

# AKROFILL

**P 2470**

**2K SF Primer**

**Application:** 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.

**Remarks:** Stir well before use.  
Potlife: 3.5 hours at 20°C in a sealed container.

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<b>Solid Content</b>	70 % +/- 2
<b>Storage temperature</b>	5-45 °C
<b>Shelf life</b>	12 months

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## 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.

## Safety advice:

**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.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions.

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## P 2470 2K SF Primer



**Mixing Ratio** 100 Parts by volume P 2470 2K SF Primer





**Hardener** 25 Parts by volume D 501 Hardener



**Thinner** 25 Parts by volume  
FR 500 THINNER  
R 2100 Thinner, fast  
R 2200 Thinner, medium  
R 2300 Thinner, slow



**Spray viscosity at 20°C** DIN 4: 18-23 s **Potlife at 20°C** 3.5 h  
ISO 4: 42-58 s

	 <b>HVL spray gun</b>	 <b>Compliant gravity-feed spray gun</b>
<b>Application pressure</b> bar		2
<b>Nozzle pressure</b> bar	0.7	
<b>Nozzle size</b>	1.7-1.9	1.6-1.8
<b>Number of spray coats</b>		1
<b>Film thickness</b> µm		20-25

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## Drying



**Drying at 60°C**      20 min



**Infrared (short wave)**    11 min

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

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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