

# TECHNICAL INFORMATION

Preparation Date:  
19.02.2013.



Updating Date: 19.02.2013.

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## Product Name: APP MODULAR 2K Acryl Line 2:1.

Low emission, two-component Acrylic-Polyurethane top coat of short drying time and high quality. It is purposed for car body works in case of utility vehicles, buses, tanks, any exposed and highly loaded parts of machines and structural components. It features with high mechanic strength as well as resistance to impact and scratches including chemicals like acids and bases at small concentration or fats and naphtha.

Product and additives: APP MODULAR 2K Acryl Line 2:1  
APP HS Spezial S Harter  
APP 2K Acryl Harter  
APP 2K Verdunnung.

Special additives: APP MODULAR 2K Acryl Line 50-95 – Dulling paste  
APP 2K Elastic  
APP Anti-Silikon.

Basic components: APP MODULAR 2K Acryl Line 2:1 – Polyurethane-Acrylic resin  
APP HS Spezial S Harter I APP 2K Acryl Harter – Isocyanate hardeners.

Colour: Solid high gloss colours made according to recipe.

Specific gravity: 0.97-1.42g/cm<sup>3</sup>

Yield: ~9 m<sup>2</sup>/l for ca. 50µm of dry coat.  
Caution!  
In practice yield depends on many factors including: object shape, base roughness, application method and working conditions.

Application: Purposed for car body works in case of utility vehicles, buses, tanks, any exposed and highly loaded parts of machines and structural components.

Substrate: Factory made coats after grinding.  
Surfaces initially coated with:

- Acryl undercoats e.g. APP 2K HS Acrylfiller 4:1, APP 2K HS Acrylfiller 5:1, APP 2K HS Compact Acrylfiller 5:1
- Epoxy primers e.g. APP 2K Grund EP
- Single component fillers e.g. APP 1K Filler

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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- Single component water based filler APP 1K Aqua Primer
- Filling and insulating primer APP Smart Primer
- Adhesion improving primers e.g. APP 1K Kunststoff-Primer.

### Substrate preparation:



Prepare the surface by grinding with P320-P400 sandpaper.



Prepare the surface by grinding manually with water-proof P600-P800 sandpaper.

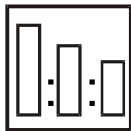


Before spraying with APP Modular Special Base clean the surface and remove any dust, and degrease with W900 and WB900 remover as well as APP Premium industrial wipers.

Remove dust finally with dust catching cloths APP SAS or APP SAS Aqua.

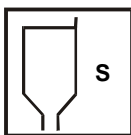
### Use

#### Mixing ratio:



#### Mixing ratio by volume:

2 parts	APP MODULAR 2K Acryl Line
1 part	APP HS Spezial S Harter lub
	APP 2K Acryl Harter
10-20%	APP 2K Verdunnung



Spraying viscosity at +20°C: 21-24 s F/4.

#### Caution!

Use APP HS Spezial S Harter or APP 2K Acryl Harter hardeners purposed for Acryl top coat only.

Always add hardened according to a recommended dose.

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

If necessary (for other gloss effect) before adding hardener add dulling paste 50-95.

If necessary (plastic) according to recommendations in the table, add APP 2K Elastic before adding the hardener.

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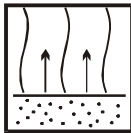
Application method:



Apply with a spray gun fitted with  $\varnothing 1.3-1.6$ mm nozzle at air pressure of 2.0 to 3.5bar.

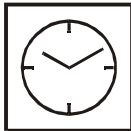


Number of coats: 2 x 1.  
Dry coat thickness: 50-55 $\mu$ m (2 x 1).  
Recommended working conditions:  
- Minimum temperature: +10°C  
- Maximum relative humidity: 70%.



Evaporation time between coats at temperature +20°C:  
- 5-10 minutes.  
Pot-life of top coat mixture:  
- 2-6 h.

### Drying



At temperature +20°C:  
Dust dry: 60 minutes.  
Workability: 8 hours.  
Hardening: 12 hours.



At temperature +60°C:  
Dust dry: 10 minutes.  
Workability: 45 minutes.  
IR radiator: 10 - 15 minutes.

All properties of coat are guaranteed after seasoning period, namely 5 to 7 days.

### Grinding



Following 24 hours at temperature +20°C polishing may be provided as well as repairs in case of defects and inclusions by using abrasive materials:

- Manually on wet with P1500-5000 sandpaper

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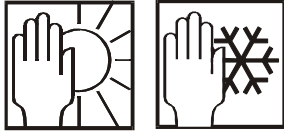
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- By machine with P1500-5000 sandpaper.

Tool cleaning: Nitrocellulose or Acryl thinner.

Storage:



Store in closed, original containers, in dry and well ventilated spaces, at temperature +5°C to + 30°C.  
Protect against freezing.

Industrial Safety:



Product for professional use only.  
See: labels on containers and MSDS.  
User shall follow locally and regionally applicable industrial safety regulations.

VOC:

Permitted VOC in g/l of product ready to use:  
840g/l dla APP MODULAR 2K Acryl Line.  
Maksymalna zawartość LZO g/l w produkcie gotowym do użytku:  
<840g/l dla APP MODULAR 2K Acryl Line.

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