

TECHNICAL INFORMATION

Date drafted:
08/06/2022



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Product name: APP AcrylFiller Multi Sanding two-component filler primer. APP No.: 020470-020475.

HS grade two-component acrylic filler with high-solids content, low absorption, short drying time. It has excellent adhesion to steel, polyester putties and old coatings of paint. It is intended to work in the classic method with sanding. Available in three colours: grey, black and white.

Packaging. AcrylFiller – 1.0 L, 4.0 L; hardener – 0.20 L, 0.8 L.

Product and additives. APP AcrylFiller Multi Sanding – 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 Sanding – acrylic resin, mineral fillers, pigments and solvents.
APP Harter AcrylFiller Multi – isocyanate hardeners.

Colour. Black, grey, white.

Specific weight. 1.610 ± 0.050 kg/L.

Application APP AcrylFiller Multi Sanding is a fast-drying primer with low content of organic particles VOC < 540 g/L and increased covering properties, intended for priming using the classic method with 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.
Pre-sanded OEM factory coatings. Surfaces pre-treated with:

- polyester products, e.g. APP Ultra,
- 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.

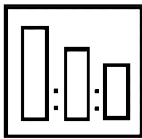
Dry level existing finishes and polyester products with P180-P240 sandpaper.

Wet sand surfaces coated with factory paints and primers using P220-P280 sanding paper.

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

Application

Mixing ratios.

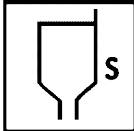


A) Mixing ratios by volume:

5 volumes	APP AcrylFiller Multi Sanding
1 volume	APP Harter AcrylFiller Multi
0-20%	APP Acryl Verdunnung
Spray	52-20 s 4 mm DIN/+20°C.
viscosity:	

B) Mixing ratios by weight:

100	APP AcrylFiller Multi Sanding
12	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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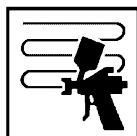
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Volume of finished product for 0% thinner addition	Mixing ratios by weight				
	APP AcrylFiller Multi Sanding	APP Harter AcrylFiller Multi	APP Acryl Verdunnung		
	100	12	5%	10%	15%
[L]	[g]	[g]	[g]	[g]	[g]
0.1	134.2	16.4	4.36	8.71	13.1
0.2	268	32.8	8.71	17.4	26.1
0.3	403	49	13.1	26.1	39.2
0.4	537	66	17.4	34.8	52.3
0.5	671	82	21.8	43.6	65.3
0.6	805	98	26.1	52.3	78.4
0.7	939	115	30.5	61.0	91.5
0.8	1073	131	34.8	69.7	105
0.9	1208	148	39.2	78.4	118
1.0	1342	164	43.6	87.1	131

Application.

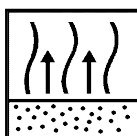


Apply with a spray gun equipped with a $\varnothing 1.5\text{-}\varnothing 1.8$ mm nozzle at an air pressure of 2.0 to 3.0 bar.



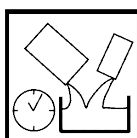
Number of layers: 2-3 x 1.
Coating thickness: 160-240 μm .
Recommended working conditions:

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



Evaporation time between coats at +20°C:

- 7-10 minutes.



Working time of the ready-to-use mixture:

- > 30 min / + 20°C.

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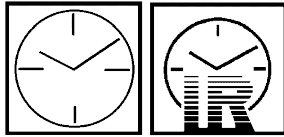


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Drying.



At +20°C:
Full curing: 3 hours.

At +60°C:
Full curing: 20-30 minutes.

IR drying: 9-12 minutes.

Sanding.



When fully cured, sand:

- dry, with machine using P320-P500 sandpaper,
- wet with P600-P1000 sandpaper.

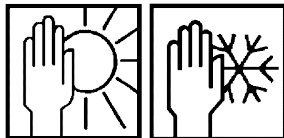
Coverability.

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

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