

Approvals and conformities

NORTHROP GRUMMAN

STRYP5480

Aeroglaze K3425 is designed for application on epoxy graphite, other plastic substrates, or over a suitable primer on metal. Aeroglaze K3425 primer/surfacer contains no corrosion-inhibiting pigments and is not suitable for direct applications to metallic substrates.

DIRECTIONS FOR USE

Surface Preparation

Substrates should be slightly sanded to remove burrs and irregular edges. Thoroughly clean the substrate with solvent or water to remove sanding dust. Fill holes or gouges with a suitable surfacer putty prior to application of Aeroglaze K3425.

Mixing

Thoroughly mix Aeroglaze K3425A for 2-3 minutes on a paint shaker prior to adding the Aeroglaze K3425B curative to obtain a uniform mixture. Do not open Aeroglaze K3425B component until it can be combined with Aeroglaze K3425A component, as it is extremely sensitive to atmospheric moisture and will harden. The mix ratio of Aeroglaze K3425A to K3425B is 9:1 by volume or 100:7.82 by weight. The full contents of the Aeroglaze K3425B should be added to the Aeroglaze K3425A container. No induction time is necessary. The pot life of Aeroglaze K3425 is 4 hours at 25°C (77°F) and 50% relative humidity.

Application

Apply Aeroglaze K3425 by conventional or HVLP spray equipment. Brushing is recommended for touch-up application only. Roller application is not advised, as it yields unacceptable results.

For operations that require sanding, the recommended wet film thickness of Aeroglaze K3425 is 101.6-127 micron (4-5 mil), which yields a dry film thickness of approximately 63.5-76.2 microns (2.5-3.0 mil). For non-sanding operations, Aeroglaze K3425 may be applied to a dry film thickness of 38-51 micron (1.5-2 mil). Allow the coating to dry for 1-2 hours between coats. The coverage rate is approximately 24.1 m²/L/mil (980 ft²/gal/mil).

Apply additional coats of Aeroglaze K3425 or a topcoat within 36 hours of application of the previous coat to avoid adhesion failure. If the recoat time is exceeded, sand with fine-grit sandpaper before application of additional coats or a topcoat.

Curing

For operations that require sanding:

Allow the primer to cure for 6 hours at 25°C (77°F) and 50% relative humidity before sanding. After

sanding, clean off the dust with an appropriate solvent such as isopropyl alcohol (IPA). Do not use water. A topcoat may be applied immediately after the sanded surface is cleaned and the cleaning solvent has flashed off. Apply a topcoat within 36 hours of application of Aeroglaze K3425.

Non-sanding Operations:

Allow Aeroglaze K3425 to cure for 1-2 hours at 25°C (77°F) and 50% relative humidity prior to application of a topcoat. Apply a topcoat within 36 hours of application of Aeroglaze K3425.

Clean-Up

Use Aeroglaze 9958 thinner to clean spray equipment immediately after application.

Topcoats

Aeroglaze K3425 primer/surfacer is compatible with Aeroglaze and Chemglaze polyurethane topcoats.

TECHNICAL CHARACTERISTICS

Typical Properties*

	Aeroglaze K3425A	Aeroglaze K3425B	Mixed
Solids Content ASTM D 2369-87 modified	75.6% by weight 56.8% by volume	100.0% by weight 100.0% by volume	77.4% by weight 61.1% by volume
Density, kg/L (lb/gal) ASTM D 1475-85	1.59 (13.25)	1.12 (9.33)	7.54 (12.86)
Viscosity, cP Brookfield RVT, spindle #2 10 RPM @ 25°C (77°F)	80	2100	200
Flash Point, seta, °C (°F) ASTM D 3278-82, Closed Cup	26.7 (80)	>93 (>200)	-
Volatile Organic Content (VOC), g/L (lb/gal) ASTM D 3960-87	387 (3.23)	0	349 (2.91)
Dry Film Coating Weight, g/ft ² /mil	-	-	349 (2.91)

**Data is typical and not to be used for specification purposes.*

Chemical Resistance

Fluids tested according to ASTM D 1308-87 immersion test conditions.

Fluids Tested	Passes
Distilled Water	30 days
Hydraulic fluid MIL-H-5606	30 days
Hydraulic fluid MIL-H-83282	30 days
Hydraulic fluid Skydrol LD4	30 days
JP-10-MIL-P-87107	30 days

PRECAUTIONS FOR USE AND STORAGE

The shelf life of Aeroglaze K3425A and Aeroglaze K3425B is one year from the date of shipment when stored in the original, unopened container at 25°C (77°F) and 50% relative humidity. Do not store or use near heat, sparks, or open flames. It is not recommended to store partial containers of Aeroglaze K3425A or K3425B. Aeroglaze K3425B will harden after exposure to moisture.

Before using this or any SOCOMORE product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Manufactured for SOCOMORE by: LORD Corporation, Saegertown, PA.

This technical data sheet replaces and cancels the previous one.

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