

### Approvals and conformities

NORTHROP GRUMMAN

STRYP5480

For application on epoxy graphite or other plastic substrates or over a suitable primer on metal. Aeroglaze® K3425 primer/surfacer contains no inhibiting pigments and is not suitable in direct-to-metal applications. Color: Medium Gray.

### Packaging

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

## DIRECTIONS FOR USE

### 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.

### Mixing

Aeroglaze K3425A - Volume: 9, Weight: 100.0

Aeroglaze K3425B - Volume: 1, Weight: 7.82

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

### 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 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.

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.

#### Cleanup

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.

## TECHNICAL CHARACTERISTICS

### Typical Properties\* of Aeroglaze K3425 Primer/Surfacer

	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 ASTM D 1475-85	1.59 kg/L (13.25 lb/gal)	1.12 kg/L (9.33 lb/gal)	7.54 kg/L (12.86 lb/gal)
VISCOSITY, Brookfield RVT, spindle #2 10 RPM @ 25°C (77°F)	80cP	2100cP	200cP
FLASH POINT ASTM D 3278-82, Setafash, Closed Cup	26.7°C (80°F)	>93°C (>200°F)	-
VOLATILE ORGANIC CONTENT (VOC), ASTM D 3960-87	387 g/L (3.23 lb/gal)	0	349 g/L (2.91 lb/gal)
THEORETICAL COVERAGE	-	-	24.1 m <sup>2</sup> /liter/25.4 μm 90.9 m <sup>2</sup> /gallon/25.4 μm 980 ft <sup>2</sup> /gallon/mil
COATING FILM DRY WEIGHT	-	-	4.61 gm/ft <sup>2</sup> /mil 0.0102 lbs/ft <sup>2</sup> /mil

#### 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***

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Aeroglaze K3425A primer/surfacers 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.

Before using this or any SOCOMORE 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.

Manufactured for SOCOMORE by: LORD Corporation, Saegertown, PA

**This technical data sheet replaces and cancels the previous one.**

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