

AF.21 X-pert

2K Acrylic filler

V05
11/2025

Description

- 2K acrylic filler
- VOC compliant
- Universal filler
- Variably adjustable through different thinners and additives (Standard, Wet-on-Wet, Air Dry)

Area of application

- All common filler applications in a bodyshop, from small parts to full resprays
- Suitable for all substrates
- Efficient coating of new parts

Benefits

- Adhesion to steel, aluminium, galvanised surfaces, e-coat, plastics (with Multi Wet-on-Wet thinner without plastic primer), polyester fillers and wood
- Variable adjustment of film thickness with up to 90 µm per spray pass
- Original e-coat can be overcoated in a wet-on-wet process without sanding
- Sanded plastics can be coated directly using AF.21 X-Pert Thinner Multi Wet-on-Wet and do not require a plastic primer
- AF.21 X-Pert Thinner Air Dry additive significantly shortens drying times at 20°C and 60°C
- Contains corrosion protection

Product data

Material data

VOC:	2004/42/IIIB(c)(540) < 540 g/l	
Shelf life: 1	2 months in unopened packaging 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:	0.89 – 0.91 g/cm ³	
Theoretical efficiency standard:	10 – 15 m ² /l	at a dry film thickness of 50 – 90 µm
Theoretical efficiency wet-on-wet:	19 m ² /l	at a dry film thickness of 30 µm
Theoretical efficiency Air Dry:	7.5 m ² /l	at a dry film thickness of 80 µm

Application

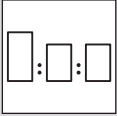
The substrate should be dry and completely free of contaminants. It is strongly recommended to work within the system. When using thinners and hardeners from other systems, drying and adhesion issues cannot be ruled out.

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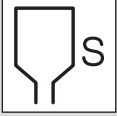
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MIXING RATIO


		Standard	Wet on Wet	Air Dry
	AF.21 X-pert AF.21 X-pert hardener Standard / Wet on Wet / Air Dry	4 1 10 - 20%	4 1 40%	4 1 30%
	AF.21 X-pert AF.21 X-pert hardener Standard / Wet on Wet / Air Dry	100 g 15 g 7 - 13,5 g	100 g 15 g 28 g	100 g 15 g 20,5 g

SPRAYING VISCOSITY

		Standard	Wet on Wet	Air Dry
	DIN cup 4mm at 20°C	20 - 40 seconds	18 - 25 seconds	15 - 21 seconds

APPLICATION

		Nozzle size / pressure		
	Spray gun gravity feed	1.6 - 1.8	1.3 - 1.4	1.3 - 1.4
		Air pressure: Please pay attention to operating pressure recommendations of the manufacturer		

		Spraying operations		
	Application	1 - 2	1	2

		Standard	Wet on Wet	Air Dry
	Pot life at 20°C	20 - 30 min	30 - 40 min	15 min

		Standard	Wet on Wet	Air Dry
	Flash off	7 - 10 min	-	4 - 5 min

		Standard	Wet on Wet	Air Dry
	Dry coat thickness	70 - 90 µm per coat	20 - 30 µm per coat	30 - 40 µm per coat

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	Process conditions	Temperature 18 - 22 °C Relative air humidity 40 - 60%		
	Object temperature	Standard	Wet on wet	Air Dry
	Drying time at: 20 °C Drying time at: 60 °C	2 - 2,5 h 25 min	20 - 30 min -	30 - 40 min 10 - 15 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/IIB (c)(540) < 540: The EU limit value for this product (product category: IIB.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.

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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