

# 302 PRM-AKD

## 1K Alkyd Primer Filler

Resin base: 1-component alkyd resin

### Technical Information 5.3.1

<b>Products needed:</b>	Pastes GJ50- Converter GK11-1302 Converter/Pastes 90 : 10 Thinner SV12-0360 Nitro SV13-0732 Fast SV13-0701 Medium		
<b>Application and properties:</b>	<b>1K Alkyd Primer Filler</b> <ul style="list-style-type: none"> <li>• good leveling</li> <li>• good sagging resistance</li> <li>• many different colors possible</li> <li>• good corrosion protection</li> <li>• min. ambient temp. +15°C for application</li> </ul>		
<b>Substrates/Pre-treatment:</b> Well-cured old paintwork Bare steel Glass-fibre reinforced plastics	<b>Cleaning</b> SV20-0505 SV22-0500 SV20-0530	<b>Sanding</b> P240-360 P80-150 P240-360	<b>Final cleaning</b> SV20-0505 SV22-0500 SV20-0530 * Other substrates could be possible. Please refer to matrix 3.9
<b>Can be overcoated with:</b>	TPC-AKD, TPC-ACR, TPC-PUR, TPC-EPX		
<b>Product details:</b>	Not suitable for use under polyester body filler. Remove corrosion (e.g., rust) by fine sanding or blasting before applying the product.		
<b>Special Remark:</b>	It cannot be ruled out that this product contains particles < 0.1 µm. The products are suitable for professional use only.		

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











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**Application:** 1K Primer Filler

**Remarks:** Values reg. VOC, coverage, solid content and viscosity are based on a mixing ratio by Vol.  
Select thinner acc. ambient temperature and size of object to be painted.

	Paint system	302 PRM-AKD 1K Primer Filler				
	VOC	Theor. Coverage at 1 µm (RAL3000/9010)		Solid Content		
	563-576 g/l	326/314 m²/kg		375/373 m²/L	49-53 % Gew.	
	Mixing ratio	302 PRM-AKD	100 % by weight		2 Vol.	
	Hardener	-				
	Thinner	SV12-0360 SV13-0732 SV13-0701	40 % by weight		1 Vol.	
	Viscosity at 23°C DIN 4		Film Thickness (DFT)		Potlife 20°C	Gloss at 60°
	2:1 Vol. 13-15 sec. 3:1 Vol. 15-17 sec. 4:1 Vol. 25-35 sec.		40-60 µm (2-3 coats) flash off 5-10 min. between		-	matt
	Application		Viscosity (sec)	Mixing ratio	Spraying Pressure (bar)	Nozzle (mm)
	Compliant Gun		13-15	2:1	< 2.5	1.6-1.8
	HVLP		13-15	2:1	~ 2	1.6-1.9
	Suction Cup		13-15	2:1	2-3	1.6-1.9
	Airless / Airmix		25-35	4:1	120-150	0.28-0.33
	Double Diaphragm or Pressure Pump		15-17	3:1	< 4	1.0
	Brush & Roll		with less thinner; only brush application possible			
	Drying at Object Temp.		dust-dry	Flash Off (wet-on-wet)	Touch Dry	Recoatable
	20°C		10 min	1 h	1 h	max. 72 h
	60°C		-	30 min	30 min	-