

Technical Instruction Sheet

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Characteristics: AKEMI® 2K HS-Acrylic-Filler is a high quality solvent filler-formulation based on Acrylate hardened with Isocyanates. The product is distinguished by the following qualities:

- outstanding filling properties
- excellent corrosion resistance
- quick drying
- excellent adhesion and mechanical resistance
- high solid Contents
- simple and safe application
- easy to sand
- the top coat has a good resistance to sagging

Field of Application: AKEMI® 2K HS-Acrylic-Filler is mainly used for manufacturing of vehicles, cars and machinery and wherever there may be high Visual requirements for paint Jobs (on various surfaces such as iron, steel, zinc-plated steel, aluminium)

- Instructions for Use:**
1. The surface must be clean, dry and free of dust, oil or grease
Steel surface:
Sandblast according to Norm-purity Sa 214 of EN ISO12944, part 4;
Alternative: remove rust manually
Zinc-plated surfaces: high pressure steam cleaner
Aluminium: clean thoroughly, remove impurities according to EN ISO 12944
 2. Do not apply at object temperature below + 5°C. Best application temperature + 15°C to +25°C. Surface temperature must be at least 3°C above the dew point of the ambient temperature.
 3. Four parts by volume (six parts by weight) 2K HS Acrylic-Filler are thoroughly mixed with one part by volume (one parts by weight) of AKEMI® Hardener normal for 2K HS Acrylic-Filler.
 4. Thinning with PUR/Acrylate-Thinner:

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|-----------------------|------------|--|
| Spray-gun: | Viscosity: | 30-45 s/4mm DIN Cup add 10-20%thinner |
| | Nozzle: | 1,5 - 1,8 mm; air pressure: 3-5 bar |
| Spray-gun HLVP: | Viscosity: | 30-45 s/4mm DIN Cup add 10-20%thinner |
| | Nozzle: | 1,5 - 1,9 mm; air pressure 3 bar, |
| Spray-gun Airless: | Viscosity: | 40-60 s/4mm DIN Cup add3-10%thinner |
| | Nozzle: | 0,33 - 0,38 mm, pressure: 120-160 bar |
 5. Potlife 20-30 min. h at 20°C and 65% rel. humidity
 6. Drying Time, sanding and overcoatable

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|-----------------------|------------------|
| Dust free: | after 30 minutes |
| Touch dry / to sand: | after 4 – 5 h |
| Overcoatable: | after 5 – 6 h |
| Wet in wet paintable: | after 20 – 30 |
| Through dry: | after 12 – 24 h |

The drying times are based on tet at 20°C and 65% relative humidity with a dry film thickness of approx. 60µm.

Oven drying: possible up to 80°C, flash-off time 15 min. before
 Can be sanded: after 60 minutes at 40°C (object temperature)
 Can be sanded: after 35 minutes at 60°C (object temperature)
 Can be sanded: after 25 minutes at 80°C (object temperature)

| | | |
|-------------|------------------|----------------|
| Wet sanding | Initial sanding: | P 500 - P 600 |
| | Final sanding: | P 800 - P 1000 |
| Dry sanding | Initial sanding: | P 280 - P 320 |
| | Final sanding: | P 360 - P 400 |

7. Tools can be cleaned with PUR/Acrylate-Thinner
 8. Empty the container fully before disposing of it.

Technical Data:

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| Colour: | light grey, anthracite |
| Gloss: | matt |
| Resistance: | temperature resistance up to 130°C (dry coat) |
| Solids of weight: | approx. 66+ / -2% (of mixture) |
| Solids of volume: | approx. 47+ / -1% (of mixture) |
| Density: | approx. 1,35 g/ml (of mixture) |
| Recommend dry film: | 60 – 120 µm, maximum 150 – 200 µm |
| Theoretical coverage at 80 µm DFT: | approx. 4,2 m ² / kg The practical coverage may be lower depending on the kind of application, design, roughness of substrate or application conditions. |
| Theoretical consumption At 80 µm DFT: | approx. 240 gr/m ² |
| Viscosity as supplied at 20°C: | (Base component) approx. 40 dPas Hardener approx. 12 s/4 mm DIN cup (DIN 53211) |
| Shelf life: | 12 months in originally sealed containers stored at cool place, hardener 6 months. |

Safety Measures: Please refer to the EC safety data-sheet

Notice:

The above information is based on the latest stage of our development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trials of the product, in an inconspicuous area or fabrication of a sample piece.