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.

**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. 1 coat Krylon® Industrial Acrylic Waterborne Bonding Primer
2. 2 coats Krylon® Industrial Waterborne Acrylic Enamel or Krylon® Industrial PreCat Epoxy

**Previously Painted Hard, Slick Or Glossy Surfaces:**
1. 1 coat Krylon® Industrial Acrylic Waterborne Bonding Primer
2. 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.
**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. ft. 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 roller 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

- @ 50°F: 1 hour
- @ 77°F: 40 mins
- @ 120°F: 20 mins
**To Touch:**
**To Handle:** 6 hours
**To Recoat:** 8 hours
**To Cure:** 7 days
**Reduction** | Water
**Clean-Up** | Soap & Water
**Tinting** | Do not tint
**Sizes** | 1 gallon, 5 gallon

**TECHNICAL DATA**

**APPLICATION**

**System Tested** | Substrate: Pre-finished 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

**Salt Fog Resistance** | (over Iron Guard Primer)
ASTM B117, 1000 hours: Excellent

**Thermal Shock** | ASTM D2246, 15 cycles: Passes

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.