

Technical Data Sheet

HENSOGRUND 1K AK

Solvent based, single pack primer based on alkyd resin for structural steel members derusted by hand or blasted

SUBSTRATES / PROPERTIES

Substrates: **Steel** (Sa 2 ½, St 2), **cast iron** (Sa 2 ½)

- VOC approx. 370 g/l
- Free from zinc phosphate
- Good penetration on steel surfaces derusted by hand

PRODUCT DATA

HENSOGRUND 1K AK

Colour: red brown, matt | **Packaging:** 6 kg, 13 kg and 25 kg in one-way pails

Preparation: Stir well before use!

Thinning and/or Cleaning with HENSOTHERM® V45

Shelf life: 12 months in unopened original pails at ambient temperatures in dry conditions

HENSOGRUND 1K AK / Reference values (theoretical values without losses)

| | | |
|--|---------------------------------------|--------------------------------------|
| Specific gravity (g/ml) 1.37 | Coverage rate (m²/kg) 4.6 | Volume solid (%) 57 |
| Consumption rate (kg/m²) 0.220 | Wet film thickness (µm) 140 | Dry film thickness (µm) 80 |

APPLICATION INSTRUCTIONS

Recommendation at temperatures of approx +20 °C




Airless



Roller / Brush

| | | |
|---------------------------------|----------------|--------------|
| Nozzle size (inch) | 0.013 | - |
| Operation pressure (bar) | 150–250 | - |
| DFT* per layer (µm) | 80 | 60–80 |
| Thinning (%) | 3–5 | 0 |

*DFT = Dry film thickness

| Drying time at 60 µm DFT | Ambient temperature +20 °C |
|---|--|
|  <p>Dust dry: Ready for overcoating: Ready for overcoating with HENSOTHERM®:</p> | <p>after approx 20 minutes after approx 4–5 hours after 24 hours</p> |
| Each layer must be dried through (fingernail test positive) before the next application! | |

APPLICATION INSTRUCTIONS

Surface preparation

Steel and cast iron surfaces

- Blasting to surface preparation level Sa 2.5 according to DIN EN ISO 12944-4, surface roughness medium (G) according to DIN EN ISO 8503-1
- If sand blasting is not possible, than mechanical preparation St 3, metallically bright, surface roughness must exist
- Remove all bond damaging substances by e.g. cleaning, washing
- Manual rust removal of rusted surfaces e.g. with a wire brush or prepared by machine (minimum requirement PSt 2 / St 2) or sweep blasting
- The coverage rate does not consider the correction factor for rough surfaces according to ISO 19840.

Before overcoating with HENSOTHERM®

Before the application of the HENSOTHERM® fire protection coating all bond damaging substances shall be removed completely. All bond damaging substances shall be removed completely by sweep blasting in case of later use outdoors or in areas with increased relative humidity; adjustment of the dry film thickness if required.

Note: For dry film thicknesses (DFT) > 100 µm (max 160 µm) and low temperatures, the drying time may be exceeded up to a minimum of 7 days (!) before overcoating with HENSOTHERM®.



Air and surface temperatures: The temperature of the steel surface and the ambient temperature must remain between +15 °C up to +25 °C during the coating procedure. Not below +10 °C or above +30 °C! During the application, the surface temperature of the coated part must be at least +5 °C above the dew point of the ambient temperature!



Relative humidity max. 80 %

COATING SYSTEMS

Products

| | |
|---|--|
| Primer | HENSOGRUND 1K AK |
| Fire protection coating | HENSOTHERM® 410 KS, HENSOTHERM® 421 KS, HENSOTHERM® 310 KS, HENSOTHERM® 320 KS |
| Top coats depending on the system | HENSOTOP SB, HENSOTOP WB, HENSOTOP 2K PU (in RAL and DB colour shades or in individual colour shades available) |

PRECAUTIONS FOR SAFETY USE



Use HENSOGRUND 1K AK in accordance with all applicable local and national regulations.
Giscode: BS60

The information provided herein reflects the current state of our technical testing and experience with the use of this product. However, the buyer/user is hereby not relieved of their duty, at their own responsibility, to properly examine our materials for their suitability for the intended use based on the respective site conditions. Legal claims for damages arising from the use of this product for purposes other than, or in a manner that differs from, the description contained herein without our prior written approval are precluded and may not be asserted against us. In light of the circumstance that we have no influence over site conditions and various factors that could influence the performance and use of our product, a guarantee of results or liability, regardless of legal grounds, cannot be derived from this information or from verbal consultation provided by one of our employees unless we may be accused of intent or gross negligence. Our General Terms and Conditions apply for all other purposes (www.rudolf-hensel.de/gtc). The most recent version of our technical data sheet is valid and may be requested from the Rudolf Hensel GmbH or downloaded at www.rudolf-hensel.de. © Rudolf Hensel GmbH 04/24

RUDOLF HENSEL GMBH

Lack- und Farbenfabrik

Lauenburger Landstraße 11
21039 Börnsen | Germany

Tel. +49 40 72 10 62-10
Fax +49 40 72 10 62-52

E-Mail: contact@rudolf-hensel.de
Internet: www.rudolf-hensel.de

