

**Technical Data Sheet**

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- Properties:** AKEMI® 1K Epoxy Primer is an all-purpose primer.
- The product is characterized by the following properties:
- best adhesion and corrosion prevention on steel, zinc-coated steel, aluminium and GRP
  - good flow
  - fast drying
  - can be painted over with water-based and solvent-based systems
  - suitable for use "wet-on-wet"
  - offers good isolation against humidity
- Application Area:** Suitable as an adhesion and corrosion prevention primer for spot and smart repair applications on cleaned and abraded surfaces of steel, galvanized steel, aluminium, fiberglass, old paintworks and on plastic parts after treated with an adhesion promoter.
- Instructions for Use:**
1. Ensure the surface to be primed is completely clean, free of grease and dry.
  2. Remove all rust from metal surfaces.
  3. For best adhesion results abrade with grit P80 to P400, depending on the surface.
  4. Shake the can well for approximately 2 minutes.
  5. Carry out test spraying and adapt the nozzle.
  6. Apply 1 to 2 even coats from a distance of approx. 25 cm.
  7. Allow 3 to 5 minutes flash off between the coats.
  8. Drying time depends on layer thickness, humidity and ambient temperature approx. 12 to 15 minutes (air drying) and 8 to 10 minutes (IR).
- Special Notes:**
- For professional use only.
  - 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:**
- |                         |   |
|-------------------------|---|
| Basis of binder:        | epoxy resin                                   |
| Colour:                 | grey  |
| Efficiency:             | 1 m <sup>2</sup>                              |
| Covering thickness:     | 20 - 30 µ in 1 to 2 layers                    |
| Density:                | approx. 0.84 g/cm <sup>3</sup>                |
| Temperature resistance: | up to 90°C                                    |
| Paintable:              | 12 - 15 minutes (20°C)<br>8 - 10 minutes (IR) |
| VOC:                    | 274.5 g/l                                     |
- Storage:** If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 60 months from production.
- Health & Safety:** Read Safety Data Sheet before handling or using this product.

TDS 11.25

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**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 trials of the product, in an inconspicuous area or fabrication of a sample piece.