Technical Data Sheet

Properties:

AKEMI® 2K Epoxy Primer is a VOC compliant, high build zinc phosphate primer. The product is characterized by the following properties:

- developed in accordance with ZTV-KOR steel construction
- very good anti-corrosion properties
- resistant to diluted acids and alkalis

Application Area:

AKEMI® 2K Epoxy Primer is mainly used in the vehicle, mechanical engineering and steel construction and wherever high requirements are demanded on corrosion protection. Applicable for car refinish repair, trailers and vans. Excellently suitable as a primer before apply of body fillers or polyester spray putties, for restoration work as well as for new parts and refinish. Can be used on a variety of materials such as:
- existing paint layers including thermoplastic acrylic paint
- sheet steel
- zinc coated steel
- stainless steel
- non-ferrous metals (aluminum, copper, zinc, brass)
- polyester laminate
- wood or plywood
- AKEMI® polyester body fillers or polyester spray putties

Instructions for Use:

1. The surface to be coated must be dry, clean, free of corrosion mill scale, grease and loose surface particles and any other foreign materials or contaminants.
2. Removal of not sustainable coatings.
3. Precleaning with an appropriate cleaner, e.g. afin® Acryclean.
4. To ensure complete adhesion sanding the sustainable surface with P180 – P240.
5. Sanding of steel, zinc coated steel, stainless steel and non-ferrous metals with P180 – P240.
6. Before primer apply thoroughly clean with an appropriate cleaner, e.g. afin® Acryclean.
7. Mixing ratio for normal coating thickness:
   100 : 15 in weight
   4 : 1 in volume
   Potlife 6 h at 20°C

   Can be thinned 5 – 10% with:

Thinner AP	for large-area applications or spray temperature above 23°C
Thinner AP-R	for normal applications or spray temperature below 23°C
Thinner TF	for spot applications or if forced drying required. Note: will reduce the potlife

8. Nozzle size: 1.5 – 1.8 mm
   Air pressure: 2 – 4 bar*
   * Note advises of the spray gun manufacturer.
9. Processing viscosity according to DIN 53211/4 mm at 20°C:
   20 – 22 sec
10. 2 to 3 layers apply.

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11. Drying properties at 80 µm dry film thickness:
    - 20°C air drying: dust-dry after approx. 30 min; recoatable after approx. 60 – 90 min; hard dry after approx. 3 – 4 h
    - 60°C oven drying: hard dry after 30 min
12. Final dry sanding with P500.

Technical Data:

Colour:	light grey
Gloss level:	matt
Solid content:	69 +/-% in weight (of the mixture)
Delivery viscosity of the base component:	27 – 30 sec at 20°C room temperature according to DIN 53211
Solid volume:	49 +/- 4% (of the mixture)
Density:	1.45 +/- 0.15 g/cm³ (of the mixture)
Recommended thickness:	80 µm dry film thickness (about ≈ 165 µm wet film thickness)
Theoretical coverage:	4.0 – 4.3 m²/kg at 80 µm dry film thickness
VOC:	440 +/- 25 g/l (of the mixture)

Storage: If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 12 months (primer) and 6 months (hardener) from production.

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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