

SPECIFICATIONS

Prepared on:
March 22, 2005



Updated on:
March 22, 2005

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Product name: APP 1K Filler

Unary filling primer providing active anticorrosion protection, for the repairs of small and larger surfaces. Chromate- and lead-free.

Container: 1.00 l.

Product and additives: APP 1K Filler;
APP 2K Verdunnung AVS.

Colour: Grey.

Output: 5-7 m²/l.

Caution!

In practice the output depends on certain factors including: object shape, roughness of the base, method of application and working conditions.

Usage: The product is intended for the repairs of body elements of motor cars, delivery vans, trucks, and buses.

Base

Proper base types:

Steel, zinc-coated steel sheet, aluminium.

Polished factory-made coats, surfaces primed and precoated with polyester products, and polyester laminates.

Caution!

Do not apply onto surfaces covered with thermoplastic lacquer (T.P.A.).
Apply APP 1K Haftgrund first in order to enhance the adhesion properties and corrosion resistance.

Base preparation:



Thoroughly remove all possible corrosion centres and polish dry all lines of transition to the old lacquer coat and polyester filler layers, using P280-P320 abrasive paper.



Before spraying the filler, remove any dust from the treated surface and degrease it using W900 remover.

The above information complies with current knowledge on our products and their possible applications. This guarantees no specific properties or usability in particular conditions. Users should observe guidelines and warnings provided on product labels and specified in material safety data sheets. We hold no responsibility if conditions beyond our control affect the final result of work.

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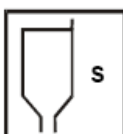
Application

Mixing ratio(s):



Add up to 50% (max. 70%) of the APP 2K Verdunnung AVS thinner in order to obtain the proper spraying viscosity.

Caution: cross dyeing is not recommended.



Spraying viscosity at +20°C: 18-22 s 4mm DIN.

Applying:



Apply using a spray gun equipped with a $\phi 1.4$ - $\phi 1.8$ mm nozzle at an air pressure ranging from 3.0 to 4.0 bar.

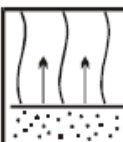


Number of layers: 2-3.

Dry coat thickness: 40-50 μm .

Recommended working conditions:

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



Evaporation time between successive layers at the temperature of +20°C: 10 minutes.

Drying:



At a temperature of +20°C:

Dust dryness: 15 min.

Ready for overcoating: 30 min.

Wet polishing: 45 min.



At a temperature of +60°C:

Dust dryness: 5 min.

Ready for overcoating: 15 min.

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Polishing:



Proceed as follows after complete hardening:

- wet polishing by hand with P600-P1000 abrasive paper;
- dry machine polishing with P360-P400 abrasive paper.

Coverage:

Unary and binary top coat lacquers:
e.g.: APP 2K Acryl Lack, APP Color MIX RAL 2:1,
APP Acryl Lack MS 2:1 RAL, base paints.

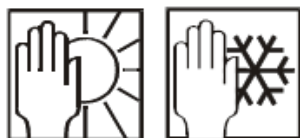
Caution!

Do not apply spray fillers onto the APP 1K Filler.

Equipment cleaning:

Nitrocellulose solvent.

Storage:



Store in original, closed containers in a dry and well-ventilated room.
Protect against freezing.

Industrial safety regulations:



For professional use only.

See: information on product labels and/or in Hazardous Material Safety Data Sheet.

Users should observe all industrial safety regulations applicable in their countries.

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