

## TECHNICAL INFORMATION



**Date of Preparation:**  
**02.04.2010**

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### **Product Name: APP 2K HS Compact Acrylfiller 5:1**

Two component HIGH SOLID class acrylic filler that features with exceptional adhesion do steel, polyester, mastic and old top coats, as well as good adhesion to zinc plates steel and aluminium. Very big content of solid substances enables application of thick coats and prevents coat running.

Package:	Compact Acrylfiller -0.83l; hardener -1.7l
Product and additives:	APP 2K HS Compact Acrylfiller 5:1 APP 2K HS Compact Harter XFCH APP 2K HS Acryl Verdunnung AVN.AVS
Special additives:	APP 2K Elastic APP Anti-Silikon
Basic ingredients:	APP 2K HS Compact Acrylfiller 5:1-acrylic resin APP 2K HS Compact Harter XFCH- isocyanate hardener
Colour:	Grey
Yield:	9m <sup>2</sup> /l (200µm) Important! In practice yield depends on the following factors: object shape, substrate roughness, application method and working conditions.
<u>Application:</u>	APP 2K HS Compact Acrylfiller 5:1 is a base primer that features with low content of organic particles LZO/VOC <540g/l and enhanced covering that is purposed for standard application with use of classic method along with grinding. Important! It is not recommended for "wet on wet" technique.
<u>Substrate:</u>	
Proper substrates:	Steel Zinc plated steel sheets and aluminium primed with single or two-component primers e.g. APP 1K Haftgrund, APP 2K Haftgrund. Grinded factory made coats. Surfaces pre- treated with: <ul style="list-style-type: none"><li>- Polyester products e.g. PE Poly-Plast</li><li>- Single-component filler e.g. APP 1K Filler</li><li>- Primers e.g. APP 1K Kunststoff-Primer.</li></ul> Important! To increase anti-corrosion resistance pre-treat steel sheets and grinded surfaces with APP 1K Haftgrund or APP 2K Haftgrund.

The above information is in accordance with currently possessed knowledge on our products and application hereof. The information does not guarantee any specific properties and fitness for particular use. Adhere strictly

to warning and remarks provided on labels of products and Material Safety Data Sheets. We are not responsible for any final results of the work resulted from factors beyond our control.

**Auto Plast Product S.A. 62-300 Września ul. Przemysłowa 10 Phone: +48(prefix) 61 437 00 00**

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**Substrate  
preparation:**

Remove any corrosion  
Grind on dry finishing surfaces and polyester products with  
P240-P320 sandpaper.

Surfaces covered with top coats and prime coats grind on  
wet with P360-P400 sandpaper.

Prior to spraying with a prime coat clean the treated surface and  
remove any dust and degrease with W900 or WB900 cleaner.

#### Application

**Mixing Ratio:**

A) For use as a filler:

5 parts	APP 2K HS Compact Acrylfiller 5:1
1 part	APP 2K HS Compact Harter XFCH
10%	APP 2K Acryl Verdunnung AVN.
Spraying viscosity	70 s 4mmF/+20°C
Mix proportions by weight:	
100	APP 2K HS Compact Acrylfiller 5:1
12.5	APP 2K HS Compact Harter XFCH
6	APP 2K Acryl Verdunnung AVN.

B) For application as a primer:

5 parts	APP 2K HS Compact Acrylfiller
1 part	APP 2K HS Compact Harter XFCH
20%	APP 2K Acryl Verdunnung AVN.
Spraying viscosity	40 s 4mmF/+20°C
Mix proportions by weight:	
100	APP 2K HS Compact Acrylfiller
12.5	APP 2K HS Compact Harter XFCH
6	APP 2K Acryl Verdunnung AVN.

**Important!**

Apply APP 2K HS Compact Harter XFCH hardener only.

Do not exceed recommended hardener doses.

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

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#### Application

Apply with a spraying gun equipped with a nozzle  
Ø1.8 -Ø2.0 mm at air pressure from 3.0 to 4.0 bar.

Number of layers: 2

Layer thickness: 200 µm

Recommended work conditions:

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

Evaporation time between layers at +20°C temperature: 5 minutes

Pot life: 25-30 minutes

#### Drying

At +20°C temperature:

Dustfree dry 30 minutes

Possible manipulation 60 minutes

Total hardening 4 hours

At temperature +60°C:

Total hardening 25-30 minutes

IR drying: 15018 minutes

#### Grinding

After total hardening grind:

- on wet with P600-P800 sandpaper
- on dry mechanical treatment with P360-P500 sandpaper

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- Recoatibility: Water-thinned and conventional paints.  
Single and two-component top coats, e.g.  
APP Color MIX 2:1, APP 2K Acryl –Lack MS 2:1.
- Cleaning of the equipment: Thinner
- Storage: Store in closed original packages in dry and well ventilated spaces.  
Protect against freezing.
- Health and Safety: Product for professional use only.  
Before use consult: labels on the product's packages or Material Safety Data Sheet.  
User shall adhere to locally applicable industrial safety regulations.
- LVO/VOC: Permissible LZO g/l value in ready to use product.  
540 g/l for APP 2K HS Compact Acrylfiller 5:1  
Maximum LZO g/l content in ready to use product.  
502 g/l for APP 2K HS Compact Acrylfiller 5:1

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