

TECHNICAL INFORMATION

Preparation Date:
19.03.2013.



Updating Date:
19.03.2013.

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Product Name: APP 1K Primer Filler APP No.: 020710.

Single component quick drying primer that ensures anti-corrosion. It features with very good adhesion to iron, steel, zinc plated steel and aluminium and some types of plastic. May be covered with any type of 1K and 2K traditional top coats, as well as water-thinnable coats.

Packaging: APP 1K Primer Filler -1.0l

Product and additives: APP 1K Primer Filler
APP 2K Acryl Verdunnung AVN.

Colour: Dark grey.

Yield: 5-7m²/l
Caution! In practice yield depends on many condition including shape, base roughness, application method and working conditions.

Purpose
Purposed for work with "wet on wet" system, classic priming along with grinding and SMART micro repairs. Also may be used as the primer improving adhesion or filler.

Substrate
Appropriate substrate:

Iron, steel, zinc coated steel and aluminium,
Grinding of factory made coats and Polyester filling.
Caution!
Do not apply on thermoplastic top coats (T.P.A).

Substrate preparation:



Carefully clean and remove any corrosion sources and perform sanding on dry with P320-P500 sandpaper.

Level any irregular surfaces of bonding of old top coat and Polyester filling.

Perform sanding on wet with P600-P800 sandpaper in case of base coats and old top coats.

The above information is based on currently available data and knowledge on the product and its use. The information does not purport to be a description of product in terms of its quality, suitability for use in some conditions, nor does it guarantee any particular features. User shall follow instructions provided on labels and MSDS. Producer is not responsible for consequences and work effects that were influenced with factors beyond his control.

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Before spraying clean the surface to remove dust and degrease with W900, WC900 PLUS or WB900 stripper.

Use

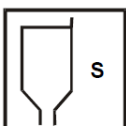
Mixing ratio:



Mixing ration by volume:

2 vol. APP 1K Primer Filler

1 vol. APP 2K Acryl Verdunnung AVN



Mixing ratio by weight:

100.0. APP 1K Primer Filler

36.3. APP 2K Acryl Verdunnung AVN

Spraying viscosity: 18-22s 4mm F/+20°C

Application:



Apply with a spray gun fitted with nozzle Ø1.1-1.5mm at air pressure from 2.0 to 3.5bar.

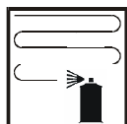


Quantity of coats: 1-3 x 1.

Dry coat thickness: 10-50µm.

Recommended conditions:

- Min. temperature :+10°C
- Max. relative humidity:80%

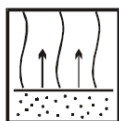


Quantity of coats: 2-3 x 1,

Dry coat thickness:50-60µm

Recommended conditions:

- Min. temperature :+10°C
- Max. relative humidity:80%



Inter layer evaporation time at temperature: +20°C:
10 min.

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Drying



At temperature +20°C:

Dusty dry: 30-45 min.

Touch dry: 30-45 min.

Ready to be covered: 40-50 min.

Coverability:

After 40-50 min./+20°C apply water-thinnable and traditional top coats.

Caution!

Do not apply Polyester top coats on APP 1K Primer Filler.

Grinding:



After total hardening perform:

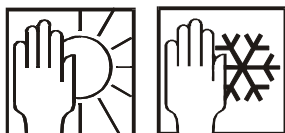
- on wet grinding with P600-P800 sandpaper

- machine grinding on dry with P360-P500 sandpaper.

Equipment cleaning:

Nitrocellulose thinner.

Storage:



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

Protect against freezing.

Occupational safety:



Product for professional use only.

See: labels on containers and MSDS

User must follow locally and regionally applicable industrial safety regulations.

VOC:

Permitted g/l VOC content in product ready to use.

780g/l for APP Primer Filler Spray

Maximum g/l VOC content in product ready to use.

620g/l for APP Primer Filler Spray

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