

# Technical Information

## AKROFILL



2K SF Primer

Product Category: **C 2.2**

### Fields of use

2-component primer for direct use on metal substrates (steel, aluminum, galvanized steel as per quality standard of the automotive industry) under STOP FILLER II.

### Additional Information

#### Technical characteristics

Solids content 70 % ± 2	Density 1.430–1.530 g/cm <sup>3</sup>
Storage temperature min. 5°C to max. 45°C	Shelf life 12 months

### Application

Stir well before use

### Substrate / Pre-treatment / Cleaning

Clean with PK 700 or PK 900.

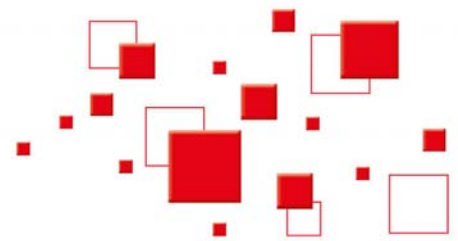
Sand (steel with P80, aluminum with P150-P180, galvanized steel and old paintwork with P240).







Clean with PK 1000.

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	<b>AKROFILL</b> D 501 FR 500 / R 2100 / R 2200 / R 2300	100% by vol. 25% by vol. 25% by vol.	100 g 17 g 15 g
	<b>Viscosity at 20°C:</b> ISO 4 cup: DIN 4 cup:	42 to 58 seconds 18 to 23 seconds	
	<b>Potlife:</b> 3.5 hours at 20°C in a sealed container		
	<b>HVLP gravity-feed spraygun</b> <b>Compliant gravity-feed gun</b>	1.7 – 1.9 mm 1.6 – 1.8 mm	0.7 bar at the nozzle 2.0 bar
	Number of spraycoats: Film thickness:	1 20 – 25 µm	
	Drying at 60°C	20 min.	
	(short wave)	11 min.	

### Finishing

After cool down, further treatment with STOP FILLER II within one working day.

### Safety instructions

**2004/42/IIIB(Cl)(540)520:** The EU limit value for this product (product category: IIB.Cl) in ready-for-use form is max 540 grams of VOC per liter. The VOC content of this product is 520 g/l.

It cannot be ruled out that this product contains particles < 0.1 µm.

The products are suitable for professional use only.

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.