

1K Etch Primer

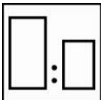
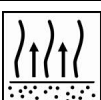
Adhesion Primers

06/11/2019

L2.03.02 UK & Ireland

DESCRIPTION

Chromate free, etching primer surfacer for general use in refinishing cars and also light commercial vehicles.

Mixing ratio		2 1	1K Etch Primer Multi Thinner
Mixing stick		D	
Equipment		Spray gun set up: 1.2-1.6 mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		1-2 x 1 coat	
Flash-off		Between coats 5-7 minutes at 20°C	Recoat between 15 minutes and 24 hours at 20°C
Recoatability		2K HS Primer Filler 2K Filler 540 2K Graphite Filler	2K High Build Filler 1K Primer Filler (RTS) Topcoat HS 420
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

Product 1K Etch Primer

Thinner Multi Thinner Fast
Multi Thinner Standard
Multi Thinner HT

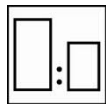
Chemical Basis	1K Etch Primer Multi Thinner	Polyvinyl butyral A blend of organic solvents
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METHOD OF USE

Substrates Steel
Zinc coated steel
Aluminium

Substrate preparation Steel: Sand with P180-P280 grit dry
Zinc coated steel: Abrade with Scotch Brite 447 Red
Aluminium: Abrade with Scotch Brite 447 Red

Mixing ratio



2 1K Etch Primer
1 Multi Thinner

Mixing stick D

Spraying viscosity 16 - 18 sec. DIN Cup 4 at 20°C

Potlife After mixing, use within 6 months at 20°C

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Spray gun set up



Spray gun:
HVLP Gravity
LVLP/HR Gravity

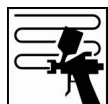
Fluid opening:
1.2-1.6 mm
1.2-1.6 mm

Spraying pressure:
0.7 bar (at air cap)
1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application



Apply one or two single coats.

Minimum application temperature: 15°C
Maximum relative humidity: 75%

Equipment cleaning

Use Multi Thinners or nitro cellulose thinner

Drying



Recoat after
15 minutes at 20°C

Recoat within
24 hours at 20°C

Layer thickness

6 – 12 microns

Material usage

Ready for use mixture at 1 µm layer thickness :

40 m²/liter

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

Recoatability

2K HS Primer Filler
2K Filler 540
2K Graphite Filler

2K High Build Filler
1K Primer Filler (RTS)
1K Primer WB

Topcoat HS 420
2K Topcoat

Product storage

Avoid extreme temperature fluctuation and high humidity levels

Shelf life

2 years at 20°C

VOC

2004/42/II B(c)(780)760

The EU limit value for this product (product category : IIB.c) in ready to use form is max. 780 g/l VOC.

The VOC content of this product in ready to use form is max. 760 g/litre.

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FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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