AF.21 1K Filler

1K Hybrid filler

V01
11/2021

CHARACTERISTIC

- 1K Hybrid filler - acrylic / epoxy
- Drying time: 10 min / 60 °C object temperature
- VOC compliant

AREA OF APPLICATION

- For isolating putty spots
- Painting of new parts
- Filling of plastic parts with direct adhesion without applying a primer first (except PE & PP)

BENEFITS

- 100% rust protection
- Very user friendly
- Very good sandability

PRODUCT DATA

MATERIAL DATA

Colour:	grey
V.O.C.:	2004/42/IIB(c)(540) < 540 g/l
Shelf life:	12 months in closed original container at 20 °C
Density filler at 20 °C:	1.41 - 1.45 g/cm³
Density hardener at 20 °C:	0.79 - 0.81 g/cm³
Efficiency:	8 m²/l at a dry film thickness of 60 µm

HANDLING

The surface must be finely sanded, dry and free of impurities.
It is strongly recommended to work with the complete system. Drying and adhesion problems cannot be excluded with use of thinning materials of external systems.

Adhesion to steel, aluminium, e-coat, galvanized steel, putties, old paint and plastics.

Plastic parts made of PE, PP and mixed plastics made therefrom must be flame-treated or pre-activated with Carsystem Plastic Primer.
Due to the variety of existing plastic types the compatibility with the substrate must be checked in advance.

CARSYSTEM HEADQUARTERS
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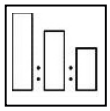
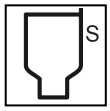
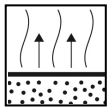
MIXING RATIO		
	**AF.21 1K Filler** **AF.21 1K Filler Thinner**	**by volume** 2 1
	AF.21 1K Filler **AF.21 1K Filler Thinner**	**by weight** 100 g 28 g
SPRAYING VISCOSITY		
	**DIN cup 4mm at 20 °C**	19 - 21 seconds
APPLICATION		
	Spray gun **gravity feed**	**Nozzle size / pressure** Nozzle size: 1.3 - 1.6 mm Air pressure: Please pay attention to operating pressure recommendations of the manufacturer.
	Application	**spraying operations** 1 - 2
	Pot life at 20 °C	-
	**Flash off**	4 - 5 minutes
	Dry coat thickness	25 - 30 µm per coat
	Process conditions	Temperature 18 - 22 °C Relative air humidity 40 - 60 %

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PROCESSING			
	Object temperature	**20 °C**	**60 °C**
	Drying time	25 - 30 min	5 - 10 min
	Dry sanding	P400 - P600	
	Wet sanding	P800 - P1000	

STORAGE AND TRANSPORTATION CONDITIONS

Protect from freezing, heat, sunlight and moisture. Store tightly closed in a dry, cool place. Recommended storage and transportation temperature range is: +10 to +30 °C. Avoid extreme temperature fluctuation.
Note: The storage and transportation temperature must be not lower than +5 °C. Acclimatize the product to room temperature naturally.

2004/42/IIB (c)(540) < 540: The EU limit value for this product (product category: IB.c) in ready to use form is max. 540 g/litre of VOC.

REMARKS

Allow the product to reach the recommended application temperature naturally (avoid rapid heating/cooling). It is not recommended to apply the product at a temperature below 18 °C. Low application temperature changes the coating‘s properties and may impair the visual effect. Prior to application, the product temperature, spray booth temperature and object temperature should be adjusted to about 20 °C.

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SAFETY ISSUES

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions.
In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgement in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

Directions for handling and waste disposal are in our Material Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry.

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