**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.

**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.

**TECHNICAL DATA**

**VOLUME SOLIDS**
52% ± 0.6%

**RECOMMENDED DFT**
2.0 mils to 3.0 mils (50 to 75 microns)

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>20 minutes</td>
<td>30-45 minutes</td>
<td>1 hour</td>
</tr>
</tbody>
</table>

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

**THEORETICAL COVERAGE**
842 mil sq ft/gal (20.6 m²/L at 25 microns).

See APPLICATION for coverage rates.

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842 mil sq ft/gal (20.6 m²/L at 25 microns).

**STORAGE TEMPERATURE**
Minimum 35°F (2°C)  Maximum 100°F (38°C)

**SHELF LIFE**
12 months at recommended storage temperature.

**FLASH POINT - SETA**
65°F (18°C)

**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.

**APPLICATION**

**COVERAGE RATES**

| Minimum | 2.0 (50) | 4.0 (100) | 417 (39) |
| Suggested | 2.5 (65) | 5.0 (125) | 554 (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.
APPLICATION EQUIPMENT

Air Spray

<table>
<thead>
<tr>
<th>Gun</th>
<th>Fluid Tip</th>
<th>Air Cap</th>
<th>Air Hose ID</th>
<th>Mat'l Hose ID</th>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>DeVilbiss JGA</td>
<td>E</td>
<td>765</td>
<td>5/16&quot; (7.9 mm)</td>
<td>1/4&quot; (6 mm)</td>
<td>55 psi (3.8 bar)</td>
<td>15-17 psi (1.0 - 1.2 bar)</td>
</tr>
</tbody>
</table>

Airless Spray

<table>
<thead>
<tr>
<th>Tip Orifice</th>
<th>Atomizing Pressure</th>
<th>Mat'l Hose ID</th>
<th>Manifold Filter</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.011&quot;-0.015&quot; (279-381 microns)</td>
<td>2000-5000 psi (137-207 bar)</td>
<td>1/4&quot; or 3/8&quot; (6.4 or 9.5 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

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. 15 thinner or VM&P Naphtha.

†Values may vary with color.