

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### V2012 Acryl Filler 5:1

#### PRODUCT

V2012 Acryl Filler 5:1 – **Filling and grounding primer for galvanized steel.**  
Hardener 1:5 for Acryl Filler V2012.  
Thinner for acrylic systems.

#### PRODUCT DESCRIPTION

High quality 2-pack acrylic undercoat with excellent adhesion to steel, aluminum, galvanized steel, polyester putties and old coatings. Designed especially for automotive repair.

- ✓ Excellent adhesion to difficult substrates.
- ✓ Easy to mixing and apply.
- ✓ Exceptional vertical stability.
- ✓ Good filling and isolation properties.
- ✓ Easy to sanding.

**Colour** – White, Light Grey, Black.

**Gloss** – Matt.

#### VOLATILE ORGANIC COMPOUNDS

VOC for filling primer = 460 [g/l]

VOC for grounding primer = 510 [g/l]

This product complies with European Union Directive (2004/42/EC), which for this category of product (B/3) provides VOC value of 540 g/l.

#### SUBSTRATE PREPARATION

Acryl Filler V2012 can be applied over:

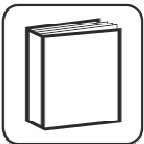
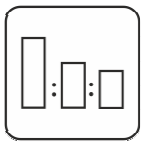

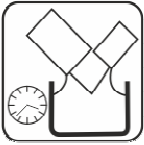

- ✓ Steel and aluminum after sanding and degreased.
- ✓ Galvanized steel after sanding and degreased.
- ✓ Sanded polyester glass laminates (GFK/GRP).
- ✓ 2-pack polyester putties, polyester spraying fillers.

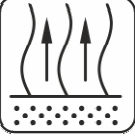




- ✓ Wash primers.
- ✓ 2-pack acryl fillers.
- ✓ 2-pack epoxy fillers.
- ✓ Old finishes in good condition after sanded and degreased.

Good Surface preparation is necessary to achieve the best results of Repairs. Recommended abrasive paper with gradation as follows:

- grinding by hand (dry or wet ) : P280÷P320 (GRP P400).
- grinding by machine (dry) : P180÷P220.

## APPLICATION PROCESS

	<p><b>Application</b> For car repairs as a filling or grounding primer.</p>								
	<p><b>Mixing Ratio</b> <b>by volume</b></p> <table style="margin-left: 20px;"> <tr> <td>Filler</td> <td>5</td> </tr> <tr> <td>Hardener</td> <td>1</td> </tr> <tr> <td>Thinner</td> <td>15% (filling primer)</td> </tr> <tr> <td></td> <td>25% (grounding primer)</td> </tr> </table> <p>Mix well until smooth mixture is achieved</p>	Filler	5	Hardener	1	Thinner	15% (filling primer)		25% (grounding primer)
Filler	5								
Hardener	1								
Thinner	15% (filling primer)								
	25% (grounding primer)								
	<p><b>Spraying Viscosity</b> 40÷50 seconds at 20°C (filling primer ) 25÷30 seconds w 20°C (grounding primer)</p>								
	<p><b>Pot Life</b> Approx. 60 minutes at 20°C.</p>								
	<p><b>Number of layers</b> 1÷3 layers; 60÷300µm depending on the size of the gun nozzle.</p> <p><b>Parameters for RP spray gun</b> Nozzle: 1,6÷2,0 mm; Pressure : 2,0-2,5 bar.</p> <p><b>Parameters for HVLP spray gun</b> Nozzle: 1,5÷1,9 mm; pressure inside the nozzle: 0,7 bar.</p>								

	<p><b>Evaporation Time</b></p> <p>Between coats: 5÷10 minutes Before baking: 5÷15 minutes</p> <p>Evaporation time depends on temperature and film thickness.</p>
	<p><b>Curing time at 20°C:</b> Filling primer /130÷300 µm/ - ready to sand after drying overnight. Grinding primer /60÷130 µm/ - ready to sand after 3÷4 h.</p> <p><b>Curing time at 60°C object temperature:</b> Filling primer /130÷300 µm/ - ready for sand after baking for 35÷40 minutes and cooling dawn (about 2 h). Grinding primer /60÷130 µm/ - ready to sand after baking for 25÷30 minutes and cooling dawn (about 2 h).</p> <p>Temperature below 20°C significantly decreases the hardening time.</p>
	<p><b>IR Drying</b></p> <p>Filling primer /130÷250µm/: 15÷20 minutes under short wave. Grinding primer /60÷130 µm/: 10÷15 minutes under short wave.</p> <p>Drying time may change depending on the type of heater.</p>
	<p><b>Dry Sanding:</b></p> <p>Grinding Machine: P360÷P500. Hand Sanding: P280÷P360.</p>
	<p><b>Wet Sanding:</b></p> <p>Hand Sanding: P600÷P1000.</p>

## FURTHER WORK

2K acryl fillers can be directly over coated with:

- ✓ 2-pack acryl topcoats.
- ✓ 1-pack basecoats.

**GENERAL NOTES**

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results you can achieve at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.

**Caution:** *To maintain safety, always follow the instructions given in the MSDS for the products.*

**STORAGE**

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Note:** *After each use the container with products shall be immediately closed! Protect hardener against freeze and humidity!*

**WARRANTY PERIOD**

V2012 Acryl Filler 5:1 - 12 months from the date of Manufacture.  
Hardener 1:5 for V2012 Acryl filler – 12 months from the date of Manufacture.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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