


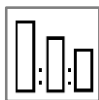








TDS 20-4-1


### Cardea® 1K Anticorrosive Primer

<b>Description</b>	Cardea® 1K Anticorrosive Primer is 1K primer which has an excellent corrosion protection and adhesion properties.		
<b>Related Products</b>	Cardea® 1K Anticorrosive Primer Cardea® Universal Thinner TDS No: 50-2-1		
<b>Substrate</b>	Steel, Galvanize, Aluminum, Stainless steel		
<b>Surface Preparation</b>		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.	
<b>Mixing</b>			By Volume By Weight
		Cardea® 1K Anticorrosive Primer	100 100
		Cardea® Universal Thinners	90 - 130 80 - 120
<b>Viscosity</b>		18 s / 20°C (DIN 4)	
<b>Spray Gun Parameters</b>		Gun Type	Nozzle size Air pressure
		Gravity feed spray gun	1,2-1,6 mm 1,5 – 2,2 bars
<b>Application</b>		1-2 wet coats.	
<b>Flash-off Time</b>		Approximately 3 - 5 minutes (at 20°C) before next coat. Apply next coat within 24 hours (at 20°C).	



TDS 20-4-1

## Cardea® 1K Anticorrosive Primer

<b>Dry Film Thickness</b>	4 – 6 µm	
<b>Theoretical Coverage</b>	8,5 m <sup>2</sup> /l at 4 µm	
<b>Next Coat</b>		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
<b>Equipment Cleaning</b>	Use acrylic or cellulosic thinners	
<b>Package</b>	Cardea® 1K Anticorrosive Primer	: 0,5 L
	Cardea® Universal Thinner	: 1 L, 5 L
<b>Color</b>	Grey	
<b>Safety</b>	Professional use only. See Material Safety Data Sheet.	