



TNEMEC SHOP PRIMER AK01

PRODUCT PROFILE

GENERIC DESCRIPTION	Alkyd
COMMON USAGE	AK01 is a high-solids, fast drying primer that provides extended weathering for shop and field priming of structural and miscellaneous steel.
COLORS	SPGR Gray, SPRD Red
FINISH	Flat
SPECIAL QUALIFICATIONS	Meets SSPC-Paint Specification No. 15. Product meets the performance requirements of TT-P 664D-SSPC-Paint No. 25 as specified for use in SSPC Environmental Zone 1A and 1B

COATING SYSTEM

TOPCOATS	Series 2H, 2HS, 30, 115, 1026, 1028, 1029. Note: Some systems are not for use on surfaces that are continually wet or sweat frequently. Reference the applicable topcoat data sheet for additional information.
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SURFACE PREPARATION

STEEL	SSPC-SP2 Hand Tool or SSPC-SP3 Power Tool Cleaning SSPC-SP6/NACE 3 Commercial Blast Cleaning when extended field exposure is expected.
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TECHNICAL DATA

VOLUME SOLIDS	52% ± 0.6 %
RECOMMENDED DFT	2.0 mils to 3.0 mils (50 to 75 microns)
CURING TIME	

Temperature	To Touch	To Handle	To Recoat
75°F (24°C)	20 minutes	30-45 minutes	1 hour

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS	EPA Method 24 Unthinned: 2.7 lbs/gallon (326 grams/litre) Thinned 5% (No. 13 Thinner): 2.8 lbs/gallon (339 grams/litre)
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HAPS	Unthinned: 0.47 lbs/gallon solids Thinned 5% (No. 13 Thinner): 0.51 lbs/gallon solids
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THEORETICAL COVERAGE	842 mil sq ft/gal (20.6 m ² /L at 25 microns). See APPLICATION for coverage rates.
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PACKAGING	Five-gallon pail yielding 5 gallons (18.9 L) and 55 gallon drum yielding 50 gallons (189.2 L).
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STORAGE TEMPERATURE	Minimum 35°F (2°C) Maximum 100°F (38°C)
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SHELF LIFE	12 months at recommended storage temperature.
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FLASH POINT - SETA	65°F (18°C)
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HEALTH & SAFETY	Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Safety Data Sheet for important health and safety information prior to the use of this product. Keep out of the reach of children.
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APPLICATION

COVERAGE RATES	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Minimum	2.0 (50)	4.0 (100)	417 (39)
Suggested	2.5 (65)	5.0 (125)	334 (31)
Maximum	3.0 (75)	6.0 (150)	278 (26)

Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

MIXING	Stir thoroughly, making sure no pigment remains on the bottom of the can.
THINNING	Normally not required. May thin up to 5% with VM&P Naphtha or No. 13 Thinner if needed.

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APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	765	5/16" (7.9 mm)	1/4" (6 mm)	55 psi (3.8 bar)	15-17 psi (1.0 - 1.2 bar)

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.011"-0.015" (279-381 microns)	2000-3000 psi (137-207 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Brush/Roller: Recommended for touch-up of small areas.

SURFACE TEMPERATURE

Minimum 50°F (10°C) Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

Flush and clean all equipment immediately after use with No. 13 thinner or VM&P Naphtha.

†Values may vary with color.

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