

# Technical Data

## Muki AC



### Product description

Muki AC is a water borne single pack, low VOC, anticorrosive and high solids shopprimer based on an acrylic emulsion.

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### Recommended use

To be used as a pre-construction primer on blast cleaned steel surfaces in automatic shoppriming plants to protect steel during transport, storage and production. On steel for underwater use the shopprimer must be removed. Can also be used as an industry primer as a part of paint system for corrosion classes C2 - C3 (ISO 12944).

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### Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry ( $\mu\text{m}$ )	20	50	25
Film thickness, wet ( $\mu\text{m}$ )	50	125	65
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	20	8	16

### Comments

Dry film thickness measured on a smooth test panel.  
Recommendations are for automatic application in a shopprimer plant.

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### Physical properties

Colour	Black, Grey, Red
Solids (vol %)*	40 $\pm$ 2
Flash point	58 °C $\pm$ 2 (Setaflash)
Gloss	Flat
Water resistance	Good

\*Measured according to ISO 3233:1998 (E)

VOC: 57 g/l (actual).

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### Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

#### Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:2007). Roughness: using abrasives suitable to achieve grade Fine to Medium S/G (30-85  $\mu\text{m}$ , Ry5) (ISO 8503-2)

## Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

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## Condition during application

The temperature of the substrate should be minimum at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. For application in shopprimer plants the recommended steel temperature is 30-40°C.

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## Application methods

<b>Spray</b>	Use airless spray or conventional spray
<b>Brush</b>	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.
<b>Roller</b>	May be used for small areas.

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## Application data

<b>Mixing ratio (volume)</b>	Single pack.
<b>Thinner/Cleaner</b>	Water. Fresh clean water.
<b>Guiding data airless spray</b>	
<b>Pressure at nozzle</b>	15 MPa (150 kp/cm <sup>2</sup> , 2100 psi)
<b>Nozzle tip</b>	0.33 - 0.43 mm (0.013 - 0.017")
<b>Spray angle</b>	40-80°
<b>Filter</b>	Check to ensure that filters are clean.
<b>Note</b>	Recommended to have closed packaging.

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## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate
- \* Relative Humidity 70%.

<b>Substrate temperature</b>	<b>23°C</b>	<b>40°C</b>
<b>Surface dry</b>	5 min	1-3 min
<b>Through dry</b>	10 min	5 min
<b>Dry to recoat, minimum</b>	4 h	4 h

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

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## Typical paint system

Applied as a shopprimer:

**Muki AC 1 x 25 µm (Dry Film Thickness - measured on a smooth test panel)**

Applied as an industry primer:

**Muki AC 1 x 40 - 50 µm (Dry Film Thickness - measured on a smooth test panel)**

Undamaged shopprimer can be overcoated with water borne acrylic, alkyd and epoxy primers. When fully cured, it can be overcoated with approved solvent borne alkyd, acrylic and epoxy primers. Please contact your local Jotun office for more information.

**Other systems may be specified, depending on area of use**

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## Procedure for preparation and cleaning of application equipment

If the application equipment is made in stainless steel, designed for and only used for application of water borne coatings this preparation and cleaning procedure is not needed.

When switching over from solvent borne shopprimer to water borne shopprimer the equipment must be cleaned properly. Rinse and flush the pump and the lines thoroughly with the thinner used in the previous shopprimer. Then clean the system with Jotun Thinner No. 4 and thereafter water, before application of Muki AC.

When switching back to solvent borne shopprimers, do the cleaning procedure in reverse order using first water, Jotun Thinner No. 4, and then the solvent corresponding with the solvent borne shopprimer.

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## Storage

The product must be stored above 0°C and in accordance with national regulations, subject to re-inspection thereafter. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed. SHELF LIFE: 12 months. Should be protected from temperatures higher than 40°C.

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## Handling

Handle with care. Stir well before use.

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## Packing size

20 litre container

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## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

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**DISCLAIMER**

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product can be used under conditions beyond our control, we can only guarantee the quality of the product itself. We also reserve the right to change the given data without notice. Minor product variations may be implemented in order to comply with local requirements.

If there is any inconsistency in the text the English (UK) version will prevail.

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