

81-0001

## ACRYLIC PRIMER HI-BUILD PRIMER SURFACER

Acrylic 1K Primer System

## VERSION

Version 1

Date 10 January, 2020

## PRODUCT DESCRIPTION

81-line, Acrylic Primer Grey is 1K primer. It's contain high performance Acrylic resin and anticorrosion chemicals. It's provides excellent adhesion to all metals and protects against harsh conditions that can cause rust on steel surface. In addition, it can be used as heavy build filler without affecting the gloss of base coat or clear coat.

## SUITABLE SUBSTRATE

Direct to steel  
Direct to Aluminum  
Direct to galvanized steel  
OEM Electro coat [E-coat]  
Existing finishes

## KEY CHARACTERISTICS

- Quick dry Primer
- Acrylic Primer
- Primer or sealer
- Easy to sanding

## PHYSICAL PROPERTIES

Color	Light Grey
Supply viscosity	14 – 16 seconds by ford cup No.4 [81-0081 [ 80-0001 : T-AKL 1:1 by wt.]]
Specific gravity	1.15 – 1.25 g/cm <sup>3</sup>
Shelf Life	1 Year, Store in average temperature between 40 – 95 °F (5 – 35 °C). Avoid too much temperature fluctuation or direct contact with sunlight. Suitable storage temperature is 70 °F or 21°C

## MIXING AND RELATED PRODUCTS

Mixing Ratio	Paint : Thinner [ 1 : 1-2 ] [ by Volume ]
Reducer Thinner	AKL thinner #86-104 or recommend by our staff

## APPLIED CONDITION

Spray Viscosity at 25°C	DIN 4	10 – 15 s		
	FORD 4	10 – 15 s		
Spray equipment		Fluid tip	Spray distance	
	Gravity feed	1.2-1.4 mm	15-20 cm	
	Suction feed	1.4 -1.6 mm	15-20 cm	
	HVLP	1.2-1.4 mm	10-15 cm	
	Pressure feed	1.0-1.2 mm	15-20 cm	
Spray pressure		Overall and panel repair	Spot repair	
	Gravity feed	3-4 bar	2.0-2.5 bar	
	Suction feed	3-4 bar	2.0-2.5 bar	
	HVLP	0.7 bar at nozzle	0.7 bar at nozzle	
	Pressure feed	4-6 bar	-	
Number of coats	2			
Film Thickness	40-50 micron [Total dry film]			
Cover rate	Approximately 10-12 m <sup>2</sup> . / liters of un-mixed paint per single coat.			
Drying time	15-20 °C	21-25 °C	25-30 °C	30-40 °C
	50-60 min	40-50 min	30-40 min	20-30 min
Surface Preparation	with soap and water. Rinse and wipe dry with clean cloth. Finally, clean surface using Wiping Solvent #85-4 (slow) or #85-7 (fast) with clean cloth. Sand steel, aluminum, or galvanized metal with 150 – 240 grit sand paper. Primer can be applied direct to metal; however, for improved adhesion to metal, we recommend priming with Epoxy Primer #58-xxxx or Etch Primer/Wash Primer #82-xxxx. OEM or Original Paint must be cured and sanded with 150 – 240 grit sand paper. Clear or lacquer must be sanded with 150 – 240 grit sand paper before to avoid lifting. Body filler or fiberglass must be sanded with 150 – 240 grit sand paper.			
Sanding step	Final dry sanding by #P500 to #P600 before apply Topcoat			
	- Initial sanding steps may be executed with a coarser sanding grit #P320 to #P400			
Surface cleaning	Final wet sanding step #P800 before apply Topcoat			
	- Initial sanding steps may be executed with a coarser sanding grit P600 – P800t a maximum 200 sanding grit step difference or less throughout the sanding procedure.			
Surface cleaning	Remove any surface contamination prior to the application of topcoat using an appropriate surface cleaner			

## PRECAUTION

Warning	For professional or trained applicator use only. Not for sale or use by the general public. Before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep outreach of children. Always wear approved organic vapor goggle and safety mask when using product. Apply paint in good ventilating area.
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