



TDS 20-4-1

Cardea® 1K Anticorrosive Primer



Description		Cardea® 1K Anticorrosive Primer is 1K primer which has an excellent corrosion protection and adhesion properties.		
Related Products		Cardea® 1K Anticorrosive Primer Cardea® Universal Thinner	TDS No: 50-2-1	
Substrate		Steel, Galvanize, Aluminum, Stainless steel		
Surface Preparation		Degrease with Cardea® U-Clean 300 by clean cloth.		
		P220 - P320		
		Clean with Cardea® U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.		
Mixing			By Volume	By Weight
	│	Cardea® 1K Anticorrosive Prin	ner 100	100
		Cardea® Universal Thinners	90 - 130	80 - 120
Viscosity	s	18 s / 20°C (DIN 4)		
Spray Gun Parameters		Gun Type	Nozzle size	Air pressure
	N. C.	Gravity feed spray gun	1,2-1,6 mm	1,5 – 2,2 bars
Application		1-2 wet coats.		
Flash-off Time	<u>}</u>	Approximately 3 - 5 minutes (at 20 Apply next coat within 24 hours (at		oat.



The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.







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Dry Film Thickness	4 – 6 μm	
Theoretical Coverage	8,5 m 2 /l at 4 μ m	
Next Coat	Cardea® Primers, Fillers (Do not apply Epoxy Primer). See TDS 20-1-1, 20-1-2, 20-2-1, 30-3-1, 30-1-1	
Equipment Cleaning	Use acrylic or cellulosic thinners	
Package	Cardea® 1K Anticorrosive Primer : 0,5 L Cardea® Universal Thinner : 1 L, 5 L	
Color	Grey	
Safety	Professional use only. See Material Safety Data Sheet.	



