

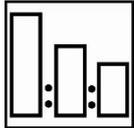
## 4+1 High Build Acrylic Filler

FOR PROFESSIONAL USE ONLY

### Description

Akripol 4+1 High Build Acrylic Filler is a 2 component acrylic filler designed for vehicle refinishes. It has high build and fast drying properties.

### Sanding version



4 Akripol 4+1 High Build Acrylic Filler  
1 Akripol 4+1 Acrylic Filler Hardener  
1 Akripol Universal Acrylic Thinners

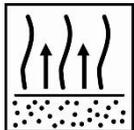


Spray gun set-up:  
1.6 – 1.8 mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLP max 0.6-0.7 bar at the air cap



2 – 3 coats



Between coats:  
5 - 10 minutes at 20°C

Before curing:  
5 - 10 minutes at 20°C



3 hours at 20°C

30 minutes at 60°C



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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### Product and Additives

	Akripol 4+1 High Build Acrylic Filler
<b>Hardener</b>	Akripol 4+1 Acrylic Filler Hardener Akripol 2K Hardener Extra Fast / Fast / Slow
<b>Thinner</b>	Akripol Universal Acrylic Thinner Fast / Slow

### Raw Materials

Akripol 4+1 High Build Acrylic Filler:	Acrylic Resins
Akripol 2K Hardener:	Polyisocyanate Resins

### Suitable Substrates

Existing finishes  
Steel  
Polyester surfaces  
Washprimer 1K CF  
Akripol Bodyfillers

### Substrate Preparation



**Substrate cleaning:** Before sanding, clean with suitable substrate cleaners to remove possible contaminations from the substrate. Wash the substrate with warm water and detergent beforehand and rinse thoroughly.



**Existing finishes:**  
Degrease and dry sand with P280 grit or wet sand with P400 grit.



**Polyester Putties:**  
Dry sand with P280.



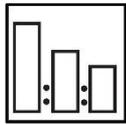
**Steel surfaces:**  
Degrease and dry sand with P120-220 grit.

**Substrate cleaning:** Before applying, clean the surface by using suitable surface cleaning thinner to remove possible impurities.

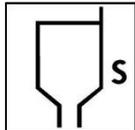
# 4+1 High Build Acrylic Filler

**FOR PROFESSIONAL USE ONLY****Mixing before application**

Stir Akripol 4+1 High Build Acrylic Filler until homogeneous before use.

**Mixing Ratio by Volume****Sanding version**

4 parts Akripol 4+1 High Build Acrylic Filler  
1 part Akripol 4+1 Acrylic Filler Hardener or Akripol 2K Hardener Extra Fast / Fast / Slow  
1 part Akripol Universal Acrylic Thinners

**Viscosity****Sanding version**

27 - 30 seconds at 20°C (DIN4)

**Spray gun fluid tip / Working pressure****Sanding version**

**Spray Gun**  
Gravity feed

**Fluid Tip**  
1.6-1.8 mm

**Application Pressure**

1.7 – 2.2 bar at spray gun the air inlet  
HVLP max. 0.6-0.7 bar at the air-cap

**Pot-life****Sanding version**

45 mins after mixing at 20°C with Akripol 4+1 Acrylic Filler Hardener

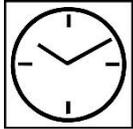
**Application process****Sanding version**

Apply 2-3 single coats, allowing for 5-10 minutes flash-off time between coats.

## 4+1 High Build Acrylic Filler

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### Drying time



	Dry sanding		Wet sanding	
	20°C	60°C	20°C	60°C
4+1 Acrylic Filler Hardener	3 hours	30 min.	2.5 hours	30 min.
Akripol 2K Hardener Fast	3,5 hours	30 min.	3 hours	30 min.

### Final sanding



Final sanding step P500



Final sanding step P1000



Remove contamination using an appropriate cleaner

### Recoatable with

AkzoNobel Kemipol basecoats and 2K topcoats.

### Color

Light Grey, White, Black

### Film thickness

~50 - 55 µm film per coat (sanding version)

### Theoretical material usage

Sanding version  
The theoretical material usage is 8.1 m<sup>2</sup>/l. at 50 µm (ready to spray mixture).

Note : The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

### Cleaning of equipment:

Akripol Super Cellulosic Thinner

# 4+1 High Build Acrylic Filler

**FOR PROFESSIONAL USE ONLY****Product storage**

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.



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**HEALTH & SAFETY DATA concerning 4+1 High Build Acrylic Filler and additives:**

For professional use only.(See Material Safety Data Sheet). See text on the label of this product. The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.

The effectiveness of our systems is based on laboratory research and many years' practical experience. We guarantee that the quality of the work performed according to our system meets the AKZONOBEL KEMİPOL A.Ş standards, provided that our instructions are carefully followed and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.

[www.akripol.com.tr](http://www.akripol.com.tr)

**AKZONOBEL KEMİPOL A.Ş. İzmir, TÜRKİYE**