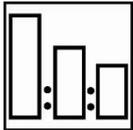


5+1 Filler

FOR PROFESSIONAL USE ONLY

Description

Akripol 5+1 Filler is a 2 component acrylic filler designed for car refinishes. It has very good sandability properties. It is a colored primer system consists of 3 different grey shades; Light Grey, Grey and Dark Grey, that are also intermixable.



5 Akripol 5+1 Filler
1 Akripol 2K Hardeners
1 Akripol Universal Acrylic Thinners

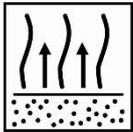


Spray gun set-up:
1.6 – 1.8 mm

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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Description

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Product and Additives

	Akripol 5+1 Filler
Hardener	Akripol 2K Hardener Extra Fast / Fast / Slow
Thinner	Akripol Universal Acrylic Thinner Fast / Slow

Raw Materials

Akripol 5+1 Filler:	Acrylic Resins
Akripol 2K Hardener:	Polyisocyanate Resins

Suitable Substrates

Existing finishes
Washprimer 1K CF
Steel
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 P220 or P320 grit



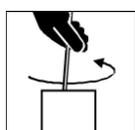
Polyester Putties:
Dry sand with P180 - P280 grit



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

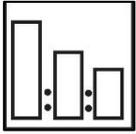
Substrate cleaning: Before applying, clean the surface by using suitable surface cleaning thinner to remove possible impurities.

Mixing before application

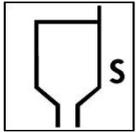


Stir Akripol 5+1 Filler until homogeneous before use.

5+1 Filler

FOR PROFESSIONAL USE ONLY**Mixing ratio by volume**

5 parts of Akripol 5+1 Filler
1 part of Akripol 2K Hardeners
1 part of Akripol Universal Acrylic Thinners

Viscosity

20 – 24 seconds at 20°C (DIN 4)

Spray gun setup / Application pressure

Spray Gun
Gravity feed

Fluid Tip
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

Application process

Apply 2-3 full coats, flash-off 5-10 minutes between coats.

Pot life

90 mins after mixing at 20°C with Akripol 2K Hardener Fast

Film thickness

~50 µm film per coat.

Theoretical material usage

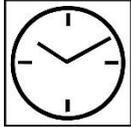
10 m²/l for 60 µm film thickness (ready to spray mixture)

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

5+1 Filler

FOR PROFESSIONAL USE ONLY

Drying time



	<u>20°C</u>	<u>60°C</u>
Akripol 2K Hardener Fast	4 hours	30 min.
Akripol 2K Hardener Extra Fast	3 hours	30 min.



Give 5 minutes flash-off time before infrared drying.
The panel temperature should not exceed 100°C during drying.

Final sanding step



Final sanding step P500 (dry)

- *The first sanding steps can be done with the coarser sanding paper P360-P400.*
- *Follow the maximum 100 steps rule when choosing the sanding paper.*



Final sanding step P1000 (wet)

- *The first sanding steps can be done with the coarser sanding paper P600-P800.*
- *When choosing the sanding paper, make sure that there is a maximum difference of 200.*

In case of wet sanding, wait 30 minutes at 20°C before applying the topcoat.



Surface cleaning

Before the topcoat application, the surface should be cleaned using cleaning thinners.

See applied topcoat technical data sheet for more details.

Recoatable with

All AkzoNobel Kemipol basecoats and 2K topcoats.

Color

Light Grey, Grey, Dark Grey

Cleaning of equipment:

Akripol Super Cellulosic Thinner

5+1 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 Akripol 5+1 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

AKZONOBEL KEMİPOL A.Ş. İzmir, TÜRKİYE