

# SOCOGLAZE PRIMER WB410

## 2K WATER-BASED EPOXY PRIMER

Technical Data Sheet

### Approvals and conformities

THALES GLOBAL SERVICES

64003582-024

SOCOGLAZE PRIMER WB410 is a two-part water-based epoxy primer. It is a chrome free anti-corrosion / adhesion primer that is overcoatable with polyurethane paints.

### Benefits:

- Good corrosion resistance.
- Good resistance to cleaning agents and water immersion.

### USES

Substrate	Preparation
Aluminium alloy	Anodisation
Steel	Sand blasting, sanding
Composite	Sand blasting, sanding

### Please, consult us regarding SOCOMORE solutions for:

- Surface preparation (SOCOCLEAN, DIESTONE & DS ranges),
- Functionalized coatings (SOCOGLAZE, AEROGLAZE, CHEMGLAZE, PRIAM, LBYH ranges),
- Surface treatment (SOCOCLEAN & SOCOSURF ranges),
- Adhesion promotion (SOCOGEL & PREKOTE ranges)
- Chemical stripping (SOCOSTRIP & SPC ranges).
- Non destructive testing products & services (BABBCO range)

**socomore** The Surface Company



### DIRECTIONS FOR USE

#### Two Component Product

Name	Pot-Life (hh:mm)
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1/3

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**socomore**

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SOCOGLAZE HARDENER WB410	03:00
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## Preparation & Application

During application, the following requirements must be adhered to:

- $15^{\circ}\text{C} < T^{\circ} < 35^{\circ}\text{C}$
- $30\% < \text{Hy} < 70\%$

1 - PNEUMATIC SPRAYING	Viscosity AFNOR CUP 4 : 55 s +/- 15	Weight	Tol +/-
Base	SOCOGLAZE PRIMER WB410	100	
Hardener	SOCOGLAZE HARDENER WB410	58	1
Adhesion promotor	PROMOTEUR ADHERENCE WB410	2.4	0.1
Thinner	DL 1511	15	5

Table: Application method determines thinner ratio. Viscosity measurements provided are intended to be guidelines only and not parameters for quality control. Verified information is provided in certification documents, which are available from the technical department on request.

## Mixing and viscosity measurement

- Stir part A for at least 2 minutes.
- Stir part B for at least 2 minutes.
- Add the hardener (part B) into the base (part A) and mix for at least 2 minutes.
- Add the adhesion promoter WB410 to the A+B mixture, and mix for 1 minute.
- Add 15% (in weight) of thinner to the A+B+promoter mixture, and mix for 1 minute.
- Perform a viscosity measurement: CA4 Cup
- If the viscosity conforms to 40-70s for CA4 Cup, the product can be applied.
- If the viscosity does not conform, adjust the viscosity with an extra 5% (in weight) thinner (max).
- If the viscosity now conforms to 40-70s for CA4 Cup, the product can be applied.
- Do not dilute more than 20g.

AIR DRYING	
Characteristic	Value
Dust dry	01:30 h
Touch dry	03:00 h
Hard dry	12:00 h
Overcoating	Min: 03:00 h / Max: 72:00 h

FORCED DRYING		
Characteristic	Value	Value
Flash off	00:30 h	00:30 h
Force dry	02:00 h	01:00 h
Temperature	60°C	80°C

## Recoat time and process

- Recoat window: 3h to 72h.
- If cured at 60°C or 80°C: recoat is possible after cooling (within 72h).
- After 72h:
  - Reactivate the surface using an abrasive paper, grade P220 to P320.
  - Remove the dust and clean the surface using an approved cleaning solvent.

- Apply a thin layer of primer.
- Dry the thin layer: 3h at room temperature or 1h at 60°C or 30 minutes at 80°C.
- Apply the topcoat.

## TECHNICAL CHARACTERISTICS

Technical Data - Product Ready For Use	
Characteristic	Value
Weight solids	48.7% +/-2
Volume solids	37.4% +/-2
Density	1.23 +/- 0,05
Recommended wet film thickness	80µm +/-15
Recommended dry film thickness	30µm +/-5
Theoretical coverage	105 g/m2 for 30µm
Shade	Grey
Appearance	Matt

Data for mixture n°1

Other Data		
Characteristic	Value	Note
VOC BASE	26.9 G/L (gram / liter)	
VOC HARDENER	3.2 G/L (gram / liter)	
VOC RTU Mix	27.7 G/L (gram / liter)	Base Mix + Hardener + Promoter + Thinner

## PRECAUTIONS FOR USE AND STORAGE

### Storage

Can be stored for 12 months between 5°C and 35°C in original, unopened containers. KEEP AWAY FROM FROST.

Shelf life after first opening:

- Base: 3 months
- Hardener B: 3 months

For more information regarding the danger of the product, please consult the product safety data sheet according to local regulation.

For professional use only.

**This technical data sheet replaces and cancels the previous one.**

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as SOCOMORE deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Pictures are not contractual. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.