

Technical Data Sheet  
**AK PRIMER 330**  
Alkyd primer fast-drying

**RELATED PRODUCTS**

**THIN 50**



Universal solvent, slow, standard, fast





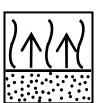
**USE**

- Alkyd Primer fast-drying is a free air-drying product. The primer is perfect as a base coat for steel and cast iron. The product exhibits good adhesion and mechanical resistance.

**PROPERTIES**

- Active anti-corrosion pigments: durable coating for years
  - Chemical resistance

| <b>SUBSTRATES</b>  |                                  |  |                |              |
|--|----------------------------------|--|----------------|--------------|
| Steel and cast iron  |                                  | The steel/cast iron substrate shall be dry and free of oils, grease, dust, loose old coatings, milling scale, loose rust and foreign bodies. The surface shall exhibit bare metallic gloss. Mat smooth and shining metallic surfaces with P120 sand paper to produce sufficient substrate roughness. |                |              |
| Old coatings   |                                  | Mat and degrease.<br>Test coat a small area of the old coating. If the dry coat finish is unsatisfactory, remove the old coating completely and pretreat the substrate as instructed above.  |                |              |
| Note: Dry sanding generates dust. Proper respiratory protection is recommended.  |                                  |  |                |              |
| <b>MIXING RATIO</b>  |                                  |  |                |              |
|   | Coating method                   | Product  | Volume ratio   | Weight ratio |
|  | Rollers or brushes               | AK PRIMER 330<br>Universal solvent THIN 50   | 100<br>0 ÷ 5%  | 100<br>0 ÷ 4 |
|  | Pneumatic spraying               | AK PRIMER 330<br>Universal solvent THIN 50   | 100<br>0 ÷ 10% | 100<br>0 ÷ 8 |
|  | Airless spraying                 | AK PRIMER 330<br>Universal solvent THIN 50   | 100<br>0 ÷ 5%  | 100<br>0 ÷ 4 |
| <b>VISCOSITY</b>   |                                  |  |                |              |
|   | DIN 4/20°C<br>Pneumatic spraying | 22 - 24 s  |                |              |
| <b>COLOURS</b>   |                                  |  |                |              |
| Grey   |                                  |  |                |              |
| <b>VOC CONTENT</b>   |                                  |  |                |              |
| VOC II/A/i limit*  |                                  | 500 g/l  |                |              |
| Actual VOC content   |                                  | 490 g/l  |                |              |
| * For ready to apply mixture acc. to EU Directive 2004/42/EC   |                                  |  |                |              |
| <b>APPLICATION CONDITIONS</b>  |                                  |  |                |              |
| <ul style="list-style-type: none"> <li>- The substrate shall be dry.</li> <li>- Min. product temperature: +10°C.</li> <li>- The coat, coated surface and ambient temperatures must be between +5°C and +30°C.</li> <li>- The relative humidity must not exceed 80%.</li> <li>- Do not coat at high humidity (e.g. when rain, snow or fog is forecasted), on hot afternoons and/or in strong wind.</li> </ul> <p>The application conditions determine the product layer drying time and the developed coating properties. The substrate temperature shall be 3°C higher than the ambient dew point or more.</p> |                                  |  |                |              |

| APPLICATION  |  |   |                                      |            |
|--|--|---|--------------------------------------|------------|
| <br><b>CAUTION:</b> Follow the equipment manufacturer's guidelines  |  | Nozzle  | Pressure                             | Distance   |
|  | Pneumatic spraying   | 1.3 - 1.5 mm  | 2 - 4 bar                            | 15 - 20 cm |
|  | Airless spraying in air jacket   | 0.28 - 0.33 mm (0.011" - 0.013")  | 100 - 120 bar<br>Air jacket<br>2 bar | 10 - 15 cm |
|   | Brush  | Natural bristle brushes or natural and synthetic bristle brushes are recommended.           |                                      |            |
|   | Roller   | Velour and mohair rollers are recommended.  |                                      |            |
| <p>The spray application parameters depend on the individual performance and requirements of the tool and must be tested prior to coating.</p> <p><b>Caution!</b><br/>           Verify that all corners and edges have been properly coated.<br/>           Depending on the roller type, the coating may contain air bubbles which burst and form craters during drying.</p> |  |   |                                      |            |
|   | Recommended number of layers   | 1 - 2<br>Apply in more layers on complex shapes to produce a homogeneous coating thickness. |                                      |            |
|  | Overall wet layer thickness  | 85 - 115 µm   |                                      |            |
|  | Overall dry layer thickness  | 45 - 70 µm  |                                      |            |
|  | The yield of the ready to use mixture for the given range of dry layer thickness | 14 m <sup>2</sup> /l<br>at 40 µm  |                                      |            |
|   | Flash-off time between layers  | Recoat in 1 - 5 h<br>or after 7 days  |                                      |            |
|  | Time to recoat (with the enamel)   | Recoat in 1 - 5 h<br>or after 7 days  |                                      |            |
| COATABILITY:   |  |   |                                      |            |
| Alkyd, polyvinyl, and chlorinated rubber enamel coats.   |  |   |                                      |            |
| TECHNICAL DATA   |  |   |                                      |            |
| Solids content by weight   |  | 60 - 63%  |                                      |            |
| Solids content by volume   |  | 57 - 60%  |                                      |            |
| Density  |  | 1.4 - 1.5 g/cm <sup>3</sup>   |                                      |            |
| Gloss (at 60°), PN-EN ISO 2813   |  | ≤10   |                                      |            |
| Adhesion, PN-EN ISO 2409   |  | 0 - 1   |                                      |            |
| Water resistance, PN-EN ISO 2812-2   |  | intermittent, not resistant to permanent submersion   |                                      |            |

|  |                                    |            |
|--|------------------------------------|------------|
| Chemical resistance  | intermittent (splashes and sprays) |            |
| <b>DRY LEVELS</b>  |                                    |            |
|  | PN-C 81519                         | Time       |
| Dust-free  | Level 1                            | 15 minutes |
| Tack-free  | Level 3                            | 30 minutes |
| Ending hardness  | Level 6                            | 2 hours    |
| CAUTION: The drying time may vary with temperature and/or humidity.  |                                    |            |
| <b>EQUIPMENT CLEANING</b>  |                                    |            |
| Universal thinner THIN 50 or NC solvent  |                                    |            |
| <b>STORAGE CONDITIONS</b>  |                                    |            |
| Store in a dry and cool room, away from sources of fire and heat at 5°C-25°C. Avoid exposure to sunlight.  |                                    |            |
| <b>SHELF LIFE</b>  |                                    |            |
| AK Primer 330  | 12 months/20°C                     |            |
| Universal solvent THIN 50  | 24 months/20°C                     |            |
| <b>SAFETY</b>  |                                    |            |
| See the Safety Data Sheet.   |                                    |            |
| <b>OTHER INFORMATION</b>   |                                    |            |
| Registration number: 000024104.  |                                    |            |
| <p>The effectiveness of our systems results from laboratory research and many years of experience. The data contained here in meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.</p> |                                    |            |