N54628/MB518 Chromated Wash Primer

TECHNICAL DATA SHEET

Product Description

N54628/MB518 is a chromated wash primer designed to provide high resistance to filiform corrosion when applied over a range of light weight alloys.

- Two-pack, ambient curing wash primer
- High resistance to filiform corrosion
- Excellent adhesion between polyurethane primers & variety of light alloys and steel

Components

Mix Ratio (by volume)

- 7690/5461 (Base) 4 parts
- 0833/9000 (Activator) 1 part
- 0908/9000 (Thinner) to viscosity

Specifications

N54628/MB518 is qualified to:

- WL 5.7002

Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.

Surface Preparation and Pretreatment

Ensure the surface is clean, dry and intact using a high performance solvent cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Instructions for Use

Hand stir or mechanically shake base material until all components are uniformly dispersed. Add activator to base component and mix thoroughly. Add thinner while stirring.

Note: All products and components should be placed in ambient conditions of 15-30°C (59-86°F) for at least 24 hours prior to mixing and application.
N54628/MB518 Chromated Wash Primer

**Induction Time:**
15 minutes

**Viscosity:** (23°C/73°F)
- AFNOR4: 18 - 30 seconds
- BSB4: 20 - 35 seconds
- DIN4: 15 - 23 seconds
- FORD4: 14 - 27 seconds
- ISO4: 32 - 58 seconds
- ZAHN2: 25 - 38 seconds

*Note: Viscosities quoted are typical ranges obtained when using specified mix ratio.*

**Pot Life:**
8 hours @ 21 - 25°C (70 - 77°F)

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**Application Guidelines**

**Recommended Application Conditions:**
Temperature: 15 - 30°C (59 - 86°F)
Relative Humidity: 30 - 75%

**Application:**
Apply 1 coat to achieve the recommended 6-10 µm dry film thickness

**Theoretical Coverage:** (unthinned)
16 m²/Lt @ 8 µm dry film thickness
640 ft/US gal @ 0.32 mil dry film thickness

**Recommended Dry Film Thickness:**
6 - 10 µm
0.24 - 0.4 mil

**Dry Film Density:**
1.88 g/cm³
15.7 lbs./US gal
N54628/MB518 Chromated Wash Primer

Dry Film Weight:
15 g/m² @ 8 µm dry film thickness
0.003 lbs/ft² @ 0.32 mil dry film thickness

Note: These application guidelines represent PPG’s best advice for usage in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.

Equipment:

<table>
<thead>
<tr>
<th>Equipment Type</th>
<th>Tip Size</th>
<th>Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>Conventional Spray</td>
<td>1.0 to 1.5 mm</td>
<td>44 to 73 psi (3 to 5 bar)</td>
</tr>
</tbody>
</table>

Equipment Cleaning:
Clean spray equipment before use and as soon as possible after use. DeSoto® CN20, CN44 or Desoclean™ 45 solvent cleaners are recommended.

Physical Properties

Colour:
Yellow

Gloss:
Not Applicable

<table>
<thead>
<tr>
<th>DRYING TIMES @ 50% R.H</th>
<th>23°C (73°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust Free</td>
<td>10 minutes</td>
</tr>
<tr>
<td>Maskable</td>
<td>1 hour</td>
</tr>
<tr>
<td>Force Dry</td>
<td>15 minutes</td>
</tr>
<tr>
<td>Overcoating</td>
<td>1 hour (min.)</td>
</tr>
<tr>
<td></td>
<td>72 hours (max.)</td>
</tr>
<tr>
<td>Full Cure</td>
<td>7 to 9 days</td>
</tr>
</tbody>
</table>

Note: Drying times listed above are dependent upon film thickness applied, air flow conditions and application technique.

Flash Off Time:
15 minutes prior to force dry
N54628/MB518 Chromated Wash Primer

**VOC: (ASTM)**

<table>
<thead>
<tr>
<th>Component</th>
<th>VOC (g/Lt)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mixed unthinned</td>
<td>710</td>
</tr>
<tr>
<td>7690/5461 Base Component</td>
<td>695</td>
</tr>
<tr>
<td>0833/9000 Activator</td>
<td>780</td>
</tr>
<tr>
<td>0908/9000 Thinner</td>
<td>840</td>
</tr>
</tbody>
</table>

**Flash Point:**

<table>
<thead>
<tr>
<th>Component</th>
<th>Flash Point</th>
</tr>
</thead>
<tbody>
<tr>
<td>7690/5461 Base Component</td>
<td>16°C (61°F)</td>
</tr>
<tr>
<td>0833/9000 Activator</td>
<td>20°C (68°F)</td>
</tr>
<tr>
<td>0908/9000 Thinner</td>
<td>3.5°C (38°F)</td>
</tr>
</tbody>
</table>

**Shelf Life:**

<table>
<thead>
<tr>
<th>Component</th>
<th>Shelf Life</th>
</tr>
</thead>
<tbody>
<tr>
<td>7690/5461 Base Component</td>
<td>24 months in original unopened container</td>
</tr>
<tr>
<td>0833/9000 Activator</td>
<td>24 months in original unopened container</td>
</tr>
<tr>
<td>0908/9000 Thinner</td>
<td>10 years in original unopened container</td>
</tr>
</tbody>
</table>

*Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.*

*Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.*

**Storage Recommendations**

Inspect the condition of the container to ensure compliance. The material should be stored at temperatures between 5°C to 35°C (41°F to 95°F) to ensure shelf life.

*Note: When procuring to a qualified material specification, follow those storage instructions.*
Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call the local PPG office at the numbers listed below:

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ASC – Australia
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