



TNEMEC UNIVERSAL PRIMER AK02

PRODUCT PROFILE

GENERIC DESCRIPTION Phenolic Alkyd

COMMON USAGE Lead- and chromate-free, fast-drying, corrosion-resistant primer that accepts a variety of high-performance topcoats. Ideally suited for steel fabricators, OEM's and field applications where "dry fall" characteristics are desired. **Note:** Not recommended for immersion.

COLORS SPGR Gray, SPRD Red

SPECIAL QUALIFICATIONS Welds produced in accordance with ASW D1.1 through AK02 passed weld integrity testing.

COATING SYSTEM

PRIMERS Self-priming

TOPCOATS Series AK02, 2H, 2HS, 43-36, 66, N69, 73, 115, 1026, 1028, 1075, 1095. **Note:** No maximum recoat time for listed topcoats.

SURFACE PREPARATION

STEEL **Enclosed or Protected:** SSPC-SP3 Power Tool Cleaning
Weather-Exposed: SSPC-SP6/NACE 3 Commercial Blast Cleaning

CAST/DUCTILE IRON Contact your Tnemec representative or Tnemec Technical Services.

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants

TECHNICAL DATA

VOLUME SOLIDS 56%

RECOMMENDED DFT 2.0 to 3.5 mils (50 to 90 microns) per coat.

CURING TIME **Temperature:** 75°F (24°C)
To Touch: 15 minutes
To Handle: 30 minutes
Dry Through: 45 minutes
To Recoat (Minimum):

Itself and Alkyds	Water-Based Acrylic and Latex Paints	Epoxies and Polyurethanes
16 hours	24 hours	24 hours

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 2.75 lbs/gallon (330 grams/litre)
Thinned 4% (No. 2 Thinner): 2.94 lbs/gallon (352 grams/litre)
Thinned 9% (No. 2 Thinner): 3.15 lbs/gallon (377 grams/litre)

HAPS **Unthinned:** 2.20 lbs/gal solids
Thinned 4% (No. 2 Thinner): 2.72 lbs/gal solids
Thinned 9% (No. 2 Thinner): 3.36 lbs/gal solids

THEORETICAL COVERAGE 898 mil sq ft/gal (22.0 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS One

PACKAGING Five-gallon pail yielding 5 gallons (18.9 L) and 55 gallon drum yielding 50 gallons (189.2 L).

NET WEIGHT PER GALLON 12.07 ± 0.25 lbs (5.47 ± 0.11 kg)

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)

TEMPERATURE RESISTANCE (Dry) Continuous 200°F (93°C) Intermittent 250°F (121°C)

SHELF LIFE 6 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

	Dry MILS (MICRONS)	Wet MILS (MICRONS)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	4.5 (115)	359 (33.4)
Minimum	2.0 (50)	4.0 (100)	449 (41.7)
Maximum	3.5 (90)	6.5 (165)	257 (23.9)

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 Power mix contents of each container, making sure no pigment remains on the bottom. Continue agitation until thoroughly mixed.

THINNING Use No. 2 Thinner. For air spray, thin up to 9% per gallon. For airless spray, brush or roller, thin up to 4% per gallon.

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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 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	75-90 psi (5.2-6.2 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019" (380-485 microns)	2700-3000 psi (186-207 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.

Roller: Use high quality synthetic woven nap covers, 1/4" nap for smooth surfaces, 3/8" nap for rough surfaces.

Brush: Recommended for small areas only. Use high quality nylon or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 40°F (4°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 the recommended thinner or xylol.

† Values may vary with color.

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