FREEWORLD
AUTOMOTIVE COATINGS

Data Sheet Number:
APU-03-3
APU 105

APU 105: Acryline 4:1 2K Filler Primer

- High build 2K Filler Primer
- Good filling properties
- Excellent gloss hold out
- Easy to sand
- Excellent sag resistance
- Anti-corrosive properties

Technical Description

- Mix 4:1 with Acryline 2K Hardener (APU 202/3)
- Potlife 60 min @ 23°C
- Air dry / force drying possible

APU 105: Acryline 4:1 2K Filler Primer

WORKING PROCESS:

4:1 as a High Build Filler Primer

SUBSTRATE:

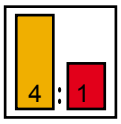
- Pre-primed Aluminium and Galvanised zinc substrates with Acryline Etch Primers (APU 106)
- Through-hardened sanded paintwork
- Fibre glass, cleaned and sanded
- Steel panel, rust free, cleaned and sanded
- E-coat, sanded

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.

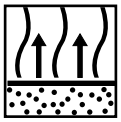


4:1 with Acryline 2K Hardener (APU 202/3)
Potlife 60 min @ 23°C

Thin with Acryline Slow Thinner (ATH 301)
22 - 24 sec DIN 4@ 23°C

1.6 - 1.8 mm
HVLP: 1.8 - 2 bar
Conventional: 3 - 4 bar
2 coats = 45 - 60 micron

1.8 - 2.0 mm
Conventional 3 - 4 bar
2 coats = 45 – 60 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 2 hours depending on film build

P320 - P500
Orbital sander

P600 - P800
Wet sanding

APU 105: Acryline 4:1 2K Filler Primer

Flashpoint:	Specific Gravity:	Solid content:
23°C	1.4 g/cm³ (approx.)	+/- 60% (by weight)

Average DFT: 50 micron.

Raw Material: Acrylic resin, corrosion-resistant pigments 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.

Freeworld Automotive Coatings (Pty) Ltd:

Cape Town
P.O.Box 42
Eppingdust 7475
Tel: (021) 505-2400
Fax: (021) 534-3791

Durban
P.O.Box 1386
Durban 4000
Tel: (031) 451-3200
Fax: (031) 451-3408

Alberton
P.O.Box 136178
Alberton North 1456
Tel: (011) 861-0300
Fax: (011) 907-8858

Port Elizabeth
P.O.Box 1594
Port Elizabeth 8000
Tel: (041) 401-1400
Fax: (041) 453-4612