KLB KÖTZTAL
Lacke + Beschichtungen GmbH

KLB-SYSTEM ACRYL
AC 20

Rapid-setting, low viscosity 2-component PMMA base coat

Packaging units



Article no.	Packaging	Content (kg)	Units/pallet
AK0002-92	Combi can	1.00	240
MA0102-52	Canister	10.00	50
MA0102-02	Drum	190.00	2
MA0102-25	Hobbock	25.00	12

Product characteristics

Processing time	0 °C / 32 °F : 20 min. 5 °C / 41 °F : 18 min. 12 °C / 53.6 °F : 15 min. 20 °C / 68 °F : 13 min. 30 °C / 86 °F : 10 min.
Curing time (accessibility)	0 °C / 32 °F : 60 minutes 5 °C / 41 °F : 50 minutes 12 °C / 53.6 °F : 45 minutes 20 °C / 68 °F : 30 minutes 30 °C / 86 °F : 25 minutes
Dosage of hardener	0 °C / 32 °F : 6.0 % 5 °C / 41 °F : 6.0 % 12 °C / 53.6 °F : 5.0 - 5.5 % 20 °C / 68 °F : 3.0 - 3.5 % 30 °C / 86 °F : 2.0 - 2.5 %
Further coatings	After curing and accessibility
Consumption	0.350 - 0.450 kg/m²
Colours	Non-pigmented
Shelf life	12 months (originally sealed)

Product description

KLB-SYSTEM ACRYL AC 20 is a non-pigmented, solvent-free, low-viscosity acrylic resin. **KLB-SYSTEM ACRYL AC 20** is used as base coat with good adhesion before the application of acrylic resin coatings on screed and concrete. **KLB-SYSTEM ACRYL AC 20** sets rapidly to a firmly adhesive film even at lower temperatures. For subsequent coatings, a saturated, closed, non-porous film is necessary.

Furthermore, **KLB-SYSTEM ACRYL AC 20** is suitable for thin scratch coats up to a maximum of 1.0 mm. Achieving increased layers, flexible acrylic resins like **KLB-SYSTEM ACRYL AC 313**, **KLB-SYSTEM ACRYL AC 320**, or **KLB-SYSTEM ACRYL AC 390** are recommended. The resin may also be used to mend screed cracks.

KLB-SYSTEM ACRYL AC 20, just like all other KLB acrylic resin systems, is characterized by a rapid setting, and may also be used at lower temperatures. **KLB-SYSTEM ACRYL AC 20** can be applied in combination with subsequent epoxy coatings; however, a complete scattering with quartz sand 0.7/1.2 mm is necessary.

Note: for optimizing the adhesion on non-porous or low-porous substrates, e.g. metal or tiles, we recommend the additive **KLB-SYSTEM ACRYL ADD 27** as an adhesion enhancer. The packaging sizes of **KLB-SYSTEM ACRYL ADD 27** are delivered in adjusted dimensions.

Area of application

- Use as base coat before coating with all kinds of acrylic resin coatings.
- Thin scratch coats in combination with **KLB-Mischsand 2/1** for adjusting the depth of roughness.
- Use as fast reacting base coat in combination with scattering, for other reactive resin synthetics.
- Rapid reconstruction resin for mending screed cracks.

Product features

- very rapid-setting
- resistant to water and chemicals
- cures at low temperatures
- reworkable after 1 hour
- roughness depth may be filled for adjustment
- solvent-free
- for renovations
- free of deleterious substances against varnish

Technical data

Viscosity	300	mPas	DIN EN ISO 3219 (23 °C / 73.4 °F)
Density	1.01	kg/l	DIN EN ISO 2811-2 (20 °C / 68 °F)
Water absorption	< 0.2	weight-%	DIN 53495
Shore-hardness D	68	-	DIN 53505 (after 7 days)

The values established in tests are average values. Deviations from the product specification may occur.

Included in systems

- System H3 KLB KITCHEN PMMA Standard
- System M1 KLB INDUSTRIAL PMMA RX
- System M2 KLB INDUSTRIAL DECOR PMMA

Please visit our website to get more information about our KLB systems: www.klb-koetztal.com

Tests

- Product is compliant with DIN EN 13813: 2003-01.

Substrate

The substrate to be coated must be even, dry, free of dust, sufficiently resistant to tension and compression as well as be free from weakly-bonded components or surfaces. Materials impairing adhesion such as grease, oil and paint residues should be removed with suitable measures. Substrates suitable for coating are concrete C20/25, cement screed CT-C35-F5 as well as other sufficiently solid substrates. Screeds treated with synthetic dispersions are not always suitable, as the curing reaction of the acrylic resin can be disturbed. In case of doubt, it is recommended to create a test surface. The substrate has to have adequately high strength for the intended occupational use. Coating mastic asphalt is generally not recommended. The substrates to be coated should be prepared mechanically, preferably by shot blasting. The surface strength must then be at least 1.5 N/mm². For concrete, moisture content must not exceed 4.5 CM-%, remaining residual humidity. The possibility of moisture ingress from the rear must be permanently excluded. Observe the information issued by the trade associations, e.g. the most recent versions of BEB worksheets KH-0/U and KH-0/S. Reconstructing floors may require special procedures. Obtain technical advice!

