

# ACRIFILLER FAST

## Series 3470

2K acrylic, ultra-fast, sandable filling primer for car-refinish and industrial vehicles



### TECHNICAL FEATURES

2K, Ultra High Solid, very fast drying, multi-surface, sandable, acrylic filling primer for bodywork, with filling properties used in the automotive sector for car-refinish and industrial vehicles. It is suitable as first coat for substrates in iron, iron coated with a primer, plastic (ABS and PVC). The product has excellent drying speed, high sagging stability and low absorption of the finish. It can be applied in two-coat systems and in direct gloss systems.

### APPLICATION FIELD

As an ultra-fast filling and sandable primer (P800/1000 wet paper, P400/P600 dry paper) for car-refinish and industrial vehicles.

Classification according to Directive 2004/42/EC - Legislative Decree 161/06 - Cat. B/c) Surfacers/filler and general primer. EU LIMIT VALUE 540 g/l - CONTENT 540 g/l

## GENERAL INFORMATION

**System:** Two pack - 2K

**Nature:** Solvent-based

**Packages:** 1 l - 4 l

**Colors ready in stock:** Grey Ral 7040

**Suitable Substrates:** Iron, Thermoplastics (ABS, PVC, PC), Fiberglass and Thermosetting plastics

**Overcoatable with:** Acrylic and polyurethane enamels

## SUBSTRATE PREPARATION

The iron support must be perfectly clean, free from greasiness and previously sanded. OEM and/or existing paints must be carefully sanded and cleaned.

## APPLICATION

### Application conditions

The application of the paint product is subject to various factors such as environmental conditions (among which it is necessary to mention temperature, humidity and ventilation), the geometry and laboriousness of the products to be painted, the type of surface profiles and the thicknesses to be applied. Spray application with HVLP/LVLP gravity gun with 1.7 - 1.8 mm nozzle is recommended. Apply in two coats with intervals of 1 - 2 minutes of flash off.

| EQUIPMENT          | VISCOSITY            | NOOZLE       | PRESSURE    | NOTES     |
|--------------------|----------------------|--------------|-------------|-----------|
| AIRBRUSH - CUP GUN | 20" - 30" Ford Cup 4 | 1,7 - 1,8 mm | 2 - 2.5 bar | HVLP/LVLP |

## CATALYSIS

| SERIES | HARDENER               | CATALYSIS           | USE                            | POT LIFE AT 20°C | PACKAGE      |
|--------|------------------------|---------------------|--------------------------------|------------------|--------------|
| 0929   | PUR ALIPHATIC HARDENER | 25% by volume (4:1) | Non-yellowing for exterior use | 20 minutes       | 0,25 l - 1 l |

## ENVIRONMENTAL CONDITIONS



ENVIRONMENT  
TEMPERATURE

5°C - 35°C



SUBSTRATE  
TEMPERATURE

5°C - 35°C



RELATIVE  
HUMIDITY

60 %



SHELF LIFE

Store 2 years in original sealed packaging at +5/+35°C.

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### TECHNICAL DATA



| THEORETICAL AVERAGE SPREADING RATE                              | APPLICATION | DILUTION                          | GLOSS | WET FILM THICKNESS EACH COAT | DRY FILM THICKNESS EACH COAT | N° OF COATS                                    | TOTAL DRY FILM THICKNESS | THEORETICAL AVERAGE CONSUMPTION |
|-----------------------------------------------------------------|-------------|-----------------------------------|-------|------------------------------|------------------------------|------------------------------------------------|--------------------------|---------------------------------|
| 9 m <sup>2</sup> /l each coat at the dry film thickness of 50 μ | Spray       | 5-10% with PUR Thinner Serie 0988 | -     | 110 μ                        | 50 μ                         | 2 coats to achieve the total desired thickness | 100 μ                    | 146 g/m <sup>2</sup>            |

### DRYING



| OVERCOATING INTERVAL                         | AIR DRYING | DUST-FREE DRYING | DRY TO TOUCH | DRY THROUGH | FULL CURE | FLASH OFF                                      | STOVING DRYING                                                  | RESISTANCE TO TEMPERATURE                             |
|----------------------------------------------|------------|------------------|--------------|-------------|-----------|------------------------------------------------|-----------------------------------------------------------------|-------------------------------------------------------|
| 1 - 24 hours (after it is necessary to sand) | 20°C       | 5 minutes        | 30 minutes   | 12 hours    | 4 days    | Before drying with hot forced air 5-10 minutes | 10 minutes at 60°C (after 10 minutes the product can be sanded) | 10 minutes at 60°C (later, the product can be sanded) |

