

SPECIFICATIONS

Prepared on:
March 22, 2005



Updated on:
December 21, 2007

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Product name: APP 1K Haftgrund

Unary, chromate-free, quick-drying reactive primer, which guarantees excellent anti-corrosive protection and very good adhesion. Zinc-free. The product has weldability certificate DVS 0501 no. 275/670/99/925.

Container: 1.00 l, aerosol - 400 ml.

Product and additives: APP 1K Haftgrund;
APP 2K Verdunnung AVS.

Colour: Red and brown.

Output: 6-8 m²/l.

Caution!

In practice the output depends on certain factors including: object shape, roughness of the base, method of application and working conditions.

Usage:
elements The product is intended for active anti-corrosive protection of the body of motor cars, delivery vans, trucks, and buses.

Base

Proper base types: Iron, steel, zinc-coated steel sheet, aluminium.
Polished transition lines of factory-made coats and polyester filler layers.
Caution!
Do not apply onto surfaces covered with thermoplastic lacquer (T.P.A.).

Base preparation:



Thoroughly remove all possible corrosion centres and polish dry using P240-P320 abrasive paper.
Smooth down all lines of transition to the old lacquer coat and polyester filler layers.



Before spraying the primer, remove any dust from the treated surface and degrease it using W900 remover.

The above information complies with current knowledge on our products and their possible applications. This guarantees no specific properties or usability in particular conditions. Users should observe guidelines and warnings provided on product labels and specified in material safety data sheets. We hold no responsibility if conditions beyond our control affect the final result of work.

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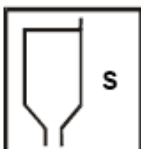
Product name: APP 1K Haftgrund

Application

Mixing ratio(s):



Add up to 50% of the APP 2K Verdunnung AVS thinner in order to obtain the proper spraying viscosity.



Spraying viscosity at +20°C: 18-22 s 4mm DIN.

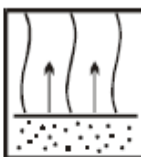
Applying:



Apply using a spray gun equipped with a ϕ 1.3- ϕ 1.5 mm nozzle at an air pressure ranging from 3.0 to 4.0 bar.



Number of layers: 1-2.
Dry coat thickness: 10-15 μ m.
Recommended working conditions:
- minimum temperature: +10°C;
- maximum relative humidity: 80%.



Evaporation time between successive layers at the temperature of +20°C: 10 minutes.

Drying:



At the temperature of +20°C:
Dust dryness: 10-20 min.
Handling possible: 20-30 min.
Ready for overcoating: 30-40 min.

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Coverage:

Apply the following products without polishing after 30-40 minutes:

- APP 1K Filler - during local repairs;
- APP 2K Acryl Filler 5:1 - during overall repairs;
- APP 2K HS Acryl Filler 4:1 - during overall repairs;
- unary and binary top coat lacquers, e.g.: APP 2K Acryl Lack, APP Color MIX RAL 2:1, APP Acryl Lack MS 2:1 RAL.

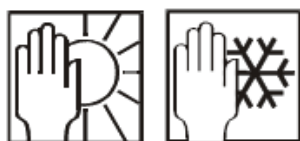
Caution!

Do not apply polyester products, base paints and water-thinned base lacquers onto this primer.

Equipment cleaning:

Nitrocellulose solvent.

Storage:



Store in original, closed containers in a dry and well-ventilated room.
Protect against freezing.

Industrial safety regulations:



For professional use only.

See: information on product labels and/or in Hazardous Material Safety Data Sheet.

Users should observe all industrial safety regulations applicable in their countries.

VOC:

Permissible VOC content [g/l] in a ready-to-use product.

780 g/l for APP 1K Haftgrund

840 g/l for APP 1K Haftgrund Spray

Maximum VOC content [g/l] in a ready-to-use product.

679 g/l for APP 1K Haftgrund

666 g/l for APP 1K Haftgrund Spray

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