Wet-on-wet Epoxy Primer AEM1

v.10-10.2018

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/IIB(c)(540) max. 540 g/l

Primer AEM1
Shelf life : 12 months Density (20°C): 1.45 - 1.50 g/cm³ Colors: grey/yellow(approximate RAL 7032)

Hardener AEMDU1
Shelf life : 12 months
Density (20°C): 0.90 - 0.92 g/cm³ Colors: yellow

Mixing ratio :

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

Viscosity :

DIN 4 mm (20°C)	17-21 s

Application :

	Nozzle	Pressure
Spray gun gravity feed	1.6 mm	Operating pressure according to the recommendations of the manufacturer of the gun used.

Application	Number of layers: sandable	Number of layers: wet-on-wet	flash-off between layers	Dry film thickness wet-on-wet	Dry film thickness sandable
	1-2	1	5-10 min	20 - 35 µm	40 - 60 µm

The information provided in this technical data sheet represents the best of our knowledge. Please check before use whether this product is suitable for your application.

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

Drying time :

	surface / object temperature / Hardener Speed	60°C	20°C
	AEMDU-0.5	30 min (sandable)	5h (sandable)
			30 min (wet-on-wet)

	hand sanding	P400 - P600
	Machine sanding	P400 - P500

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

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