

Technical Data Sheet

00A0164 Primer

Version 2021-1

00A0164 primer products are proprietary epoxy-based primers/back coats developed to optimize adhesion in Aluminium Composite Material (ACM) products.

Substrate & pre-treatment	
Pre-treatment	Chrome Free conversion
Width	≤ 1620mm
Thickness aluminium	0,3-2,0mm
Substrate (alloy, temper)	3000 , 4000, 5000 series (H4x) EN 573-3
Front side finish	
Resin chemistry	Proprietary Epoxy based
Thickness	4-6µm EN 13523-1
Colour	Grey – visual okay / functional coating; tolerances not applicable EN 13523-3; EN 13523-22
Specular gloss	Approx. 40 gloss units (acc. to EN 1396 Table 3) EN 13523-2
Pencil hardness	≥ HB EN 13523-4
Adhesion	≤ GT1 NEN-EN-ISO 2409
Adhesion + rapid deformation indentation	≤ GT1 EN 13523-6
Resistance to cracking on bending (T-Bend test on non-embossed material) ⁽³⁾	Temper ≤ H44 H46 H48
	≤ 1,5T ≤ 2,0T ≤ 2,5T
	EN 13523-7
Resistance to MEK solvent (rubbing test)	≥ 50 double rubs EN 13523-11
Resistance to cracking after impact	No cracks EN 13523-5 7,5 Nm energy per mm of substrate depth