

TECHNICAL INFORMATION

Date of preparation:
4 November 2020



Date updated:
4 November 2020
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Product name: APP AcrylFiller Compact two-component acrylic filler.
APP No.: 020444, 020445.

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

Packaging: APP AcrylFiller Compact - 0.83L,
APP Harter AcrylFiller Compact - 0.17L.

Product and accessories: APP AcrylFiller Compact - acrylic primer,
APP Harter AcrylFiller Compact - hardener,
APP Acryl Verdunnung – acrylic thinner.

Special additives: APP Elastic
APP Anti Silicone.

Basic components: APP AcrylFiller Compact – acrylic resin,
APP Harter AcrylFiller Compact – isocyanate hardener.

Colour: grey and dark grey.

Coverage: 9 m²/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.

Application APP AcrylFiller Compact 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.

Substrate

Suitable substrates: Galvanised steel sheet and aluminium primed with one- or two-component reactive primers, e.g. APP Haftgrund,
APP 2K Haftgrund.

Steel and sanded OEM factory coatings.

Surfaces pre-treated with:

- with 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.

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Substrate preparation:



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

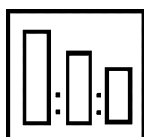
Wet-sand surfaces coated with factory paints and primers using P360-P400 sandpaper.



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 ratio:



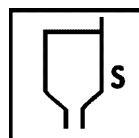
A) For use as a filling primer:

5 parts APP AcrylFiller Compact
1 part APP Harter AcrylFiller Compact
10% APP Acrylic Thinner

Spray 70 s 4 mm F /+20°C.
viscosity:

Mixing ratio by weight:

100 APP AcrylFiller Compact
12 APP Harter AcrylFiller Compact
7 APP Acrylic Thinner



B) For use as a primer:

5 parts APP AcrylFiller Compact
1 part APP Hard Acrylic Filler Compact
20% APP Acrylic Thinner

Spray 40 s 4 mm F /+20°C.
viscosity:

Mixing ratio by weight:

100 APP AcrylFiller Compact
12 APP Harter AcrylFiller Compact
13 APP Acrylic Thinner

Important!

Use only the APP Harter AcrylFiller Compact hardener.

Do not exceed the recommended amount of hardener.

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

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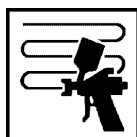
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Volume of the finished product for 0% additive APP Acrylic Thinner	Mixing ratios by weight					
	APP AcrylFiller Compact	APP Harter AcrylFiller Compact	APP Acrylic Thinner			
	100	12.81	0%	10%	15%	20%
[L]	[g]	[g]	[g]	[g]	[g]	[g]
0.1	129.2	16.55	0.00	7.26	10.89	14.52
0.2	258.3	33.10	0.00	14.52	21.78	29.03
0.3	387.5	49.65	0.00	21.78	32.66	43.55
0.4	516.7	66.20	0.00	29.03	43.55	58.07
0.5	645.8	82.75	0.00	36.29	54.44	72.58
0.6	775.0	99.30	0.00	43.55	65.33	87.10
0.7	904.2	115.9	0.00	50.81	76.21	101.6
0.8	1033	132.4	0.00	58.07	87.10	116.1
0.9	1163	149.0	0.00	65.33	97.99	130.7
1.0	1292	165.5	0.00	72.58	108.9	145.2

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.

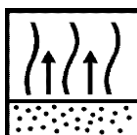


Number of coats: 2 x 1.

Coating thickness: max 200 μ m.

Recommended working conditions:

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



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

- 5 minutes.

Pot life of the ready-to-use mixture: 25–30 minutes.

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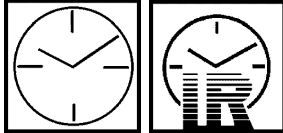


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Drying



At +20°C:
Dust-dry 30 minutes.
Handling time 60 minutes.
Full cure: 4 hours.
At +60°C:
Full cure: 25–30 minutes
IR drying: 15–18 minutes.

Sanding



Once fully cured, sand:

- wet sand with P600-P800 sandpaper
- by machine using P360-P500 sandpaper.

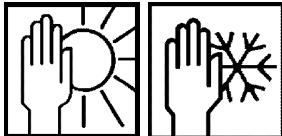
Compatibility:

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 Compact 5:1
Maximum VOC content (g/l) in the ready-to-use product.
502 g/l for APP Acrylfiller Compact 5:1

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