

SOCOGLAZE PRIMER WB421

2K WATER-BASED EPOXY PRIMER

Technical Data Sheet

Approvals and conformities

COLLINS RATIER FIGEAC

FN131-2

SOCOGLAZE PRIMER WB421 is a two-part water-based epoxy primer. It is an anti-corrosive / adhesion primer, overcoatable with polyurethane paints.

Performance :

- Excellent resistance to water immersion,
- Good resistance against corrosion and cleaning agents,
- Good adhesion on several substrates.

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

1/4

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Name	Pot-Life (hh:mm)
SOCOGLAZE PRIMER WB421 HARDENER	03:00

Preparation & Application

During application, the following requirements must be observed:

- 15 °C < T° < 35 °C
- 30 % < Hy < 70 %

1 - PNEUMATIC SPRAYING Viscosity 55 s +/- 15 AFNOR CUP 4		Volume	Weight	Tol +/-
Base	SOCOGLAZE PRIMER WB421	30,3	47,6	
Hardener	SOCOGLAZE PRIMER WB421 HARDENER	27,2	52,4	1
Adhesion promotor	LED 348	1	1,5	0,1
Thinner	DL 1511	5,4	7,5	2,5

Table: Thinner ratio according to application method. 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 on request to the technical department.

Mixing and viscosity measurement:

- Stir the Base for at least 2 minutes,
- Stir the Hardener for at least 2 minutes,
- Add the hardener into the base and mix for at least 2 minutes,
- Add 1,5% (in weight) of adhesion promotor LED 348 to the base+hardener mixture, and mix for 1 minut,
- Add 7,5% (in weight) of thinner to the base+hardener+promotor mixture, and mix for 1 minutes,
- Perform a viscosity measurement: CA4 Cup,
- If the viscosity is conform : 40-70s for CA4 Cup, the product can be applied,
- If the viscosity ins't conform, adjust the viscosity with an extra 2,5% thinner (max),
- If the viscosity is now conform : 40-70s for CA4 Cup, the product can be applied,
- Do not dilute more than 10%.

AIR DRYING	
Characteristic	Value
Dust dry	01:30 hours
Touch dry	03:00 hours
Hard dry	12:00 hours
Overcoating	Mini : 03:00 hours / Maxi :72:00 hours

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

Recoating time and process :

- Recoatable window : 3h - 72h.

- If cured at 60°C or 80°C : Recoat possible after cooling (without exceeding 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.
 - Then, drying of this thin layer : 3h à room temperature or 1h at 60°C or 30min at 80°C
 - Finally, apply the topcoat.

TECHNICAL CHARACTERISTICS

Technical Data - Product Ready For Use	
Characteristic	Value
Weight solids	50% +/-2
Volume solids	37% +/-2
Recommended wet film thickness	68μ +/-10
Recommended dry film thickness	25μ +/-5
Theoretical coverage	90 g/m2 for 30μ
Shade	Beige
Appearance	Matt

Data for mixture n°1

Other Data		
Characteristic	Value	Note
VOC, PART A	69,3 G/L (gram / liter)	
VOC PART B	3,6 G/L (gram / liter)	
VOC	39,2 G/L (gram / liter)	Mix Base + Hardener + 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 1rst opening :

- Base : 3 months
- Hardener : 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

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