



ACRYLINE 4:1 FILLER PRIMER

PRODUCT CODE APU 105

PRODUCT DATA SHEET

ACRYLINE 4:1 FILLER PRIMER is a two component, high build polyurethane primer / filler with good filling and anti – corrosive properties. It is specifically designed for use under **ACRYLINE POLYURETHANE ACRYLIC (APU SERIES)**. It can be used wet on wet.

ACRYLINE 4:1 FILLER PRIMER SHOULD BE MIXED THOROUGHLY WITH ACRYLINE HARDENER BEFORE USE. DO NOT USE THE BLEND AFTER THE POT LIFE LIMIT.

USAGE

- In the automotive industry for the refinishing of motor cars, motor bikes and commercial vehicles such as buses, trucks.
- In the boat building industry.
- Light industrial use for plant and machinery.
- Garden furniture, bicycles.
- For interior and exterior applications.

TECHNICAL AND PHYSICAL DATA

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| • Colour : | Beige |
| • Consistency : | Medium viscosity liquid. |
| • Specific Gravity : | 1.42 approximately |
| • Volume Solids : | 42% approximately |
| • Application temperature: | 3°C above dew point. |
| • Dry temperature | Continuous: 60°C |
| • resistance: | Non-continuous: 90°C |
| • Flash Point : | 28°C, closed cup |
| • Hardener: | ACRYLINE HARDENERS APU 202/203 |
| • Mixing ratio: | 4 parts Base : 1 part Hardener by volume |
| • Pot Life: | 75 minutes at 25°C |
| • Packing : | 1 L, 5 L |

Paints should be stirred before use and occasionally whilst in use.
Contact your supplier for further information

APPLICATION

- **Surface preparation:** Apply to clean, rust free bare metal, galvanised steel, fibreglass or to previously painted surfaces that are fully cured. Ensure that all surfaces are clean, free from dust, dirt, oil, grease or any contaminants by using **ACRYLINE PRE CLEANER (ATH 310)**. Wet dry sand primer with P600 grit paper before applying topcoat. If wet sanded, clean and dry surface thoroughly. Wipe surface with **ACRYLINE PRE CLEANER (ATH 310)** before topcoats are applied. Aluminium and zinc areas must be primed with **ACRYLINE ETCH FILLER (APU 101)** before applying **ACRYLINE 4:1 FILLER PRIMER (APU 105)**. Surfaces must be dried thoroughly after sanding and cleaning.
- **Application method:** Conventional spray:

Nozzle orifice	1.7 mm – suction feed 1.5 mm – gravity feed
Nozzle pressure	40 – 60 p.s.i
- **Dilution:** For normal use, after mixing with hardener, dilute with **ACRYLINE THINNER ATH 301 (slow)** or **ATH 302 (fast)** depending on ambient temperature and weather conditions. Thin to a viscosity of 18 – 20 seconds Ford Cup No.4 at 20°C. When used as an isolator, thin to 14 seconds Ford Cup No.4 at 20°C and apply 1 coat of 30 microns.
- **Spreading rate / Film thickness:** Apply at a spreading rate in between 7.0 and 9.0 m²/l. The dry film thickness will vary in between 60 microns and 45 microns.
- **Drying time:**

Baking: Allow a flash-off of 15 minutes and then bake for 30 minutes at 60°C.
Air drying: 60 – 90 minutes at 20°C depending on film build before sanding.
Wet on wet: allow 15 minutes before overcoating.
- **Cleaning solvent:** **KARNAMEL THINNER.**
- **Preceding coat:** **ACRYLINE ETCH FILLER (APU 101)** or **ACRYLINE APU 107 1K ETCH PRIMER** where appropriate.
- **Subsequent coat:** **ACRYLINE FINISH POLYURETHANE ACRYLIC (APU SERIES).**
- **NOTE:** This product cannot be used over ACRYLIC LACQUERS. Wet-on-wet application will lengthen hard-dry time depending on conditions and primer film build.

SAFETY

- **ACRYLINE 4:1 FILLER PRIMER** contain flammable materials, keep away from sparks and open flames.
- Caution – contain isocyanate. When spraying, operator must wear compressed air breathing apparatus or other suitable protection which is satisfactory for use with isocyanates.
- Working area must be well ventilated and booth must have good extraction.
- Wear adequate protective equipment during application.

These recommendations are meant as a guide, no guarantee is implied since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

This data sheet supersedes those previously issued and may be changed without prior notice.

Distributed by Mauvilac Industries Ltd,
Motorway M2, Pailles – Republic of Mauritius.
Tel: (230) 212 5318/19/20
Fax: (230) 212 5315
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