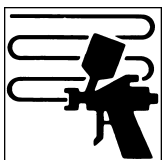
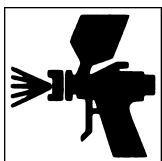
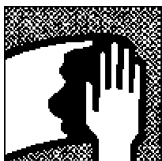
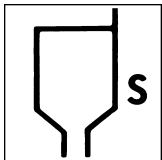
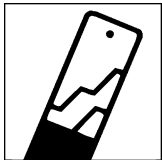
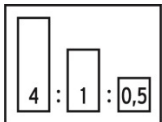


Technical Information Sheet - Product Information

Product: **2K ACRYL-PRIMEFILL 4:1**

(white, light grey, dark grey, black)



Properties:

This modern 2c acrylic filler is quick drying both when forced and at room temperature, easy to sand, and has a high filling capacity. Depending on the thickness of the coating, 2K ACRYL-PRIMEFILL 4:1 can be used as a high build filler or as a primer.

Good adhesion on aluminium, steel plate, galvanised steel plate, and GRP.

Applications:

Car repairs, manufacturing

Instructions for use:

The surface to be coated must be carefully cleaned, removing all dirt, grease and remnants of old paint, and sanded. Stir 2K ACRYL-PRIMEFILL 4:1 before use and carefully mix the desired quantity with 2K PRIMEFILL HARDENER at a ratio of 4:1, and dilute with airo 0.5 Acrylic Thinner.

After use, the containers must be carefully sealed and protected against moisture.

Application parameters:

Mixing ratio:	2K ACRYL-PRIMEFILL:	4.0 vol.
	2K PRIMEFILL HARDENER:	1.0 vol.
	airo Acrylic Thinner:	0.5 vol.

Application viscosity: 30 - 35 s / DIN 4 mm / 20 °C

Nozzle: 1.5 - 1.7 mm / **Air pressure:** 1.5 – 2.0 bar

Number of stages: Filler: 2 - 3 / Primer: 1 - 2

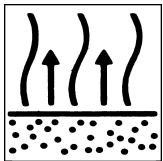
Flash-off times: 5 - 10 min

Recommended thickness of coating: Filler: 100 - 160 µ / Primer: 60 - 90 µ

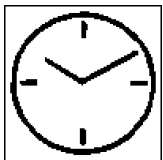
Technical Information Sheet - Product Information

Product: **2K ACRYL-PRIMEFILL 4:1**

(white, light grey, dark grey, black)


Drying time:

- a. Air drying: +20 °C: 3 - 4 hours
- b. Kiln drying: +60 °C: 15 - 30 min (after 5-10 min flash-off time)
- c. IR drying: 5 - 10 min (according to machine type)


Sanding:

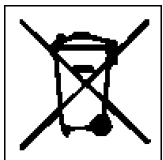
Filler: Dry sandpaper P320 / P400
 Primer: Dry sandpaper P400 / P500

Wet sanding is possible if required.

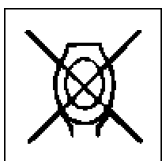

Chemical basis:

2K ACRYL-PRIMEFILL 4:1:

Acrylic resins, anti-corrosion pigments, filling materials, and solvents


Pot life:

45-60 minutes


Processing temperature:

The ambient and material temperatures should be between +18 °C and +25 °C during application.

Do not use at less than +15 °C.

Storage stability:

At + 20 °C in tightly sealed containers: at least **12 months**.

Disposal:

Dispose of according to official local regulations.