

1K Etch Primer

LESONAL

Technical Data Sheet

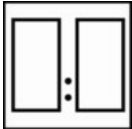
29 / 10 / 2018

L2.03.02 UK & Ireland

Adhesion Primers

Description

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



2 1K Etch Primer
1 Multi Thinner



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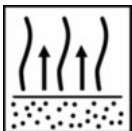
Spray gun set-up:
1.2-1.6 mm

Application pressure:
1.7-2.2 bar*

*Refer to spraygun used



1-2 x 1 coat



Flash off between coats:
5 – 7 minutes (20°C)

Recoatibility between:
15 minutes and 24 hours 20°C



Recoatible with:

2K HS Primer Filler,
2K Filler 540
2K Graphite Filler
2K High Build Filler

1K Primer Filler (RTS)

Topcoat HS 420



Use suitable respiratory protection

Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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Description

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

Product & ancillary items**Product** 1K Etch Primer**Thinners** Multi Thinner Fast For faster flash off times on smaller repairs, or in cooler or less well-ventilated conditions
Multi Thinner Standard For use on larger repairs, or in warmer conditions.**Chemical Basis** 1K Etch Primer – Polyvinyl butyral
Multi Thinner – A blend of organic solvents**Method of use****Substrates** Steel
Zinc coated steel
Aluminium**Substrate preparation** Prior to commencing any sanding work, thoroughly cleanse the surface with Lesonal Degreaser.

Steel – remove all traces of rust and abrade thoroughly until a clean surface is achieved. Any mill scale should be removed by shot blasting.
Zinc coated steel - abrade thoroughly with Scotch Brite 447 (Red).
Aluminium - abrade thoroughly with Scotch Brite 447 (Red).
After sanding work is completed and just prior to the application of 1K Etch Primer, again degrease thoroughly with Lesonal Degreaser.

Mixing Ratio 2 volumes – 1K Etch Primer
Mixing stick D 1 volume – Multi Thinner**Spraying Viscosity** 16 - 18 sec. DIN Cup 4 at 20° C.**Pot life** After mixing, use within 6 months at 20°C.

Spraying pressure:*	Spraygun	Fluid opening	Spraying pressure
	HVLP Gravity	1.2 – 1.6 mm	0.7 bar (at aircap)
	LVLP (HR) Gravity	1.2 – 1.6 mm	2 - 3 bar (at inlet)
	Gravity feed	1.2 – 1.6 mm	3-4 bar

* Refer to spraygun used

Application : Apply one or two single coats.
At a minimum of 15°C**Flash off** 5 – 7 minutes between layers

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Layer Thickness	6 – 12 microns		
Theoretical use per Ltr/m²	40 m ² /liter at a layer thickness of 1 micron (the practical material usage depends on many factors, i.e. shape of the object, roughness of the surface, application method and application circumstances)		
Cleaning Equipment	Use nitrocellulose thinner.		
Drying Times	Minimum	15 min. at 20° C	
	Maximum	24 hrs. 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
Helpful tips	Do not apply the product in a relative humidity greater than 75 %, or if the substrate is at dew point i.e. condensation has formed on the surface. Wait until conditions improve and the surface has dried out.		
Color	Green		
Shelf life	1 year		
VOC	2004/42/IIB(c)(780)760 The EU limit value for this product (product category: IIB.c) in ready to use form is max. 780 g/liter VOC. The VOC content of this product in ready to use form is max. 760 g/liter.		

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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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