VESTOLUX

1K-R3-TAUCHGRUND AK-ZP KG14- .U

VESTOCOR®
PROTECTIVE COATINGS

Product description:
1-component priming coat based on alkyd resin (AK) - zinc phosphate, solvent-based, perfect for dipping. This primer hardens quickly.

Applications:
Suited for priming abrasive blasted structural steelwork, boilers, grey cast iron parts, piping, machinery, etc. Can be welded over (max. film thickness 25 µm).

Hardener:
Not applicable

Article numbers, colour:
E.g. KG14-3011, approx. RAL 3011 brown red.
Other colour shades on request.

Technical specifications (relating to the mixture):

Flash point:	above +23 °C
Viscosity:	100-140 sec./4 mm nozzle
Density:	approx. 1.30 g/ml
Mixture ratio:	---
Pot life:	---
Dry film thickness (DFT):	30-50 µm
Solid density:	approx. 48 %
Gloss class (20°/60°):	matt
Tinctural power (theoretical):	approx. 8.7 m²/kg at 40 µm DFT
VOC value:	approx. 445 g/l
Organic solvent content:	approx. 35 % weight
Temperature stability:	max. +120 °C, dry heat (Colour deviations are to be expected from +120 °C.)

The Technical Data indicated are subject to variations depending on colour shade and production process.

Drying times:

Dust-dry:	after approx. 45 minutes
Fast to handling:	after approx. 2 hours
Recoatable:	after approx. 8 hours
with PVC products	after approx. 24 hours

The values indicated apply to the specified dry film thickness at +20 °C and 55 % relative humidity (standard atmosphere).

Working temperature / humidity of air:
+5 °C to +35 °C

The substrate temperature must be at least 3 °C above the dew point of the ambient air. The relative humidity of air should not exceed 85 %.

Thinner:
VESTOCOR thinner VN62-, also for tool cleaning.

Subsequent coats:
Depending on requirements VESTOCOR products based on:
VESTOLUX, VESTOTEX, VESTOPUR

Substrate preparation:
In any case, adhesion-reducing residues such as oil, grease, dust, mill scale, etc. are to be removed.

Steel: abrasive blasting to preparation grade Sa 2.5 of the norm DIN EN ISO 12944-4 is recommended. A thorough manual rust removal can be accepted in technically justified exceptional cases. However, this cannot ensure the same adhesion and corrosion protection as a blasted substrate surface. Any remaining mill scale can result in spalling. Residues hampering adhesion (e.g. oil, grease and dust films, etc.) must be removed.

Applying:
Brush/roller: processing in delivery state.
Dipping: The viscosity has to be adjusted individually.

Airless spray-painting: generally from delivery state, if required add 5 weight per cent VESTOCOR thinner as a maximum.

Minimum pressure:	approx. 120 bar
Nozzle:	approx. 0.23-0.48 mm

Repair of transport and installation damages:
Recommended surface preparation: abrasive blast flaws to preparation grade Sa 2,5 of the DIN EN ISO 12944-4. Repair with: VESTOLUX R3-Tauchgrund AK-ZP KG14-. If - for technical or environmental reasons - only a power rust removing to PSt3 acc. to DIN EN ISO 12944-4 is possible, repair can also be done with VESTOPOX 1K-PUR primer FG20.

Storage and identification according to hazardous substance/workplace safety regulations:
For the identification according to valid hazardous substance regulations see the associated Material Safety Data Sheets and labels.

Storage life:
Main component: approx. 12 months in case of proper storage of non-opened drums at +5 °C to +25 °C.

Safety and protection precautions:
When processing note the safety and health at work rules from the trade association, BGR 500, chapter 2.29, as well as the relevant EC Material and Safety Data Sheets. In liquid state, the products are classified to be hazardous to waters, and therefore they must not come into waters.

Information and recommendations in this document are based on today's state of our knowledge and are intended to inform purchasers. They do not exempt purchasers to check the products for their suitability and application. We guarantee a perfect quality within the scope of our general terms and conditions of business. All previous Technical Data Sheets cease to be valid.