



N54628/MB518 Chromated Wash Primer

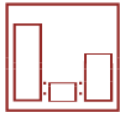
TECHNICAL DATA SHEET

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



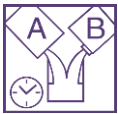
Induction Time:

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)

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

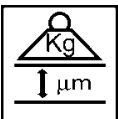


Theoretical Coverage: (unthinned)

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:



Equipment Type	Tip Size	Pressure
Conventional Spray	1.0 to 1.5 mm	44 to 73 psi (3 to 5 bar)

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

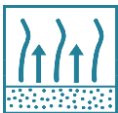


Gloss:
Not Applicable



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

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)

Mixed unthinned	710 g/Lt
7690/5461 Base Component	695 g/Lt
0833/9000 Activator	780 g/Lt
0908/9000 Thinner	840 g/Lt



Flash Point:

7690/5461 Base Component	16°C (61°F)
0833/9000 Activator	20°C (68°F)
0908/9000 Thinner	3.5°C (38°F)

Shelf Life:

7690/5461 Base Component	24 months in original unopened container
0833/9000 Activator	24 months in original unopened container
0908/9000 Thinner	10 years in original unopened container

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.



N54628/MB518 Chromated Wash Primer

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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