



AC01

0001

Polyurethane paints

1K-Acrylic Primer

Trade name / Product code	AC01 / 0001
Material base	Polyacrylic resin
Glossiness level	Matte
Thinner	AR10 / AR20 ; alternatively SR05
Processing data	<p>Air spraying</p> <p>Thinner: AR20, AR10</p> <p>Application viscosity: 20 to 40 s / 4 mm cup DIN / 20 °C</p> <p>Jet: 1.3 - 1.6 mm</p> <p>Pressure: 3 - 5 bar</p> <p>Airless / airmix spraying</p> <p>Thinner: AR20, AR10</p> <p>Application viscosity: 20 to 80 s / 4 mm cup DIN / 20 °C</p> <p>Jet: 0.28 - 0.33 mm airless / E311, E411 airmix</p> <p>Pressure: 120 - 150 bar airless 80 - 120 bar / 1.8 - 2.2 bar airmix</p> <p>Roller, brush</p> <p>Thinner: AR20</p> <p>Application viscosity: 20 to 80 s / 4 mm cup DIN / 20 °C</p>
Processing	<p>The minimum temperature of the paint before processing should be 10 - 25 °C!</p> <p>Mix the paint thoroughly after opening the package. Thin the paint to the viscosity value needed for the specific application with thinner AR10 or AR20. Mix slowly to avoid admixing air with the paint and bubble formation.</p>
Drying times at 20 °C Wet thickness 50 µm	<p>Dustproof / 20 °C: 20 minutes</p> <p>Touch dry / non-sticking / 20 °C: 40 minutes</p> <p>Recoatable / 20 °C: 30 – 60 minutes</p> <p>Workable / 20 °C: 4 hours</p> <p>The rate of cure and the time of achieving the final properties vary depending on the climatic conditions and coat film thickness.</p> <p>Additional drying: after solvents have vaporized away (approx. 20 - 30 minutes after application).</p> <p>Additional drying temperature: max. 60 °C.</p>
Technical data	<p>Colours: 0100, 0110, 0840, RAL as agreed</p> <p>Supplier viscosity, 20 °C: thixotropic</p> <p>Density, paint, 20 °C: 1.40 to 1.60 g/cm³ depending on colour</p> <p>Dry matter content, paint: approx. 71 % by weight approx. 55 % by volume</p> <p>VOC content, paint: approx. 290 g/kg approx. 430 g/l</p> <p>Total organic carbon TOC content: 260 g/kg</p> <p>Theoretical spreading rate:</p> <p>Dry film thickness 40 µm 7 to 9 m²/kg</p> <p>Consumption depends on object shape, surface roughness, and application technique and conditions.</p>
Maximum thinning to 500 g	110 g AR10 per kg of paint.



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VOC in 1 l of processed and thinned mix

To Regulation No. 415/2012 Coll.

Application data

Application conditions

Air temperature:	+10 to +25 °C
Paint temperature:	+10 to +25 °C
Object surface temperature:	min. 10 °C min. 3 °C above dew point
Relative humidity of air:	max. 70 %
Number of coats:	1 - 2
Wet film thickness:	min. 75 µm recommended: 100 - 125 µm
Dry film thickness:	min. 40 µm recommended: 60 µm

The thickness of a coat applied in a single working step on a vertical surface depends on object shape, surface roughness, and application conditions.

Overcoatability: The paint can be overcoated with the same paint or a suitable top paint.

Second paint coat can be applied "wet on wet" after 30 - 60 minutes of spraying the first coat.

If exposed to the effects of polluted environment, the surface should be cleaned thoroughly before next coat application, at best by rinsing with high-pressure clean water, and let dry up.

The maximum period of overcoatability with a top coat is 30 - 50 days; after that, a new prime coat has to be applied in a dry film thickness of 30 - 40 µm.

Application

Prime coats of metal products including hot-dip galvanized ones (such as structures, containers, machine guards, lighting poles, door frames, or metal pallets). It provides excellent corrosion resistance and first-class adhesion to the substrate. . It is suitable as a primer overcoatable with a wide range of 2K and 1K synthetic top coats.

Surface preparation Steel

Any grease, scale, old coats, corrosion products and dust have to be removed thoroughly from the metal surface at least to St 3 or Sa 2 to 2½. This method of surface preparation allows achieving the optimum anticorrosive properties of the coats. Problematic spots such as edges, welds, joints, etc. should be pre-treated by strip coating with a brush or a roller. Paint application should be started within 6 hours of blasting at the latest to avoid flash corrosion occurrence!

Surface preparation Hot-dip galvanized steel

Any mechanical dirt has to be removed from hot-dip galvanized steel surfaces (areas) before coating and the surface degreased thoroughly by rinsing with water and suitable detergent. Using warm water is preferable.

It is recommended to make a test of suitability for the particular application purposes.

Utility properties

The coating system is suitable for the normal atmospheric load. The cured coat is resistant to abrasion.

Cross-cut test (steel): degree 0 to 1

Temperature resistance:

Long term:	90 °C
Short term (max. 60 minutes, dry):	120 °C

For more details please contact our technical department.



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Cleaning and maintenance	The mixing and application tools should be cleaned as soon as possible with thinner C6000 or AR10, AR20, SR05.	
Packages	1 kg to 200 kg metal packages as agreed.	
Shelf life	24 months from the date of manufacture if kept in the original closed packages in a dry room, out of direct sunlight and at a temperature from +5 to +30 °C. The storage areas should meet all the conditions for storage of hazard class II combustibles.	
Documentation	Material Safety Data Sheet Product certificate Declaration of Conformity	Construction-technical certificate Certification Result Protocol
Waste disposal	Coating composition N 08 01 11 Waste paints Empty packages N 15 01 10 Packages containing residues of hazardous substances	
Disclaimer	<p>The product data provided in this Technical Application Guide results from the current level of production, laboratory and application tests. The manufacturer reserves the right to make revisions according to the state of development. As the product is used frequently beyond our control, we cannot guarantee anything else than the quality of the product as such. We are not liable for any mistakes occurring due to wrong application, application past the shelf life or improper storage.</p> <p>This document only provides non-binding information that has to be concretized by the end user for the specific product type. On no account this document supersedes the identification data of this product specified in the material safety data sheet.</p>	
Date of issue	31.5.2015	
Revision date	31.5.2015	

Before starting works with this product, ALWAYS read thoroughly the relevant material safety data sheet and the material safety data sheet of the applicable thinner! Observe the safe handling and occupational safety instructions. The product is a hazard class II combustible liquid. For more detailed information please contact our technical department.