

SPECIFICATIONS

Prepared on:
March 28, 2006



Updated on:
December 21, 2007

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Product name: APP 2K Haftgrund 2:1

Binary, acid-hardenable anticorrosive primer with low volatile substance content, characterised by short hardening time. Contains zinc orthophosphate. Chromate-free.

Container: 2K Haftgrund - 1.00 l; hardener - 0.5 l.

Product and additives: APP 2K Haftgrund 2:1;
APP 2K Harter HH.

Basic components: APP 2K Haftgrund 2:1 - isomer mixture;
APP 2K Harter HH - acidic phosphate hardener.

Colour: Grey.

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: The product is intended for active anti-corrosive protection during lacquer repairs of vehicles.
It is an ideal base for the APP 2K Acrylfiller 5:1 binary acrylic filling primer.

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 all lines of transition to the old lacquer coat and polyester filler layers, using P240-P320 abrasive paper.



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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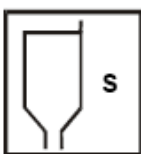
Product name: APP 2K Haftgrund 2:1

Application

Mixing ratio(s):



2 volumes APP 2K Haftgrund
1 volume APP 2K Harter HH



Spraying viscosity: 16-18 s 4mm DIN/+20°C.

Caution!

Use APP 2K Harter HH hardener only.

Never exceed the recommended hardener amount.

Applying:



Apply using a spray gun equipped with a $\phi 1.3$ - $\phi 1.5$ mm nozzle at an air pressure ranging from 3.0 to 5.0 bar.

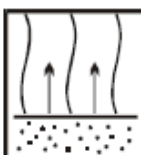


Number of layers: 1-2.

Dry coat thickness: 10-15 μm .

Recommended working conditions:

- minimum temperature: +5°C;
- maximum relative humidity: 80%.



Evaporation time between successive layers at a temperature of +20°C:
2-3 minutes.

Usability time for a ready-to-use lacquer mixture: 24 hours.

Drying:



At a temperature of +20°C:

Ready for spray coating: 25-30 minutes.

At a temperature of +60°C:

Ready for spray coating: 5-10 minutes.

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Product name: APP 2K Haftgrund 2:1

Polishing:



Coating without polishing.

Coverage:

APP 1K Filler - during local repairs.
APP 2K Acryl Filler 5:1 - during overall repairs;
APP 2K Grund EP;
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.

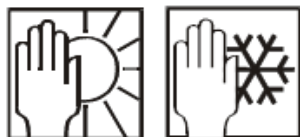
Caution!

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 2K Haftgrund 2:1

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

689 g/l for APP 2K Haftgrund 2:1

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