### WARNINGS AND RECOMMENDATIONS

- Being an anticorrosive primer, if exposed outdoors or where a long maintenance of the initial characteristics is required, it is necessary to apply a suitable protective final coat.
- The use of nitro thinners for the application of polyurethane coating systems can create pitting phenomena on the surface of the dried film. Furthermore, the presence of partially reactive solvents can give rise to undesired reactions, reducing the aesthetic and mechanical features of the system. The choice of unsuitable regenerated thinners can create problems of color change, product sedimentation and less effectiveness in reducing viscosity.
- Shelf Life Component B: the shelf life of the hardener used with Component A is 12 months.
- Air drying takes place at 20°C and after one hour the product can be sanded.
- For galvanized steel and aluminum supports, they must be previously degreased, cleaned and treated with Epoxy Primer such as PRIMOZIN - GREY R7040 code 0770.N02870 hardened at 25% with Epox Slow Hardener Series 0918 (compliant with European Directive 2004/42/EC).
- On cataphoresis carry out a light sanding.
- In case of high temperatures, particularly critical humidity conditions and especially when coating large surfaces, due to the very fast drying of the product, issues of poor wettability of the support could arise. In these environmental situations, it is recommended to use the standard product Acrifiller Series 3400.

### SUPPLY TECHNICAL DATA

**Composition:** Modified acrylic  
**Reference color:** Grey Ral 7040  
**% solid content by weight:** 67 ± 2%  
**% solid content by volume:** 48 ± 2%  
**VOC:** 463 ± 2 g/l  
**VOS:** 32 ± 2%

| PARAMETER        | DATA                                       | TEST METHOD |
|------------------|--------------------------------------------|-------------|
| SPECIFIC GRAVITY | 1,4 - 1,5 g/ml                             | ISCOL 2     |
| VISCOSITY        | 4000 - 5500 mPa.s (20°C)<br>Rod 4 Speed 20 | ISCOL 1     |

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### MIXING RATIO A+B

|                                                             | METHOD        | 0929     |
|-------------------------------------------------------------|---------------|----------|
| Specific weight after catalysis (A+B): $1,31 \pm 0,05$ g/ml | A+B BY WEIGHT | 100 + 18 |
| % solid content by weight (A+B): $62 \pm 2\%$               |               |          |
| % solid content by volume (A+B): $45 \pm 2\%$               | A+B BY VOLUME | 100 + 25 |
| VOC (A+B): $493 \pm 2$ g/l                                  |               |          |
| VOS (A+B): $37 \pm 2\%$                                     |               |          |

### NOTES

**Cleaning tools:** At the end of the application, carefully wash the spray guns, the painting systems and the containers with a suitable thinner and store the tools dry to avoid encrustations.

**Sanitary labelling:** Handle the product with care. Make reference to the MSDS and respect the national and local regulations in force concerning personal and environmental safety.

**Additional notes:**

- The data reported in this data sheet have been obtained using only Franchi&Kim production materials (coatings, hardeners, thinners) applied in accordance with the specifications described. The improper use of thinners and/or hardeners, different from those suggested or not manufactured by Franchi & Kim, can compromise application features, performances and final curing of the product. Therefore, in case of mixed coating systems with Franchi & Kim and other brand products, the conformity of the results with the parameters indicated in the technical data sheet cannot be granted.
- The times related to pot life and drying intervals refer to a standard temperature of 20°C, except when it is expressly indicated.
- The spreading rates are theoretical, indicative and intended per coat as they can be influenced by the color and the application system. Practical application test is suggested.
- Pot Life times have been defined at the temperature of 20°C, therefore higher or lower temperatures, hardeners, environmental conditions and humidity different from the standard can influence in defect or in excess the duration of the Pot Life.

The information contained in this technical document is correct and accurate to the best of our knowledge, and should therefore be considered reliable. In any case, they cannot imply a guarantee on our part, as certain factors such as the preparation of the product and the substrate, the conditions of use, application, drying and overcoating, as well as the state of conservation of the products, are outside our strict control. It is responsibility of the user to verify the suitability of the products for the specific use, as well as the correct and precise execution of the work in accordance with the content of the technical data sheet, the recommended coating system and preparation of the support. For further information regarding the method of application and conditions of use, it is recommended to contact our technical support service. It should be noted that the packaging image could have a placeholder purpose and could therefore be an indicative reference. The packages indicated may vary according to the additions or changes of the annual price lists. This document replaces all previous versions. In any case, it is advisable to refer to the annexes with the explanatory notes to better understand and deepen the parameters of the technical data sheet. The updated edition, available on the website [www.franchi-kim.com](http://www.franchi-kim.com) in the section technical data sheets of the download area is to be considered the only ones to consult as reference.

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