

Approvals and conformities

NASA	MSFC-PROC-547 Rev E
OTAN/NATO	8010-01-228-3161 (gallon kit)

Aeroglaze 9924 two-component wash primer is designed for priming bare metal surfaces, particularly non-ferrous substrates such as aluminum. Aeroglaze 9924 contains hexavalent chromium.

Features & Benefits

- Meets military performance requirements of MIL-C-8514.
- **Excellent Adhesion:** provides excellent adhesion to aluminum, properly prepared steel, and galvanized steel.
- **Corrosion Resistant:** provides superior corrosion protection. When used in conjunction with Aeroglaze polyurethane coatings and/or Aeroglaze epoxy primers, primer provides outstanding durable properties.
- **Infinite Recoat Time:** no maximum recoat time as long as the primed surface remains free of dirt, grease, and other surface contaminants and is protected from exposure to water.

DIRECTIONS FOR USE

Surface Preparation

Thoroughly clean surfaces prior to primer application to remove all dirt, oil, grease, and oxides. Different substrates require specific surface preparation methods as listed below.

Perform an adhesion test prior to priming special alloys, chemically treated surfaces, or metal surfaces not listed below. Aeroglaze 9924 wash primer is not recommended for use over painted surfaces or chemical conversion treatments.

Ferrous Substrates

Remove all grease, oil, and surface contaminants following SSPC-SP 1 Solvent Cleaning procedures by wiping with a suitable solvent such as Aeroglaze 9958 thinner. Remove all weld splatter and prepare weld seams, rivet heads, and joints using SSPC-SP 3 Power Cleaning procedures. Blast clean the surfaces using a dry, quality blast media to obtain a 51-76 micron (2-3 mil) white metal blast anchor profile. Follow SSPC-SP 5/NACE No. 1 White Metal Blast Cleaning procedures. Blast cleaning must remove all mill scale, rust, and old paint. Remove all blast material and dust from the prepared surfaces by brushing, filtered air blow-off, or vacuuming prior to primer application. Apply Aeroglaze 9924 wash primer to blast-cleaned surfaces immediately after the surface has been prepared. Blushing or flash rusting will occur very quickly if prepared surface is left exposed to humid air.

Non-Ferrous Substrates

Except for stainless steel, most non-ferrous substrates such as aluminum, some alloys, and galvanized steel are too soft to blast clean. Use SSPC-SP 1 Solvent Cleaning procedures to prepare these substrates. Perform an adhesion test to ensure Aeroglaze 9924 wash primer will adhere to prepared alloys.

Anodized or Chemically Treated Non-Ferrous Substrates

Abrade the surface by sanding or abrasive blast cleaning to expose bare metal. Aeroglaze 9924 wash primer will not adhere unless bare metal is exposed. If sanding or abrasive blast cleaning cannot be performed, contact your Socomore representative for an appropriate primer recommendation.

Mixing

The mix ratio of Aeroglaze 9924 wash primer is 1:1 by volume. Thoroughly stir Aeroglaze 9924A component before use. While stirring, add 1/3 of Aeroglaze 9924B component and mix well. Add the rest of Aeroglaze 9924B component in two additions, stirring well after each addition. Dilute up to 20% by volume with Aeroglaze 9958 thinner to control the application film thickness. The exact thinning percentage is dependent on the spray system properties. Add the thinner while stirring the mixed primer. After the wash primer is thinned and uniformly mixed, use immediately. The working life of Aeroglaze 9924 wash primer is 8 hours. After 8 hours, discard any mixed primer. Even though the primer may still be liquid, it will no longer adhere to a substrate.

Application

Aeroglaze 9924 is best applied by HVLP spray equipment. The optimum dry film thickness of Aeroglaze 9924 wash primer is 6.4-12.7 micron (0.25-0.5 mil). Airless spray equipment can be used, provided a maximum of 12.7 micron (0.5 mil) dry film thickness is not exceeded. Excessively thick films of primer will fail cohesively. Aeroglaze 9924 wash primer must be applied in a single wet pass with a 50% overlap. Hold the gun at right angles to the surface, approximately 20.3-30.5 cm (8-12 in) away, and apply in even, parallel passes. The coverage rate is 8.4-18.3 m²/L (352-704 ft²/gal).

Drying/Curing

Allow the primer to thoroughly dry before topcoating. All corners and recesses of primed part(s) must be completely dry or poor adhesion of the topcoat will result. Use explosion-proof fans on primed parts with detailed geometry to remove solvents and accelerate drying.

Depending on conditions, Aeroglaze 9924 will dry in 2-3 hours at 18-24°C (65-75°F). High humidity conditions and low temperatures will slow drying. Aeroglaze 9924 wash primer dries to a dull, matte appearance. The substrate should be visible through the primer. Once dry, primed surfaces can be topcoated with Aeroglaze polyurethane coatings.

Clean-Up

Use Aeroglaze 9958 thinner to clean equipment. Thoroughly clean spray equipment immediately after use.

TECHNICAL CHARACTERISTICS

Typical Properties*

	Aeroglaze 9924A	Aeroglaze 9924B	Mixed
Appearance	Red Liquid	Clear Liquid	Red
Viscosity, cps @ 25°C (77°F) ASTM D 2196-66, Brookfield LVT	1000-5000 Spindle 3, 12 rpm	~10 Spindle 1, 60 rpm	225 Spindle 3, 12 rpm
Density ASTM D 1475-85, kg/L (lb/gal)	1.03-1.08 (8.6-9.0)	0.93-0.97 (7.80-8.10)	0.99 (8.3)
Solids Content by Weight, % ASTM D 2369-87 modified	31-36	-	17.4
Flash Point (Seta), °C (°F) ASTM D 3278-82, Closed Cup	31 (88)	20 (69)	-
Volatile Organic Content (VOC), g/L (lb/gal) ASTM D 3960-87	698 (5.83)	921 (7.68)	803 (6.7)
Working Life, hr	-	-	8

*Data is typical and not to be used for specification purposes.

PRECAUTIONS FOR USE AND STORAGE

The shelf life is six months for Aeroglaze 9924A component and one year for Aeroglaze 9924B component from date of shipment when stored in a dry, well-ventilated area at temperatures under 27°C (80°F) in the original, unopened container. Do not store or use near heat, sparks, or open flames.

Before using this or any SOCOMORE product, refer to the Safety Data Sheet (SDS) 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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