



ACTFLEX 600 PRIMER.

Technical Data Sheet

ACTFLEX 600 Hybrid Solvent Primer

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Description

ACTFLEX 600 Primer is a specially formulated hybrid, one-component, moisture-cured primer designed for superior adhesion across various substrates. Its advanced composition chemically interacts with surfaces, creating a molecular bond that optimizes surface preparation. This interlocking interface ensures a durable connection between the substrate and subsequent coatings, adhesives, or sealants. Engineered for exceptional performance, **ACTFLEX 600 Primer** works seamlessly with water-based membranes, enhancing adhesion and ensuring long-lasting, reliable waterproofing.

Roller, Brush Grade or Spray		Packaging (Weight)	
		▪ 4L	▪ 17L
Properties			
Appearance	Translucent Matte, Viscous Liquid	Vapor Pressure@25°C	3.8 kPa
Odour	Solvent odour	Flash Point	>23°C
Solvent Resistant	Good when fully cured	Density @25°C	1.0-1.2 g/ml.
Solubility	Soluble in organic solvent	Volatile Content	<70 %(w/w).
	Insoluble in water	Touch Dry Time, Minimum	30 minutes at 20°C and 50% R.H 15 minutes at 30°C and 50% R.H
Waterproof Time	3 Hours at 25°C and 50% R.H	Full Cure:	6 Hours at 25°C and 50% R.H.
Coverage	4m² to 6m²/L depending on surface	Application Temperature:	10°C – 26°C.
Usable Period After Opening	Within same day	Recommended Thickness:	50-100 microns (dry film)
		Shelf Life	9 Months

Suitable Surfaces

New and aged concrete – Promotes deep penetration and secure bonding.
Rendered surfaces – Strengthens adhesion for subsequent coatings.
Masonry structures – Optimizes surface preparation for waterproofing applications.
Compressed fibrous cement (Fibro) – Provides a stable base for membrane adhesion.

Porous and non-porous substrates – Enhances adhesion on various surfaces. (confirmation must be made with representative first)
Existing waterproofing layers – Ensures intercoat bonding for repair and maintenance.
Precast concrete panels – Improves adhesion on smooth, factory-finished surfaces.

Surface Preparation

Clean the Surface: Remove dust, dirt, oil, grease, wax, and any loose contaminants.
Remove Existing Coatings: If necessary, mechanically grind or abrade the surface to remove old coatings, laitance, or weak layers.
Repair Defects: Fill cracks, holes, or surface irregularities with a suitable repair mortar.
Dry the Substrate: Ensure the surface is dry before application. Avoid high moisture content that may affect adhesion.

Ensure Structural Integrity: Substrate should be stable, sound, and free from movement or flaking.
Decontaminate Non-Porous Surfaces: Wipe smooth surfaces with solvent or degreaser to remove any surface residue.
Vacuum or Blow Clean: Remove fine dust particles before primer application.
Test Adhesion (if required): Conduct a small adhesion test on critical surfaces to ensure compatibility.

Application Variability Factors

Mixing:

- Stir well before use to ensure uniform consistency.
- Do not dilute or mix with other products unless specified.

Application Method:

- Apply using a brush, roller, or airless sprayer, ensuring even coverage.
- Work the primer into the substrate to enhance penetration and adhesion.

Coating Thickness:

- Apply a thin, uniform layer. Avoid pooling or excessive build-up.
- Allow the first coat to dry before applying a second coat (if required).

Drying Time:

- Touch-dry within **30–60 minutes**, depending on temperature and humidity.
- Ensure the primer is fully dry before applying membranes, coatings, or adhesives.

Subsequent Application:

- Once dry, proceed with the application of the selected waterproofing membrane or adhesive.
- If left exposed for an extended period, reapply a fresh coat before continuing.

Cleanup:

- Clean tools and equipment with **solvent or appropriate cleaner** before the primer dries.
- Dispose of waste according to local regulations.

Limitations

- A sample test application is recommended on all substrates as staining may occur.
- **ACTFLEX 600 Primer** is NOT recommended for particle board or chip board.
- **ACTFLEX 600 Primer** is NOT a vapour barrier. Moisture will cause the primer to blister and peel.
- **ACTFLEX 600 Primer** is NOT suitable for exposure to sunlight and must be protected from sunlight after 48 hours of full cure.
- Improper storage may result in instability of product in can.

Clean Up

Clean-Up:

It is essential to clean tools and equipment immediately while the product is still wet. Use a solvent to wipe down and remove excess product from surfaces. Once dry, ACTFLEX 929 HV becomes difficult to remove, and mechanical methods may be required for cleaning.

Safety:

Always follow the appropriate **OH&S** guidelines and refer to the **MSDS** for safe handling and usage of solvents. It is crucial that no product or cleaning water is discharged into sewers or waterways. Additionally, avoid contact with spilled material to prevent any risk of contamination or harm.

Storage

Storage:

ACTFLEX 600 Primer should be stored in cool, dry conditions (10–22°C) in its original, unopened containers. Protect the material from moisture and direct sunlight, as exposure to temperatures above the recommended range may reduce the shelf life of the product. The product is **combustible** when uncured, so it is important to keep it away from any ignition sources and avoid storing it in areas such as pits, depressions, basements, or spaces where vapours may accumulate. Once the container is opened, it is preferable to use all contents, as the product is sensitive to airborne moisture.

Shelf Life:

When stored in proper conditions, ACTFLEX 600 Primer has a shelf life of **12 months** from the date of manufacture.

Safety Precautions

ACTFLEX 929 HV is classified as hazardous and may cause skin and eye irritation. Always use this product in a well-ventilated area, and wear the appropriate personal protective equipment (PPE), including chemical-resistant gloves, safety boots, and protective eyewear (to guard against splashes). Inhalation of vapours may also pose a risk, so it is essential to wear a suitable respiratory protection device. Note that **organic vapour respirators with particulate pre-filters** and **powered air-purifying respirators** are **not suitable** for use with this product.

To minimize exposure, ensure that soiled clothing is changed immediately and wash hands thoroughly before taking breaks or finishing work. In the event of eye contact, rinse immediately with plenty of water. If inhaled, move the affected person to

fresh air, and if discomfort persists or if breathing difficulties occur, seek medical attention without delay. If swallowed, **do not induce vomiting**. Contact the Poisons Information Centre (13 11 26 within Australia or 0800 764 766 in New Zealand) for advice.

IMPORTANT: The uncured product is **combustible**, so keep all sources of ignition away from the product and its vapours. For emergency situations, dial **000** for assistance from the **Police or Fire Brigade**.

Always comply with **local regulations** and follow the safety instructions outlined on the packaging. For additional safety information, refer to the **Safety Data Sheet (SDS)** available at www.forspec.com.au.

Data Sheet

This Technical Data Sheet and the Material Safety Data Sheet (SDS) may be revised at any time to comply with relevant changes to the Australian Standards or to include changes to current technology. Always read the current SDS and TDS carefully prior to use, as application and performance data may change from time to time. It is always best to request a copy of the latest technical data from Forspec Protective Coatings by calling 02 8021 3517 or emailing info@forspec.com.au. Data provided is typical but does not constitute a full specification. This should be sighted from the company for specific projects.

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