

# Wet-on-wet Epoxy Primer AEM1

## Features :

Two-component epoxy primer with strong adhesion to metal substrates. Excellent corrosion resistance, easy application, and fast drying. Very good sandability and can be used on steel, galvanized steel, aluminum, sanded cataphoresis, and old paints. Compatible with polyester fillers (underneath or on top).

This 2K epoxy primer provides excellent adhesion and good corrosion protection. Suitable for demanding automotive repairs, it can be used as a sandable primer or wet-on-wet.

## Application:

Sandable version: mix 2 parts primer + 1 part hardener + 0 to 10% thinner. Apply with a spray gun (1.6 mm nozzle), 1 to 2 coats. Wait 5 to 10 minutes between coats and sand when dry with P400-P500 grit. Wet-on-wet version: mix in the same way, but set the nozzle diameter to 1.3 mm and apply 1 coat to the surface. The surface can be recoated after 30 minutes at 20°C.

## Technical data :

VOC 2004/42/IIIB(c)(540) max. 540 g/l

### Primer AEM1

Shelf life : 12 months                      Density (20°C): 1.45 - 1.50 g/cm<sup>3</sup>                      Colors: grey/yellow(approximate RAL 7032)

### Hardener AEMDU1

Shelf life : 12 months                      Density (20°C): 0.90 - 0.92 g/cm<sup>3</sup>                      Colors: yellow

## Mixing ratio :

	-	By volume	By weight
	<b>Primer (A)</b>	2	100
	<b>Hardener (B)</b>	1	31
	<b>Thinner (C)</b>	0-10 vol. % of component A	0-9 % of component A

## Viscosity :

	<b>DIN 4 mm (20°C)</b>	17-21 s
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## Application :

	Spray gun gravity feed	Nozzle		Pressure		
		1.6 mm		Operating pressure according to the recommendations of the manufacturer of the gun used.		
	Application	Number of layers		flash-off between layers	Dry film thickness wet-on-wet	Dry film thickness sandable
		sandable	wet-on-wet			
		1-2	1	5-10 min	20 - 35 µm	40 - 60 µm

# Wet-on-wet Epoxy Primer AEM1

<b>Recommended conditions</b>	temperature 18–22°C, air humidity 40–60%
<b>Dry film thickness</b>	5 - 6.5 m <sup>2</sup> /l
<b>Shelf life at 20°C</b>	40 min

<b>Drying time :</b>			
	surface / object temperature	60°C	20°C
	<b>Hardener Speed</b>		
	AMEDU1	30 min (sandable)	5h (sandable)
			30 min (wet-on-wet)
	<b>hand sanding</b>	P400 - P600	
	<b>Machine sanding</b>	P400 - P500	

**Storage conditions :**

Store between +10 and +30°C, away from frost, heat, and humidity.