



ACRYLIC WATERBORNE BONDING PRIMER

K-Z6650

Acrylic Waterborne Bonding Primer is a waterborne, adhesion-promoting bonding primer for application over hard, slick, glossy surfaces and previously painted surfaces. It is ideal for pre-finished metal siding containing Fluorocarbon (Kynar), Polyester Polymers and Silicone Polyester. Designed for both new construction and maintenance applications. Must be topcoated with a water-based topcoat.

- ✓ Single component
- ✓ Corrosion resistant
- ✓ Promotes adhesion
- ✓ Acceptable for use in high performance architectural applications
- ✓ Interior and exterior use

INDUSTRIAL USE ONLY! AS OF 01/01/16 COMPLIES WITH:

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|--|---|
| <input checked="" type="checkbox"/> OTC | <input checked="" type="checkbox"/> CARB |
| <input checked="" type="checkbox"/> EC | <input checked="" type="checkbox"/> LADCO |
| <input checked="" type="checkbox"/> SCAQMD | |

krylonindustrial.com

1-800-247-3266

Revised June 2016

RECOMMENDED USES

Use this product on previously painted surfaces and properly prepared pre-finished siding such as:

- Fluorocarbons (Kynar)
- Polyester Polymers
- Silicone Polyester

RECOMMENDED SYSTEM

Pre-Finished Siding (Fluorocarbon, Silicon Polyester, Polyester Polymers):

1 coat Krylon® Industrial Acrylic Waterborne Bonding Primer

2 coats Krylon® Industrial Waterborne Acrylic Enamel or Krylon® Industrial PreCat Epoxy

Previously Painted Hard, Slick Or Glossy Surfaces:

1 coat Krylon® Industrial Acrylic Waterborne Bonding Primer

2 coats Krylon® Industrial Waterborne Acrylic Enamel or Krylon® Industrial PreCat Epoxy

Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 2–3 square feet. Allow to dry thoroughly for one week before checking adhesion.

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in U.S.) or contact your local health authority.

Surface must be clean, dry and in sound condition. Remove all oil, dust, grease, dirt, loose rust and other foreign materials to ensure adequate adhesion. **Do not use hydrocarbon solvents for cleaning.**

Pre-Finished Siding (Fluorocarbon, Silicone Polyester, And Polyester Polymers):

Remove oil, grease, dirt, oxides, and other contaminants from the surface by cleaning per SSPC-SP1 or water blasting per NACE Standard RP-01-72 (caution: excessive blasting pressure may cause warping). Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 2–3 square feet. Allow to dry thoroughly for one week before checking adhesion.

Previously Painted Surfaces:

Remove oil, grease, dirt, oxides, and other contaminants from the surface by cleaning per SSPC-SP1 or water blasting per NACE Standard RP-01-72 (caution: excessive blasting pressure may cause warping). Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 2–3 square feet. Allow to dry thoroughly for one week before checking adhesion.

PERFORMANCE TIPS

- Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.
- When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.
- During the early stages of drying, the coating is sensitive to rain, dew, high humidity and moisture condensation. Plan painting schedules to avoid these influences during the first 16–24 hours of curing.
- Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions and excessive film build.
- Excessive reduction of material can affect film build, appearance and adhesion.
- Acrylic Waterborne Bonding Primer is extremely sensitive to hydrocarbon-containing solvents. When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. Do not use hydrocarbon-containing solvents.
- Product must be topcoated.
- Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.
- Always check for compatibility of the previously painted surface with the new coating by applying a test patch of 23 square feet. Allow to dry thoroughly for one week before checking adhesion.

CLEAN UP

Clean spills and spatters immediately with soap and warm water. Clean hands and tools immediately after use with soap and warm water. After cleaning, flush spray equipment with mineral spirits to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using mineral spirits.

TECHNICAL DATA

Vehicle	Acrylic
Finish	Flat (0–5 units @ 85°F)
Color	White
Flash Point	> 200°F (93°C), PMCC, mixed
Volume Solids	43 ± 2%
Weight Solids	57 ± 2%
Weight/Gallon	11.2 lb/gal
VOC (less exempt solvents)	< 50 g/L (0.42 lb/gal) as per 40 CFR 59.406
Spread Rate	135–335 sq. f. per gallon
Rec. film thickness	Wet mils: 5-12 Dry mils: 2-5
Application	Apply by airless or conventional spray, brush or roller Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.
Shelf Life	36 months, unopened
Drying Time	@ 18 mils wet, 50% RH Note: Drying times are temperature, humidity and film thickness dependant. @ 50°F @ 77° @ 120°F
To Touch:	1 hour 40 mins 20 mins
To Handle:	6 hours 4 hours 2 mins
To Recoat:	8 hours 4 hours 2 mins
To Cure:	7 days 4 days 3 days
Reduction	Water
Clean-Up	Soap & Water
Tinting	Do not tint
Sizes	1 gallon, 5 gallon

APPLICATION

Temperature	(air, surface and material) 50°F min, 120°F max, at least 5°F above dew point
Relative humidity	85% maximum
Airless Spray	
Pressure	2400 psi
Hose	1/4" - 3/8" ID
Tip	.017"–.019"
Filter	60 mesh
Reduction	As needed up to 12.5% by volume

APPLICATION CONTINUED

Conventional Spray

Gun	Binks 95 (or similar)
Fluid Nozzle	66
Air Nozzle	63 PD
Atomization Pressure	60 psi
Fluid Pressure	25 psi
Reduction	As needed up to 12.5% by volume
Brush	
Brush	Nylon/polyester
Reduction	Not recommended
Roller	
Cover	3/8" woven with solvent-resistant core
Reduction	Not recommended

PHYSICAL TEST DATA

Provides performance comparable to products meeting federal specification TT-F-1098D Type 1

System Tested

Substrate	Pre-fi nished siding
Surface Preparation	SSPC-SP1
Finish	1 coat Acrylic Waterborne Bonding Primer
Adhesion	
ASTM D4541	325 psi

Direct Impact Resistance

ASTM D2794	160 in-lb
Flexibility	
Method	ASTM D522, 180° bend, 1/8" mandrel
Result	Passes

Moisture Cond. Resistance

Method	ASTM D4585, 100°F, 500 hours
Result	Excellent

Pencil Hardness

ASTM D3363	3B
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Salt Fog Resistance (over Iron Guard Primer)

ASTM B117, 1000 hours	Excellent
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Thermal Shock

ASTM D2246, 15 cycles	Passes
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The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of Krylon Industrial. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Krylon Industrial dealer or representative to obtain the most recent Product Data Sheet.