

AF.21 X-pert

2K Acrylic filler

V04
03/2024

Description

- 2K Acrylic filler
- Universal filler
- Drying time: Standard: 25 min / 60 °C object temperature
Wet-on-wet: 25 min / 20 °C object temperature
- VOC compliant

Area of application

- All common filling works from spot repair to full vehicle
- Very good adhesion on steel, aluminium, zinc, e-coat primers, plastic (wet on wet application) and polyester fillers
- Anti corrosion protection
- New part painting on e-coat primer

Benefits

- Settable as wet-on-wet
- Excellent sandability
- Layer thicknesses can be flexibly adjusted (low to very high layer thicknesses)
- Application on e-coat primers without sanding
- Also adheres to plastic in wet-on-wet setting

Product data

VOC:	2004/42/IIIB(c)(540) < 540 g/l
Shelf life:	12 month in closed original container at 20°C
Density Filler white / grey at 20 °C:	1,62 - 1,66 g/cm ³
Density Filler black at 20 °C:	1,54 - 1,59 g/cm ³
Density hardener at 20 °C:	0,97 - 0,99 g/cm ³
Density thinner at 20 °C:	0,88 - 0,92 g/cm ³
Theoretical efficiency standard:	10 - 15 m ² /l at a dry film thickness of 50 - 70 µm
Theoretical efficiency wet-on-wet:	19 m ² /l at a dry film thickness of 30 µm

Application

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

For sufficient adhesion, the substrate must be sanded and tempered.

After sanding with sanding fleece grey and cleaning, the following plastics can be coated (ONLY in wet-on-wet setting):

ABS/PCV, PC, PP/EPDM, PPE/PA

Metal substrates should not be sanded coarser than P220 / P240.

Without sanding, adhesion between filler and substrate cannot be guaranteed

Coating without sanding max. 3 Days.

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MIXING RATIO

		Standard	Wet on Wet
	AF.21 X-pert AF.21 X-pert hardener Standard / Wet on Wet thinner		4 1 20%
AF.21 X-pert AF.21 X-pert hardener Standard / Wet on Wet thinner		100 g 15 g 13,5 g	100 g 15 g 25 g

SPRAYING VISCOSITY

	DIN cup 4mm at 20°C	20 - 25 seconds	15 - 20 seconds

APPLICATION

	Spray gun gravity feed	Nozzle size / pressure	
			1.6 - 1.8
		Air pressure: Please pay attention to operating pressure recommendations of the manufacturer	
	Application	Spraying operations	
		1 - 2	1
	Pot life at 20°C	20 - 30 min	30 - 40 min
	Flash off	7 - 10 min	-
	Dry coat thickness	50 - 70 µm per coat	20 - 30 µm per coat

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	Process conditions	Temperature 18 - 22 °C Relative air humidity 40 - 60%	
	Object temperature	Standard	Wet on wet
	20 °C 60 °C	2 - 2,5 h 25 min	20 - 30 min -
	IR Drying	8 - 10 min Follow the recommendations of the IR lamp manufacturer. Keep the flash-off time before drying	-

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/IIIB (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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