

1K Primer 5415

Weldable adhesion primer for difficult substrates



Field of application

As a weldable adhesion promoter for difficult substrates on agricultural and construction machines, residential containers and portacabins, doors, door frames, structural elements and profiles, facades and exterior lighting, etc.

Properties

- excellent adhesion
- dries very quickly
- weldable with film thickness up to approx. 10 µm
- temporary corrosion protection for thin films

Material description

Basis	Polyvinyl butyral
Color shades	Beige, red-brown, light gray, white, black Beige is available at short notice via the quick-delivery service.
Gloss grade	Silk matt
Density	0.98–1.20 g/cm ³ ¹⁾ (in accordance with DIN EN ISO 2811)
Theoretical yield	133–168 m ² /kg ¹⁾ (at 1 µm dry layer)
Solids content	28–41% by weight ¹⁾
Delivery viscosity at 20°C	50–60 sec./DIN 4 mm
Stability	100–150 µm (wet film)
Flash point	> 23°C
Labeling	See current safety data sheet.

¹⁾ Dependent on the color shade

Coating recommendation

Substrates ²⁾	Prime coat ³⁾	Intermediate coat ⁴⁾	Top coat
Cast Steel Preferably sand-blasted (degree of cleanliness min. SA 2 ½ in accordance with DIN EN ISO 12944, part 4), iron or zinc-phosphated Galvanized steel⁵⁾ Aluminum Non-ferrous metals and similar substrates	1K Primer 5415 10–15 µm	Synthetic Resin Primer 5200 40–60 µm	Synthetic Resin Paint ⁵⁾ 5460, 5461, 5462 40–60 µm
		2K-EP Primer 5706 40–80 µm	2K-PUR Acrylic Paint 5740, 5741, 5742, 5743 40–80 µm
		2K-PUR High Solid Primer 5703 40–80 µm	Hydro 2K-PUR Paint 5860, 5861, 5862, 5863 40–60 µm

- ²⁾ The substrate must generally be free of fats, oils, separating and drawing agents, as well as dirt and corrosion products including impurities.
- ³⁾ The 1K Primer can also be used below the Brillux Stove Enamels 5590, 5591, 5592 after forced drying.
- ⁴⁾ For top coats in intense color shades, an additional intermediate coating in color shade RAL 9010 (approx. 40 µm) is required with 5461–9010 and/or 5742–9010 and/or 5862–9010 (see the technical data sheets 5460, 5461, 5462 and/or 5742 and/or 5860, 5861, 5862, 5863).
- ⁵⁾ To prevent the formation of zinc soap, a suitable intermediate coating is to be applied as a primer sealer before the top coat with synthetic resin systems for the use of galvanized substrates.(2K-EP Primer 5706).

Use

Stir the material homogeneously before application.

Compatibility Can only be combined with the thinners and top coats specified in this technical data sheet

Application temperature ≥ 10°C

Thinning Universal Thinner 5117. Distribute homogeneously while stirring.

Humidity < 75% relative humidity

Application method

Application method Air spraying

Drying

Air drying (at + 20°C, 65% relative humidity) Dust-dry after approx. 5–10 minutes, non-sticky after approx. 15–20 minutes, recoatable after approx. 1 hour, fully cured after approx. 8 hours.

Oven drying Ensure a flash-off time of approx. 10–15 minutes. Afterwards oven dry the paint for approx. 60 minutes at an object temperature of approx. 60°C or approx. 10 minutes at an object temperature of approx. 160°C. Allow longer drying times when temperatures are lower and/or humidity is higher!

Spray data

Method	Nozzle opening	Pressure	Application consistency ⁶⁾
Air spraying	1.2–1.5 mm	3-4 bar (air)	20–25 sec.

⁶⁾ Measured in a DIN 4 mm flow cup

Container sizes

25 kg

Shelf life

24 months after receipt of goods.

Store in a sealed container in a dry place and at room temperature (at most 25°C). Protect from heat sources and direct sunlight. Always keep the containers tightly sealed. Protect the contents from drying out. Dried paint residues and any surface-dried skin are insoluble in the paint and can only be removed by straining.

Minimum shelf life Refer to label

Remark

This technical data sheet is based on extensive development work and years of practical experience. Its content does not constitute a contractual legal relationship. The user/buyer is not released from the responsibility of checking our products to ensure they are suitable for the intended application. In addition, our general terms of business apply.

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