

Technical Data Sheet

Properties: AKEMI® Multi Talent is a low solvent, fast drying 2-component acrylic primer with a high solid content and a mixing ratio of 4:1. The product is characterized by the following properties:

- complies with the VOC guideline 2004/42/EG [2004/42/2B(d)(420)]
- high film build primer and wet-on-wet surfacer in one
- high solid content
- excellent filling properties
- very good flow
- fast drying
- excellent gloss holdout
- excellent adhesion and mechanical strength
- easy to sand

Application Area: Mainly used on surfaces as treated steel, treated galvanized steel, treated aluminium, OEM E-coats, bod fillers, refinish enamels and fiberglass in the vehicle, wagon and industrial sector where high optical requirements are demanded on paintwork.

- Instructions for Use:**
1. The substrate to be painted must be dry, clean, free of corrosion, grease and mould release agents.
 2. Carefully dry machine sand the surrounding area of the part to be treated with P180 to P240 and final sand with P320.
 3. Thoroughly clean using a suitable cleaner, e.g. afin® Acryclean and wipe off the panel surface immediately using a clean dry cloth.
 4. Aluminium and zinc coated steel or fibre glass must first be coated with AKEMI® Epoxy Primer.
 5. Mixing of 4 parts Multi Talent Primer in volume (6 parts in weight) with 1 part of hardener in volume or weight.
 6. Can be thinned with AKEMI® Thinner slow
 - up to 20% for high build application
 - or
 - 45% for "wet-on-wet" application
 7. Using a HVLP gun
 - for high build apply with 1.8 – 2.0 mm nozzle
 - for "wet-on-wet" apply with a 1.2 – 1.3 mm nozzle
 8. Apply on the complete area to be coated as following
 - for high build apply a first light coat followed by 2 full/wet coats
 - for "wet-on-wet" apply 1 full single coat or 1 light + 1 full. This gives a film thickness of approx. 30 µm
 9. Allow each coat to flash 3 – 5 minutes and
 - for high build 10 minutes before baking
 - for "wet-on-wet" no flash off is necessary
 10. Pot life is 45 minutes at 20°C/65 RH
 11. Drying schedule
 - **Air dry**

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|------------|------------------------|
| high build | 60 minutes at 20°C |
| wet-on-wet | 5 - 10 minutes at 20°C |
 - **Force dry** 20 – 30 minutes at 60°C
 - **Short wave IR** 10 minutes half power, followed by 10 minutes full power with a lamp distance of 90 cm
 12. Sand dry with P400 or P500

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13. Final sand dry with P800
14. Wet-on-wet sand does not require sanding, yet, in case of dirt inclusion light flatting/denibbing can be carried out when hard dry using P800 (wet or dry paper)

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|------------------------|--|---|
| Technical Data: | Base: | isocyanate hardened acrylic resin |
| | Colours: | light grey, anthracite, white |
| | Solid content: | approx. 64% of the mixture |
| | Solid volume: | approx. 45% of the mixture |
| | Density: | approx. 1.42 g/ml of the mixture |
| | Recommended dry film thickness: | 100 – 150 µm |
| | Recommended dry film thickness wet-on-wet: | 30 µm |
| | Theoretical coverage at 80 µm: | approx. 5.5 m ² /l |
| | Delivery viscosity at 20°C: | base component approx. 30 d/Pas hardener 11 s/4 mm (DIN 53211) |
| | VOC: | ≤ 480 g/l |

Storage: If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 12 months from production (filler and hardener).

Health & Safety: Read Safety Data Sheet before handling or using this product.

Important Notice: The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trails of the product, in an inconspicuous area or fabrication of a sample piece.

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