Technical Data Sheet

Properties:

AKEMI® Mammut 200 is a 2-component UHS-primer/filler with a high solid content.

The product is characterized by the following properties:
- excellent high build up (up to 200 µ in one layer)
- very fast drying
- very easy to sand
- flexible
- can be applied as a wet-on-wet surfacer by simple adjustment of the thinning ratio
- undamaged new components and factory primers do not require sanding
- excellent colour matching of the topcoat even with clear pigments

Application Area:

Mainly in the body repair for spot repairs to full panel applications and formulated to give a high adhesion on sanded etch primer and epoxy primer coatings, polyester body fillers, bare metal and galvanized steel, primed plastics and for wood and fibreglass applications.

Instructions for use:

1. The surface to be coated must be dry, clean, free of corrosion and grease as well as release agent residues.

2. Degrease with AKEMI® Eco Degreaser and before applying the primer clean slightly once more with AKEMI® Eco Degreaser.

3. Pretreatment

Old paintwork:	Orbital sanding by max. 5 mm orbit or hand sanding using P320 or finer.
Galvanised steel sheet and aluminium:	Orbital sanding by max. 5 mm orbit using P240 - P320 or finer.
Bare steel:	Orbital sanding by max. 5 mm orbit using P240 - P320 or finer. AKEMI® Epoxy Primer must be applied where optimum adhesion and corrosion resistance is required.
GRP or fibreglass:	Orbital sanding with P240 - P320 or finer, ideally with afin® Foam Disc fine.
Body fillers:	Orbital sanding by max. 5 mm orbit using P120 or P180. For sanding surrounding area use P240 or finer.
Factory primer/ E-coat:	Sanding of intact e-coated parts is not necessary. For sanding out surface damages or defects use afin® Foam Disc or afin® 2S Sanding Pad fine or super fine.

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4. Mixing ratio

- **Volume**

100 parts by volume	Mammut 200
25 parts by volume	Hardener

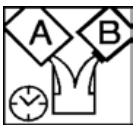
• High-build application 5 - 20 %	AKEMI® Acrylic Thinner normal, extra addition of 5% AKEMI® Active Thinner
• Nozzle size:	5% AKEMI® Acrylic Thinner: 2.5 mm 20% AKEM®I Acrylic Thinner: 1.8 mm 25% AKEMI® Acrylic Thinner: 1.6 mm
• Wet-on-wet apply:	45% AKEMI® Acrylic Thinner normal
• Nozzle size:	1.3 mm

- **Weight**

150 parts by weight	Mammut 200
25 parts by weight	Hardener

• High-build application: 5 - 20 parts by weight	AKEMI® Acrylic Thinner normal or AKEMI® Active Thinner
• Wet-on-wet apply:	45 parts AKEMI® Acrylic Thinner normal

5. Mix thoroughly in a suitable mixing cup.



6. Pot life
30 minutes at 20°C / 65% RH (using AKEMI® Acrylic Thinner normal)
15 minutes at 20°C / 65% RH (using AKEMI® Active Thinner)

7. Gun setups and air pressure

Compliant	Nozzle size	Spray pressure
HVLP	1.3 - 2.5 mm	1.8 – 2.2 bar (air pressure)* 0.7 bar (atomizing pressure)*

* Follow the recommendation of the spray gun manufacturers

8. 1 - 3 layers

Apply a light coat followed by full-wet coats.

9. Flash off
Approx. 10 minutes between layers (depending on temperature, applied layer thickness and used thinner).

10. Wet-on-wet application before base coat apply:
flash off 15 minutes at 20°C
or forced 10 minutes at 40°C

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11. Final drying:

• Object temperature 60°C	10 minutes
• Room temperature 20°C	
AKEMI® Acrylic Thinner normal	4 hours
AKEMI® Active Thinner	1 hour
• Wet-on-wet apply:	
Wet-on-wet 20°C	15 minutes
Wet-on-wet forced	10 minutes

12. Sandable: with P400

with AKEMI® Acrylic Thinner normal	
at 60°C	10 minutes
at 20°C	60 minutes
with AKEMI® Acrylic Thinner normal or AKEMI® Active Thinner	45 minutes
Final sanding for delicated colours	with P600 - P800

13. Recoating — Can be overpainted with all water- or solvent bases or full-tone colours.

Special Notes:

- For professional use only.
- Final drying time must be observed before overpainting.
- For proper waste disposal, the container must be completely emptied.
- Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

Technical Data:

Base:	isocyanate-curing polymer
Solid content:	approx. 73% (primer)
Density at 20°C:	approx. 1.5 g/cm³ (primer)
	approx. 1.4 g/cm³ (mixture)
Recommended dry layer thickness:	100 - 200 µm
VOC:	< 480 g/l

Storage:

If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 12 months from production (primer and hardener).

Health & Safety:

Read Safety Data Sheet before handling or using this product.

Important Notice:

The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information - as well as other oral or written technical advises - must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trails of the product, in an inconspicuous area or fabrication of a sample piece.

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