

Acryline: 5:1 2K Superfill Primer

PRODUCT CODE: APU 104

TECHNICAL DATA SHEET.

Product Description	2K Acrylic Super high build filler Primer.	
Intended Uses	High fill primer for use on mild steel, fibre glass, wood, some aged coatings, E-Coat and pre-primed with (APU 107) Aluminium & Galvanised surfaces.	
Features	Premium quality primer with excellent filling properties. Good vertical stability. Outstanding flow for ultra-smooth finish and advanced drying/sanding properties.	
Product Information	Appearance	Matt finish.
	Colour	Light grey.
	Generic type	Acrylic Polyurethane.
	Solvent type	Aromatic/Esters.
	Specific Gravity	± 1.322.
	Volume Solids (mixed)	± 39.55%.
	Recommended DFT	70-90 µm
	Theoretical spreading rate	5 m ² per lt. @ 80 µm.
	Viscosity @ 23 °C (mixed)	≈ 47 sec. Din cup 4.
	Pot life a@ 23°C (mixed)	1hr.
	Flash Point	Base 25°C Hardener 4°C.
Mixing Details	Ratio	5 parts base to 1-part hardener by volume
	Hardeners	APU 202 slow, APU 203 medium.
	Thinners	ATH 301 medium, ATH 302 fast.
		Add thinner to required viscosity, based on equipment used, 0-10% @ 23°C.
		Mix thoroughly until homogeneous.
Drying Times @ 23°C	Flash off	5-10 min.
	Touch	1hr.
	Handle	2 hrs.
	Hard	4 hrs.
	Force	30 min. @ 60°C panel temperature.
		Drying times are based on the specified dry film build.
Surface Preparation	Mild steel	Remove all rust deposit back to bright metal finish.
	Fibre glass	Sand to create a key with a matt finish.
	Wood	Lightly sand to remove fibre hairs.
	Aged coatings	Sand to remove gloss and create a suitable key. (Test for Compatibility)
	E-Coat	Thoroughly sand to create a key.
	Pre-primed surfaces	lightly sand to remove nibs and over spray.
	Contamination	Remove all contamination with Acryline Pre-Clear (ATH 310) using the spray on wipe off method.
Recommended Primer	Aluminium	Self priming.
	Galvanised Iron	Acryline Etch Primer (APU 107).
		Acryline Etch Primer (APU 107).
Application Equipment	Conventional cup gun	Applicators must ascertain the most suitable needle, fluid tip and air cap for the type of article being coated.
	HVLP	
	Air assisted	Air and atomising pressures must be set to produce the optimum delivery efficiency and quality of finish
	Airless	
	Pressure pot	

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Environment	Temperature	Surface	Ambient	Relative Humidity
	Min.	10°C	10°C	10%
	Max.	35°C	35°	85%
Cleaning	Equipment	Flowline thinner KNT 1.		
Safety Precautions	<ul style="list-style-type: none"> • Always keep paint out of reach of children. • Ensure good ventilation during application and drying. • If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner. • Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention. • Harmful if swallowed. Seek medical attention and do not induce vomiting. • Do not smoke while painting. • Flammable. Store in a cool dry place away from heat and sparks. • CATALYST contains isocyanate – use suitable respirator, particularly during spray application of the mixed material. • Refer to Safety Data Sheet for complete information. 			

DISCLAIMER:

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

N.B. Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

NB: TO ORDER: Quote product name, product code number, packaging and colour.

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