



APU 104: Acryline 5:1 2K Superfill Primer

- » High filling properties
- » Good vertical stability
- » Excellent gloss hold out of finishing coats
- » Outstanding flow ensuring an ultra smooth surface
- » Advanced drying and sanding properties

Technical Description

- » Mix 5:1 with Acryline 2K Hardener (APU 202/3)
- » Potlife 60 min @ 23°C
- » Air dry / force drying possible

APU 104: Acryline 5:1 2K Superfill Primer

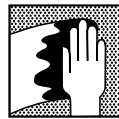
WORKING PROCESS:

5:1 as a High Build Filler Primer

SUBSTRATE:

- » Pre-primed Aluminium and Galvanised zinc substrates with Acryline Etch Primer (APU 107)
- » Through-hardened sanded paintwork
- » Fibre glass, cleaned and sanded
- » Steel, rust free, cleaned, sanded and appropriately primed
- » E-coat, sanded

PRETREATMENT / CLEANING:

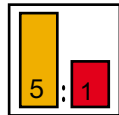


Ensure that all surfaces are clean, free from dust, oil, grease or other contaminants by using Acryline Pre-cleaner (ATH 310)

APPLICATION:



Use air fed respirator.
Refer to relevant Health and Safety Data sheets.



5:1 with Acryline 2K Hardener (APU 202/3)
Potlife 60 min @ 23°C



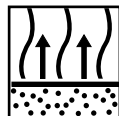
Thin with Acryline Thinner (ATH 301/302)
22 - 28 sec DIN 4 @ 23°C
Thin up to 10%



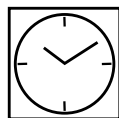
1.6 - 1.8 mm
HVLV: 1.8 - 2 bar
Conventional: 3 - 4 bar
2-3 coats = 80 - 120 micron



1.7 - 1.9 mm
Conventional 3 - 4 bar
2-3 coats = 80 - 120 micron



5 - 10 min @ 23°C
Flash off between coats and final flash off
Depending upon film build and temperature



30 min @ 60°C
Panel temperature
Air dry 3 hours depending on film build



Short wave 10 min (80-120 µm) / 15 min (> 120 µm)
Medium wave 15 min (80-120 µm) / 20 min (> 120 µm)



P400 - P500
Orbital sander



P600 - P800
Wet sanding

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| Flashpoint: | Specific Gravity: | Solid content: | Solid content: (mixed with hardener) |
|-------------|---------------------------------|--|--|
| 23°C | 1.4 g/cm ³ (approx.) | Approx 65% by weight Approx 42% by volume | Approx 60% by weight Approx 40% by volume |

Coverage (without reducer): Approx 5 m²/lt at 80 micron dry film thickness

Average DFT: 80 micron

Raw Material: Acrylic resin and inert fillers

Cleaning of Equipment: Clean equipment immediately after use with Lacquer Thinner

Shelf Life: 12 months @ 20 - 25°C in original sealed packaging

Important remarks:

- » For professional use only
- » This product cannot be used over uncured paint work and thermoplastic finishes



Protect from sunlight



Working areas should be well ventilated
Booth must have good extraction
Refer to Material Safety Data Sheet (MSDS)



Protect from severe cold



This product contains flammable materials
Keep away from sparks & open flames
No smoking permitted in the area

Warning:

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Note:

The information contained here represents the current state of our knowledge and is intended as a guide to our products and their uses. It is not intended as an insurance of certain product properties or of their specific applications. The warnings displayed on the product labels should be followed. Any industrial property rights should be observed. We guarantee perfect product quality under the terms of our general conditions of sale.

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