Mixing

Acrylic resins and acrylic hardener compound will be delivered in individual packaging units. Since the curing reaction depends on the prevailing processing temperature, the acrylic hardener is dosed according to the section on hardener dosing.

KLB acrylic resin has to be stirred or agitated to a homogeneous resin mixture before processing. Due to the rapid curing of the material, only partial quantities to be processed within the pot life should be mixed. In any case, note the indicated amount of curing agent to be added. The specified hardener additions must be observed in any case, as curing problems may occur if too little and colour changes may arise if too much is added. Empty all of the hardener compound into the core component and mix carefully with a slow speed mixer (200 - 400 r/pm) for at least 30 - 60 seconds until the hardener powder is completely dissolved. If aggregates are used to produce compounds that are still easy to stir, they can be stirred in first and the hardener powder added at the end.

Note: for priming non-absorbent or low-absorbent substrates, e.g. metal or tile, we recommend to increase adhesion by adding 1 % by weight of the additive **KLB-SYSTEM ACRYL ADD 27** into the primer. Be aware that mistakes in the dosage may cause problems with adhesion and hardening. **KLB-SYSTEM ACRYL ADD 27** is supplied in adapted packaging sizes. PMMA resins to which the additive has been added are not storage stable. Therefore, always add the additive directly before processing.

Add KLB-SYSTEM ACRYL ADD 27 to the acrylic resin before the hardener. Blend thoroughly with a slow speed mixer. Then the hardener powder is added.

Processing

Process immediately after mixing because of the short pot-life. For the base coat application, pour the material partially on the substrate and apply an even, but saturated coat with a rubber squeegee or a solvent-resistant roller. Consumption approx. 0.400 kg/m². For subsequent acrylic resin coatings, a sealed, non-porous surface must be achieved. Surfaces should be completely scattered with quartz sand 0.7/1.2 mm for further reactive resin system applications. Acrylic resin may be applied on non-sanded, non-porous surfaces. Adequate air circulation is necessary after application for good curing. Insufficient air ventilation and static air layer may result in curing disturbances. Avoid draught. **Note:** curing is adjusted for a temperature range between 0 - 30 °C / 32 - 86 °F. For application at lower temperatures, please obtain manufacturers advice. For thin scratch coats, 0.5 parts per weight of mixed sand **KLB-Mischsand 2/1** may be added. Filling coats may be applied on the primed surface with a coating knife or trowel.

Floor and air temperature must not fall below 0 °C / 32 °F. If a dew-point situation arises, adhesion may be disrupted. If working conditions are not complied with, the technical properties of the end product may deviate from those specified.

Cleaning

To remove fresh contamination and to clean tools, use thinner **VR 119** immediately. Hardened material can only be removed mechanically.

Storage

Store in dry and at frost-free conditions. Ideal storage temperature is between 10 - 20 °C / 50 - 68 °F. Bring to a suitable working temperature before application. Tightly re-seal opened containers and use the content as soon as possible.

Special remarks

The product is regulated by the German Ordinance on Hazardous Substances (GefStoffV), the German Ordinance on Industrial Safety and Health (BetrSichV), and

transport regulations for hazardous goods. The necessary information is contained in the DIN Safety Data Sheet. Observe all identification information on the container label!

GISCODE: RMA 10

Indication of VOC-content:
(EG-Regulation 2004/42) Maximum Permissible Value 500 g/l (2010,II,j/lb): Ready-for-use product contains < 500 g/l VOC.

CE marking

CE

KLB Kötztal Lacke + Beschichtungen GmbH Günztalstraße 25 FRG-89335 Ichenhausen	
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AC20-V1-022013	
DIN EN 13813:2003-01	
Synthetic resin screed mortar DIN EN 13813: SR-B1.5-NPD-NPD	
Fire behaviour	E_{fl}-s1
Emission of corrosive substances	SR
Wear resistance to BCA	NPD
Adhesive tensile strength	B 1.5
Impact resistance	NPD

NPD = No Performance Determined

Please consider the latest version of this product information on our website.

All stated information is based on our experience and technical preparation. We guarantee the correct and proper quality of our products. We do not assume any responsibility for the work not carried out by us, since we have no influence on the processing or processing conditions. We recommend on-site trials to be conducted. With appearance of this new KLB product information, all prior information loses validity. The updated version is available on our website www.klb-koetztal.com. In addition, our "General Terms and Conditions“ apply.