

Muki AC

Product description

This is a one component physically drying waterborne acrylic coating. It is a shop primer designed for high welding and cutting speed, giving reduced weld porosity and back burning. It is fast drying making it suitable for stacking shortly after application. Can be used as temporary primer in a new construction phase or as primer in a complete coating system in atmospheric environments. Suitable for properly prepared carbon steel substrates and recommended to be applied in an automated shop priming line. Compatible with advanced welding technologies including MIG, MAG and G-FCAW.

Typical use

Protective:

Suitable for structural steel and piping to be exposed to corrosive environments up to high. Recommended for refineries, power plants, bridges, buildings and mining equipment.

Approvals and certificates

Welding approved according to DVS-guideline 0501

Health approved for use as shop primer by FORCE institute

Additional certificates and approvals may be available on request.

Colours

black, grey, red

Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	40 ± 2 %
Gloss level (GU 60 °)	ISO 2813	matt (0-35)
Flash point	ISO 3679 Method 1	58 °C
Density	calculated	1.2 kg/l
VOC-EU	IED (2010/75/EU) (theoretical)	51 g/l

The provided data is typical for factory produced products, subject to slight variation depending on colour.

Gloss description: According to Jotun Performance Coatings' definition.

Film thickness per coat

Typical recommended specification range

Dry film thickness	20 - 50	µm
Wet film thickness	50 - 125	µm
Theoretical spreading rate	20 - 8	m ² /l

Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	Sa 2½ (ISO 8501-1)	Sa 2½ (ISO 8501-1)

Application

Application methods

The product can be applied by

- Spray: Use air spray or airless spray.
- Brush: Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.
- Roller: May be used for small areas.

Product mixing

Single pack

Thinner/Cleaning solvent

Thinner: Water

Guiding data for airless spray

Nozzle tip (inch/1000): 15-23

Pressure at nozzle (minimum): 50 bar/700 psi

Drying and Curing time

Substrate temperature	23 °C	40 °C
Surface (touch) dry	5 min	1 min
Walk-on-dry	10 min	5 min
Dry to over coat, minimum	4 h	4 h

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	60 °C	-

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Subsequent coat: acrylic

Packaging (typical)

	Volume (litres)	Size of containers (litres)
Muki AC	20	20

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Protect from freezing at all times during storage and transport.

Shelf life at 23 °C

Muki AC 12 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray 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.

Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.
