

TECHNICAL INFORMATION

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08/06/2022



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Product name: APP AcrylFiller Multi Wet on Wet two-component acrylic primer. APP No.: 020460-020463.

HS grade two-component acrylic primer with very good spreadability, high solids content, good insulation and short drying time. It is a dedicated product for wet-on-wet applications. Available in two colours: grey and dark grey.

Packaging.	AcrylFiller – 1.0 L, 4.0 L; hardener – 0.20 L, 0.8 L.
Product and additives.	APP AcrylFiller Multi Wet on Wet – acrylic primer. APP Harter AcrylFiller Multi regular – hardener with a regular curing time. APP Harter AcrylFiller Multi quick – hardener with quick curing time. APP Acryl Verdunnung – thinner for acrylic products.
Special additives.	APP Elastic, APP Anti Silicone.
Basic ingredients.	APP AcrylFiller Multi Wet on Wet – acrylic resin, mineral fillers, pigments and solvents. APP Harter AcrylFiller Multi – isocyanate hardeners.
Colour.	Grey, dark grey.
Specific weight.	1.570 ± 0.050 kg/L.

Application APP AcrylFiller Multi Wet on Wet is a dedicated primer for wet-on-wet applications on non-absorbent surfaces. It has a low VOC content < 540 g/L and good covering properties. It is designed for topcoating without sanding.

Substrate
Suitable substrates.

Steel.
Galvanised steel and aluminium sheets primed with one- or two-component reactive primers, e.g. APP Haftgrund, APP 2K Haftgrund. Re-sanded OEM factory coatings and re-sanded KTL coatings (cataphoresis). Surfaces pre-treated with:

- Epoxy primers, e.g. APP Grund EP,
- Adhesion primers, e.g. APP Kunststoff Primer.

Note! To increase anticorrosive resistance, pre-apply APP Haftgrund or APP 2K Haftgrund to steel sheet and areas sanded to clean metal.

The above information is in line with the current state of knowledge of our products and their possible applications. This does not guarantee specific properties or suitability for use under specific conditions. Follow the notes and warnings on the product labels and on the safety data sheet. We assume no liability if the final result of the work was influenced by factors beyond our control.

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Substrate preparation.

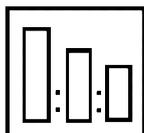


Thoroughly remove corrosion spots.
Dry sand surfaces coated with factory paints and primers using P320-P360 sanding paper.

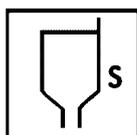


Before spraying the primer, clean the treated surface of dust and degrease it with APP W900 or APP W911 remover.

Application Mixing ratios.



A) Mixing ratios by volume:
5 volumes APP AcrylFiller Multi Wet on Wet
1 volume APP Harter AcrylFiller Multi
20-30% APP Acryl Verdunnung
Spray
viscosity: 20-17 s 4 mm DIN/+20°C.



B) Mixing ratios by weight:
100 APP AcrylFiller Multi Wet on Wet
12.5 APP Harter AcrylFiller Multi

Note!

Use only APP Harter AcrylFiller Multi hardeners. Do not exceed the recommended hardener amount.

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

If necessary (plastics), add the APP Elastic elasticity improving agent according to the mixing table before adding the hardener.

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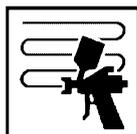
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two-component acrylic primer.
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Volume of finished product for 0% thinner addition	Mixing ratios by weight				
	APP AcrylFiller Multi Wet on Wet	APP Harter AcrylFiller Multi	APP Acryl Verdunnung		
	100	12	20%	25%	30%
[L]	[g]	[g]	[g]	[g]	[g]
0.1	130.0	16.4	17.42	21.78	26.1
0.2	260	32.8	34.84	43.55	52.3
0.3	390	49	52.26	65.33	78.4
0.4	520	66	69.68	87.10	104.5
0.5	650	82	87.10	108.88	130.7
0.6	780	98	104.52	130.65	156.8
0.7	910	115	121.94	152.43	182.9
0.8	1040	131	139.36	174.20	209.0
0.9	1170	148	156.78	195.98	235.2
1.0	1300	164	174.20	217.75	261.3

Application.



Apply with a spray gun equipped with a $\varnothing 1.2$ - $\varnothing 1.4$ mm nozzle at an air pressure of 2.0 to 3.0 bar.

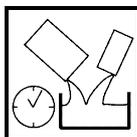


Number of layers: 1 x 1 – one continuous, closed layer.

Coating thickness: 20-30 μm .

Recommended working conditions:

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



Working time of the ready-to-use mixture:

- 45 min / + 20°C.

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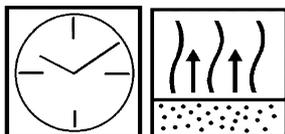
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Drying.



At +20°C:
Evaporation time to cover: 20-30 minutes.

Sanding.



Inclusions may be removed:

- by hand with dry sandpaper on a P600-P800 sponge.

Coverability.

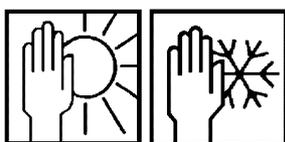
Cover without sanding with topcoat:

- 20-30 minutes after applying the primer,
- up to a maximum of 2 hours after primer application.

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

Equipment cleaning. Nitrocellulose solvent.

Storage



Store in closed original packaging in a dry and well-ventilated room.
Protect from freezing.

OHS regulations



For professional use only.
See text on product labels or SDS.
The user must comply with the OHS regulations in force in the country concerned.

VOC

Permissible VOC g/L limit in the ready-to-use product.
540 g/L for APP AcrylFiller Multi Wet on Wet
Maximum VOC content in g/L in the ready-to-use product.
< 540 g/L for APP AcrylFiller Multi Wet on Wet

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