

PRODUCT DATA SHEET

FILLER 46
Poly-acrylic primer

CHARACTERISTIC Two-component, filler, formulated with hydroxylated acrylic resin and active pigments (zinc phosphate) to be crosslinked with Induritore Poliuretano aliphatic isocyanate high solids when used as an intermediate or with Induritore Primer Acrilico when used as a primer. It is characterized by good adhesion on different metals, elasticity and sanding properties, suitable to be applied both in high and low thicknesses. With Induritore Poliuretano HS high solids ensures low emissions.

IUSE It is used as a filler with good insulating properties for systems of industrial bodywork, cars, industrial machinery. Particularly suitable for the protection of steel surfaces, light alloys, fiberglass, galvanized sheets; It can be used as a primer on new surfaces which is in maintenance.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Specific weight (A+B)	1400-1500 g/l	
Application temperature	< +120 °C	
Flash point	>23°C	
Solid by volume (A+B) by Ind. Poliuretano HS	65±2%	
Solidi in volume (A+B) by Ind. Primer Acrilico	60±2%	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1500-1600 g/l	Internal PF3
Pot-life	> 5 h	Internal PF7
Drying Time	Fully 24 h	Internal PF2

THICKNESS AND YIELD

By Induritore Poliuretano HS	Min.	Max	Recommended
Thickness of dry film, µm	40	100	70
Thickness of wet film, µm	60	150	105
Theoretical yield, m²/l	16,7	6,7	9,5
Theoretical yield, m²/kg	11,5	4,6	6,6
By Induritore primer Acrilico	Min.	Max	Recommended
Thickness of dry film, µm	35	60	50
Thickness of wet film, µm	60	100	80
Theoretical yield, m²/l	16,7	10	12,5
Theoretical yield, m²/kg	11,5	6,9	8,6

STORAGE

Product is stable till one year as long as it is kept in original and unopened buckets at temperature between +5°C e +30°C.

COLOUR PREPARATION OF SURFACE

The range of colours can be chosen in shades of RAL.
 The treatment of the surface to be coated is of primary importance and affects the performance of the coating cycle.
 A good and correct preparation of the substrate is a guarantee of quality on the duration of the coating: a high quality product applied on a poor substrate or on substrate inadequately treated is destined to an early wear, characterized by possible alteration of the coating itself.

PRODUCT DATA SHEET

FILLER 46**Poly-acrylic primer****HOT GALVANIZED STEEL**

It is important to remember that the galvanized sheet must be passivated leaving the products exposed to atmospheric agents for at least two months; then proceed with a light sanding to remove the superficial oxidation patina formed and degrease the surfaces with Nitro NV 5000 thinner.

Alternatively, a light silica sandblasting is recommended.

LIGHT ALLOYS

Perform a light sanding with P180 P220 sanding paper. Clean the surface to be treated with Nitro NV 5000 thinner and make sure it is dry and free from silicone, waxes, greases and foreign substances in general.

General considerations

On surfaces with poor preparation, we recommend the application of the first layer by brush with product slightly diluted to facilitate wetting and penetration of the product in order to promote better adhesion.

New steel

The surface must be clean and dry, free of oils and other contaminants. Sandblasting Sa2,5 ensures the best anti-corrosion performance.

Surfaces treated with shop primer

If undamaged, clean and free from any dirt, oil, grease, salts and dry, it can be painted otherwise perform the preparation as for coated surfaces.

Coated surface

With primer: it can be painted if the substrate is clean and free of dirt, oil, grease, and the application falls within the maximum re-coat time of the primer. If cleaning is required, perform pressure washing grade Wa 2 (surface free of oil, grease, salt, dirt).

With complete finishing coat: if undamaged compatible and non-chalky perform cleaning from any oil and grease with detergent, then run sanding surface followed by pressure washing to remove dust and salts.

Rusty coating: perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½; then restore the thickness of primer.

Localized maintenance: perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½. Round off the edges of the well anchored painting and restore the system in the original layers and thicknesses.

It can be applied and sanded before finishing. For dry sanding P180 then P240, wet with P500 and P800.

TOOLS

Conventional spray, airless, limited to areas not extended and touch-up, roller, brush.

PRODUCT DATA SHEET

FILLER 46
Poly-acrylic primer

APPLICATION	Mix ratio in weight	100:25 by Induratore Primer Acrilico
	Mix ratio in volume	100: 8 con Induratore Poliuretano HS
	Thinning	100:36 Induratore Primer Acrilico
	Time of use	100:10 Induratore Poliuretano HS
	Application condition	0-5% by Diluente Butol
		4 h
		+5°C +40°C
Application by airless		>3°C at dew point
		Relative humidity: <70%
		Nozzle pressure: 15 MPa (150 kp/cm ² , 2100 psi).
		Nozzle: 0,43 - 0,58 mm (0,017 - 0,023")
		Angle range: 40 - 80°
Thinner for washing		Air pressure: Compression ratio 45:1 (pressure 150-180 kg/cm ²)
		Diluente Nitro NV 5000

DRYING TIME

Dry time are purely indicative as it might be longer or shorter by keeping in consideration ventilation, humidity, thickness of the applied film. The complete curing takes place at temperatures >5 ° C; it is however possible to apply the product at even lower temperatures. In case of low temperatures, it is important to ensure the induction time indicated. In case of high temperatures, apply the product immediately. There is no limit to the maximum time of over painting, however the best adhesion is achieved when applying the next coat before the time of complete curing.

DFT 50/60 micron

Surface temperature	5°C	10°C	23°C	30°C
Out touch	3h	60'	30'	20'
Dry touch	12h	6h	3h	2,5h
Full catalysis	3 days	10h	8h	18h
Minimum time of over application	12h	6h	3h	2,5h

 RECOMMENDED FINISHES
 RECOMMENDED SYSTEM

Polyurethane, Epoxy, Chlorinated rubber, Vinyl

Marine and industrial atmosphere C3 –C4

Product	Coat	Wet Thickness	Dry thickness
Epoxy zinc 2K	1	90	60
Filler 46	1	105	70
Pur TOP 52	1	100	60
HS			
Total	3	295	190

PRODUCT DATA SHEET

FILLER 46**Poly-acrylic primer**

ALTERNATIVE SYSTEM	Product	Coat	Wet Thickness	Dry thickness
	Filler 46	1	80	50
	Pur Car 51 HS	1	100	60
	Total	2	180	110

INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary. This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.