Brillux
Industrial Coatings

Technical Data Sheet

1C Adhesion Primer 5408

Universal adhesion primer, particularly suitable for coil-coating substrates

Basis
Acrylic resin

Color
Beige, redbrown, light-gray, white, black

Gloss grade
Matt

Properties
- excellent adhesion even on difficult substrates
- fast drying
- can be sanded and over-coated after approx. 15 min. (depending on coating thickness)
- best used as an adhesion primer for coil-coated sandwich elements
- not suitable for heavy corrosion protection

Field of application
Use as an adhesion primer on difficult surfaces in combination with appropriate top coatings (see coating recommendation) for highest weather resistance. Perfectly suitable for garage doors, shop design, trade fair construction, vending machines, container, doors and door frames.

Technical data

Density
1.10 to 1.31 g/cm³ [1]
(in accordance with DIN EN ISO 2811)

Theoretical coverage
249 to 314 m²/kg [1]
(at 1 µm dry film thickness)

Solids content
47 to 60 weight % [1]

Delivery viscosity at 20 °C
90 to 120 sec./DIN 4 mm

Stability
150 to 200 µm (wet film)

Flash point
> 23 °C

Labelling
See current safety data sheet.

1) depending on color

Coating recommendation

Substrates [2]	Prime coat	Intermediate coat [4]	Top coat
Galvanized steel [3]	1C Adhesion Primer 5408 30 to 40 µm	2C Epoxy Primer 5706 [5] 40 to 80 µm	Synthetic Resin Paint 5460, 5461, 5462 40 to 60 µm
Aluminum **Non-ferrous metals** [3] **Many plastic materials** [3]	1C Adhesion Primer 5408 30 to 40 µm	n/a	
Coil-Coating	1C Adhesion Primer 5408 15 to 20 µm		

2) Generally, the substrate must be free from grease, oil, separating and drawing agents as well as corrosion products and other impurities.
3) An adhesion test should be carried out.
4) Before applying topcoats in intense colors, an intermediate coat in RAL 9010 (approx. 40 µm) with 5461.-.9010 is required (see technical data sheet 5460, 5461, 5462).
5) In order to prevent the formation of zinc soap, a sealer (2C Epoxy Primer 5706) has to be applied when using synthetic resin top coats on galvanized substrates.

Process

Material has to be stirred until homogeneous before application.

Thinning

Universal Thinner 5117. Disperse homogeneously by stirring.

Application temperature

$\geq 10\ °C$

Air humidity

< 75 % r. h.

Compatibility

Compatibility is given only in combination with the thinners and paints mentioned in this Technical Data Sheet.

Application

Air spraying, air-mix spraying, airless spraying, electrostatic spraying (with the needed conductivity).

Drying

Air drying
(at + 20 °C, 65% r. h.)
Dust-dry after 10 to 15 minutes, non-sticky and ready for re-working after 15 to 20 minutes, dry after approx. 1 hour.

At lower temperatures and/or higher air humidity longer drying times are possible.

Spray data

Process	Nozzle	Pressure	Application viscosity [1]
Air spraying	1.2 to 1.5 mm	3 to 5 bar (air)	20 to 30 sec.
Airless spraying	0.28 to 0.38 mm	100 to 150 bar (material)	40 to 50 sec.
Air-mix spraying	0.28 to 0.38 mm	100 to 150 bar (material) 1.0 to 1.5 bar (air)	40 to 50 sec.

1)   measured in DIN 4 mm flow cup (in mixture).

Packaging

30 kg

Storage

1 year after receipt.
Store in original closed container, dry and at room temperature. Protect against heat and direct sunlight.

Remark

This Technical Data Sheet is based on intense development work and many years of practical experience. The contents do not constitute any contractual relationship. The user/buyer is not released from his/her obligation to test our products for suitability for the intended application. In addition, our General Terms and Conditions shall apply.

As soon as a new edition of this Technical Data Sheet is issued, the previous specifications become invalid.
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