

Approvals and conformities

MIL-SPECS	MIL-C-8514C (Yellow)
MIL-SPECS	DOD-P-15328D (Green)

SOCOGLAZE PT-402 Acid Etching Primer, when properly reduced with **SOCOGLAZE PT-1045** Reducer, meets and exceeds MIL-C-8514C & DOD-P-15328D. SOCOGLAZE PT-402 is a polyvinyl butyral zinc chromate formulation that may be used to prime all plain or plated metallic surfaces. Priming surfaces with SOCOGLAZE PT-402 Acid Etching Primer prior to priming with epoxy primer MIL-PRF-23377 or by itself will ensure maximum adhesion and protection of all bake or air-dry finish coats (including lacquer finish coats). The finely ground emulsions of zinc chromate pigments, resins and phosphoric acid hardeners are virtually non-settling. Once applied, the Acid Etching Primer requires no sanding and has a pot life of 8 hours. Extreme humidity can affect the bonding of the coating.

Color	Specification	Reference
GREEN	DOD-P-15328D	101019
YELLOW	MIL-C-8514C	101081

Available in liquid

USES

Please, consult us regarding **SOCOMORE** solutions for:

- Surface preparation (SOCOCLEAN, DIESTONE & DS ranges),
- Functionalized coatings (SOCOGLAZE, AEROGLAZE, CHEMGLAZE, PRIAM, LBYH ranges),
- Surface treatment (SOCOCLEAN & SOCOSURF ranges),
- Adhesion promotion (SOCOGEL & PREKOTE ranges)
- Chemical stripping (SOCOSTRIP & SPC ranges)

DIRECTIONS FOR USE

Surface Preparation Instructions

- Scuff the surface with scotch bright pads.
- Dust off the surface with an air hose and wand.
- Wipe of the substrate with IPA or Acetone to remove grime and oils
- Remove all remaining dust and debris by lightly wiping the substrate with a tack or “cheese” cloth

Mixing Instructions

Shake component A in a paint shaker for 5 – 10 minutes for optimal results.

Admix by volume:

1. Stir or shake both component “A” and “B” well before mixing
2. Add 4 parts of Component “A” to 1 part of Component “B” by volume and stir thoroughly. Stir each well before mixing.
3. Reduce with **SOCOGLAZE PT-1045**. Dilution ratio is 1 part admixed primer to 2 – 3 parts **SOCOGLAZE PT-1045**.
4. Mix only an amount that can be used in one day.

Application

This product can be applied using conventional air spray equipment, HVLP spray system. Please consult with a SOCOMORE representative for specific equipment recommendations and settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix both base and catalyst thoroughly and filter/strain before spray application.
3. HVLP Spray Pressure: 7-10psi. Conventional spray equipment 15-30psi
4. Always air-blow and tack wipe the surfaces to be painted. Aircraft should be grounded to prevent static.
5. Best application results: apply 1 fog/tack coat at 0.2 mil thickness.
6. Recommended Dry Film Thickness is 0.2 mils.

NOTE: Application of SOCOGLAZE products requires the use of all OSHA approved safety equipment, including proper ventilation. Additionally, SOCOGLAZE products require the recommended temperature/humidity conditions and film thickness ranges for optimal performance.

Drying & Curing Schedule

Dry times are based on the dry film thickness of 0.2 mils (25-50 microns).

Air Dry:

Allow applied coating to dry for at least 15 minutes before painting over it.

Equipment Cleanup

Use clean **SOCOGLAZE-1045** Reducer. Do not allow material to dry or cure inside any equipment.

TECHNICAL CHARACTERISTICS

Coating Properties & Characteristics	
Characteristic	Value
Mix Ratio, by volume	4 part Base to 1 part Catalyst by volume
Reducer	SOCOGLAZE PT-1045 reduce, 1 part paint to 2 – 3 parts reducer
Recommended Dry Film; Thickness	0.2 mil
Admixed Viscosity	14 seconds, max #4 Ford

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Admixed Weight per Gallon	11.5 Lbs
Theoretical Coverage	1600 sq.fr2/gal
Pot Life	8 hours
Coatings VOC	710 g/l max. pkg. Comp A / Comp B 618 g/l max. pkg

PRECAUTIONS FOR USE AND STORAGE

Storage

Shelf life is only applicable for materials stored in unopened and undamaged original factory-filled containers. Can be stored for 12 months when stored between 50 -95 F.(10 -35 C). KEEP AWAY FROM FROST. For more information regarding the danger of the product, please consult the product safety data sheet according to local regulations. For professional use only.

This technical data sheet replaces and cancels the previous one.

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as Socomore deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Pictures are not contractual. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.