

DuPont™ 18560S™ Alumistick Epoxy Primer

Type

DuPont™ 18560S™ is a chromate-free corrosion-resistant epoxy primer

Description

DuPont™ 18560S™ is a two component non-isocyanate non-sanding primer with superior corrosion resistance and excellent adhesion for direct to aluminum applications. This primer has a ready-to-spray VOC of 2.1 lbs/gal.

Recommended Uses

DuPont™ 18560S™ is recommended for use as a metal treatment for aluminum under DuPont primer surfacers when applied over cleaned aluminum. It is not intended for use below the waterline.

DuPont™ 18560S™ is recommended for use with:

Primers Corlar® 18510S™ Epoxy Primer
 Corlar® 18515S™ High Build Epoxy Primer

General Information for Use

Components

DuPont™ 18560S™ Alumistick Epoxy Primer
 DuPont™ 18160S™ Alumistick Epoxy Activator

Mix Ratio

Thoroughly mix DuPont™ 18560S™ Alumistick Epoxy Primer prior to activation. Combine components and then mix thoroughly.

Two Component System

DuPont™ 18560S™ Alumistick Epoxy Primer
 DuPont™ 18160S™ Alumistick Epoxy Activator

Parts by Volume

2
1

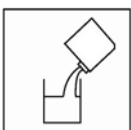
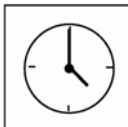
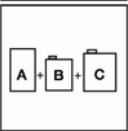
Viscosity will be 20-22 seconds in a Zahn #2 cup.

Pot Life and Induction Time

Pot life is 12 hours at 70°F (21°C). Approximately 6 hours at 90°F.
 Induction time is 15 minutes.

Additives

None recommended





Guidelines for Use

Substrates and Surface Preparation

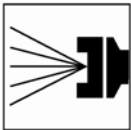
Preferred Preparation: Clean aluminum until water-break free. Remove dirt, waxes, greases with suitable detergent. Remove salts and other contaminants with fresh water and appropriate cleaners. DA sand aluminum substrate with 80 grit until a uniform silver appearance is obtained. Blow all residue from the surface. An alternative preparation is to clean the aluminum surface and treat the aluminum with an appropriate conversion coating (Alodine 600 for example). It is recommended that primer be applied as soon as possible to cleaned surfaces to avoid surface contamination.



Gun Setup

DuPont™18560S™ Alumistick Epoxy Primer can be applied with conventional and HVLP spray equipment using pressure pot, siphon or gravity fluid delivery

<i>Conventional</i>	<i>Fluid Tip</i>
Pressure Pot	1.0mm - 1.2mm (.039" - .047")
Siphon Feed	1.6mm - 1.8mm (.063" - .071")
Gravity Feed	1.4mm - 1.6mm (.055" - .063")
HVLP	
Pressure Pot	0.8mm – 1.0mm (.031" - .039")
Siphon Feed	1.9mm – 2.1mm (.075" - .083")
Gravity Feed	1.4mm – 1.5mm (.055" - .059")

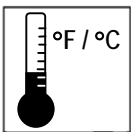


Fluid Delivery

Conventional	12 - 14 oz/min
HVLP	10 - 12 oz/min

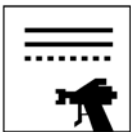
Air Pressure

Conventional	30 – 40 psi @ the gun
HVLP	8 – 10 psi @ the gun cap



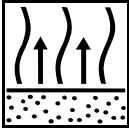
Environmental Conditions

Substrate and ambient temperature must be between 55°F (13°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%. Heating activated material above 110°F (43°C) may cause gelation.



Application

Apply one medium wet coat. Film build should be 0.8 – 1.2 mils as a non-sanding primer over aluminum. Up to two coats (2.0 – 2.2mils) can be applied, which will slow down dry times. Eight to 10 mils of DuPont Epoxy primer should overcoat DuPont™13560S™ Alumistick Epoxy Primer for maximum corrosion protection.



Dry Times

Air Dry at 70°F (21°C)

Dependent upon film builds and ambient conditions

Dry to nib sanding	30 – 60 minutes
Dry to over-coating	30 -40 minutes (1 coat) 50 – 60 minutes (2 coats)



Recoat

DuPont™ 18560S™ may be recoated at any stage of cure. DuPont™ 18560S™ can be topcoated with Corlar® 18510S™ Epoxy Primer or Corlar® 18515S™ High Build Epoxy Primer within 2 days air dry without sanding. If DuPont™18560S™ is baked or air dried longer than 2 days, it must be sanded with P400 – P600 before topcoating.



Cleanup Solvents

Use DuPont™ 3642S™ Thinner or Nason® 481-16™ for clean up.

Physical Properties

	<u>Less Exempts (LE)</u>	<u>As Packaged (AP)</u>
DuPont™ 18560S™ Epoxy Primer	2.1 lbs/gal	1.1 lbs/gal

Factory-Packaged Primer

Color	Gray (Value Shade 4)
Closed Cup Flash Point	See MSDS
Shelf Life	2 years (Unopened at 50° – 110°F)

Ready-to-Spray

Theoretical Coverage	570 ft ² /gal at 1 mil dry film thickness
Weight Solids	49.6%
Volume Solids	35.6%
Gallon Weight	11.8

Dry Film

Gloss	Satin
Recommended Film Thickness	.8 – 1.2 mils mils dry

Coating Performance

Adhesion	Excellent
Corrosion Resistance	Very Good
Chemical and Solvent Resistance	Excellent
Humidity Resistance	Excellent

Safety and Handling

For industrial use only by professional, trained painters. Not for sale to use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Do not allow material or overspray to enter drains or waterways.

E-R 4768/K-17661
Revised 12/2007