, application method and operating conditions.
- Application APP 2K HS Rapid Acrylfiller 4:1 is basecoat that features with low content of volatile organic compounds VOC < 435 g/L and improved hiding power and is purposed for basecoat made traditionally by sanding. Caution!
“Wet on wet” method is not recommended.
- Substrate: Factory made coat following sanding.
Surfaces initially covered with:
- Polyester based products e.g.: APP Ultra
 - Epoxy basecoats e.g. : APP 2K Grund EP
 - Priming coats e.g.: APP 1K Haftgrund or APP 2K Haftgrund.
- Caution!
To improve adhesion to substrate and anticorrosion protection firstly apply APP 1K Haftgrund, APP 2K Haftgrund or APP 2K Grund EP in case of sheet metal, galvanized steel and sanded surfaces down to the bare metal. Apply APP 2K Grund EP primer to prevent any old coat related defects of top coat.
- Substrate preparation: Top coats and Polyester based products shall be smoothed using P240-P320 sandpaper.

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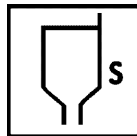
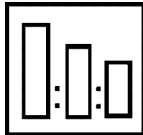
Surfaces covered with factory applied paints and basecoats shall be treated on wet with P360-P400 sandpaper.

Before spraying, firstly clean the surface to remove any dust and degrease with W900 or W911.



Use

Mixing ratio:



A) When applied as filler:

4 by volume	APP 2K HS Rapid Acrylfiller
1 by volume	APP 2K HS Rapid Härter XRFH
0-10%	APP 2K Acryl Verdunnung AVN
Spraying	45-50s 4mm F /+20°C (+0%).
viscosity:	
By weight:	
100	APP 2K HS Rapid Acrylfiller
15	APP 2K HS Rapid Härter XRFH
0-7	APP 2K Acryl Verdunnung AVN

B) When applied as priming coat:

4 by volume	APP 2K HS Rapid Acrylfiller
1 by volume	APP 2K HS Rapid Härter XRFH
15-25%	APP 2K Acryl Verdunnung AVN
Spraying	19s 4mm F /+20°C (+25%).
viscosity:	
Mixing ratio by weight:	
100	APP 2K HS Rapid Acrylfiller
15	APP 2K HS Rapid Härter XRFH
10-14	APP 2K Acryl Verdunnung AVN

Caution!

Use APP 2K HS Rapid Härter XRFH hardener only.

Follow strictly specified hardener volume.

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

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APP 2K HS Rapid Acrylfiller 4:1		APP 2K HS Rapid Härter XRFH		APP 2K Acryl Verdunnung		
Mixing ratio		4 : 1		+10%	+15%	+25%
By volume		By weight				
L	[g]	[g]	[g]	[g]	[g]	
0.1	160,0	24.3	10.8	16.3	27.1	
0.2	320,0	48.6	21.7	32.5	54.2	
0.3	480,0	72.9	32.5	48.8	81.3	
0.4	640,0	97.2	43.4	65.0	108.4	
0.5	800,0	121.5	54.2	81.3	135.5	
0.6	960,0	145.8	65.0	97.5	162.6	
0.7	1120	170.1	75.9	113.8	189.7	
0.8	1280	194.4	86.7	130.0	216.8	
0.9	1440	218.7	97.5	146.3	243.8	
1.0	1600	243.0	108.4	162.6	270.9	

Application:



Apply with a spray gun fitted with $\varnothing 1.6$ - $\varnothing 1.8$ mm nozzle at air pressure of 3.0 to 4.0bar.



Coat qty: 2.

Coat thickness:.

+0% APP Verdunnung: 160-200 μm

+25% APP Verdunnung: 60-100 μm

Evaporation time between coats at temperature +20°C:

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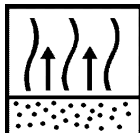
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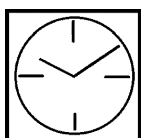
5 minutes.

Workability time: 15-35 minutes.

Recommended ambient conditions:

- Minimum temperature: +10°C
- Maximum relative humidity: 75%.

Drying



At temperature +20°C:

Dust dry: 15-20min.
Total hardening: 1.5-2h.

At temperature +60°C:

Total hardening: 25-30min.

IR drying: 12-15min.

Grinding



Following total hardening treatment is recommended:

- On wet with P600-P800 sand paper
- Mechanically on dry with P360-P600 sandpaper.

Paint finish:

Water borne and traditional basecoats

e.g.: APP Modular Special Base.

One and two-component top coats,

e.g.: APP Modular 2K Acryl Line.

Tool cleaning:

Nitrocellulose thinner.

Storage:



Store in closed, original containers, in dry and well ventilated spaces.

Protect against freezing.

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Occupational safety:



Product for professional use only.
See: labels on containers and MSDS.
User shall follow locally and regionally applicable industrial safety regulations.

VOC:

Permitted VOC in g/L of product ready to use.
540g/L for APP 2K HS Rapid Acrylfiller 4:1
Maximum VOC in g/L of product ready to use.
435g/L for APP 2K HS Rapid Acrylfiller 4:1

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