



Aeroglaze® K3425 Gray Sandable Primer/Surfacer

Typical Properties* of Aeroglaze K3425 Primer/Surfacer

	Aeroglaze K3425A	Aeroglaze K3425B	Mixed
SOLIDS CONTENT, ASTM D 2369-87 modified			
% by weight	75.6	100.0	77.4
% by volume	56.8	100.0	61.1
DENSITY ASTM D 1475-85			
kg/liter	1.59	1.12	7.54
lb/gallon	13.25	9.33	12.86
VISCOSITY, Brookfield RVT, spindle #2 10 RPM @ 25°C (77°F)			
cP	80	2100	200
FLASH POINT ASTM D 3278-82, Setaflash, Closed Cup			
°C	26.7	>93	--
°F	80	>200	--
VOLATILE ORGANIC CONTENT (VOC), ASTM D 3960-87			
g/liter	387	0	349
lb/gallon	3.23	0	2.91
THEORETICAL COVERAGE			
m ² /liter/25.4 µm	--	--	24.1
m ² /gallon/25.4 µm	--	--	90.9
ft ² /gallon/mil	--	--	980
COATING FILM DRY WEIGHT			
gm/ft ² /mil	--	--	4.61
lbs/ft ² /mil	--	--	0.0102

Basic Use

For application on epoxy graphite or other plastic substrates or over a suitable primer on metal.

Limitations - Aeroglaze® K3425 primer/surfacer contains no inhibiting pigments and is not suitable in direct-to-metal applications.

Surface Preparation

Substrates should be slightly sanded to remove burrs and irregular edges. Then wipe clean with solvent or water to remove sanding dust. Fill holes or gouges with a suitable surfacer putty prior to application of primer/surfacer.

Color

Medium Gray

Packaging

Aeroglaze K3425A 1 gallon cans - 90% full
 Aeroglaze K3425B 1 pint - 80% full

Mixing

Mix Aeroglaze K3425A primer/surfacer well before adding the Aeroglaze K3425B curative to obtain a uniform mixture. No induction time is necessary.

Mix Ratio

	Volume	Weight
Aeroglaze K3425A	9	100.0
Aeroglaze K3425B	1	7.82

Application

Aeroglaze® K3425A base should be thoroughly agitated for a period of 2 - 3 minutes on a paint shaker prior to opening to ensure that a homogeneous mixture is obtained. Aeroglaze K3425B curative does not require agitation. The correct mixing ratio must be used to ensure proper results. For application, mix 1 part by volume (7.82 parts by weight) of Aeroglaze K3425B curative to 9 parts by volume (100 parts by weight) of Aeroglaze K3425A. Aeroglaze K3425A base will not dry if Aeroglaze K3425B curative is not used or improperly mixed with part A.

Aeroglaze K3425 can be applied as received by conventional spray or HVLP spray equipment. Brushing is recommended for touch-up application only. Roller application is not advised as it yields unacceptable results. To obtain the best results, spray apply in one coat of 101.6 - 127.0 wet microns (4 - 5 wet mils). This

product information

will yield a dry film thickness of approximately 63.5 - 76.2 microns (2.5 - 3.0 mils). Allow 1 - 2 hours of dry time between coats. Application of subsequent coats after 36 hours will require mechanical abrasion of the previous coat to ensure good adhesion properties between the two coats.

Clean all equipment immediately after use with Aeroglaze 9958 thinner.

Curing Conditions

Aeroglaze K3425 primer/surfacer dries to a sandable condition in 6 hours at 25°C (77°F) and 50% relative humidity.

Thinners

Due to varied VOC limitations among states, thinning is not recommended. Consult local VOC regulations to determine if limitations apply.

If thinning is necessary for your application and not restricted by VOC limitations, use Aeroglaze 9958 thinner (refer to Bulletin DS10-7425).

Usable Pot Life

When mixed, Aeroglaze K3425A primer/surfacer and K3425B curative have a 4 hour pot life at 25°C (77°F) and 50% relative humidity.

Recoat Time

For operations requiring sanding:

- After applying Aeroglaze K3425 primer/surfacer, wait 6 hours to sand.
- Follow surface preparation instructions on this data sheet.
- Topcoating can be done immediately following sanding.

Values stated in this bulletin represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Service Department.

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Note: If time frame between application and sanding exceeds 36 hours, sand with fine grit sandpaper before topcoating.

Non-sanding operations:

- Topcoat Aeroglaze K3425 primer/surfacer within 1 to 2 hours of application.

Clean-Up

Use Aeroglaze 9958 thinner (refer to Bulletin DS107425).

Topcoats

Aeroglaze K3425 primer/surfacer may be topcoated with Aeroglaze aliphatic two package polyurethane systems, Chemglaze® aliphatic A-Line coatings, and Chemglaze aromatic Z-Line coatings.

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

Shelf Life/Storage

Aeroglaze K3425A primer/surfacer and Aeroglaze K3425B curative have a one (1) year shelf life when stored in the original containers at 25°C (77°F) and 50% relative humidity.

Cautionary Information

Before using this or any Lord product, refer to the Material Safety Data Sheet (MSDS) 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.

For additional information, contact Lord Corporation at: 814/868-3611 ext. 3277, FAX: 814/864-3452 or write: Lord Corporation, 2000 West Grandview Blvd., P.O. Box 10038, Erie, PA 16514-0038.

