

Autoseal® 3690 Primer

Description

LORD Autoseal® 3690 is an aqueous primer that provides good adhesion to EPDM rubber and various thermo-plastic elastomers.

Features and Benefits

Environmentally Friendly – provides a user friendly, low VOC coating.

Good Adhesion – adheres well to EPDM.

Convenient – applies easily using conventional, siphon, HVLP or needle-less spray methods.

Application

Surface Preparation – Remove oils and other contaminants from surface of the substrate prior to primer application. Surface temperatures between 52-93°C (125-200°F) during primer application aid in proper film characteristics and drying. Application temperatures above 93°C (200°F) can restrict proper wetting of primer onto the substrate.

Mixing – Thoroughly stir Autoseal 3690 primer before using.

Applying – Autoseal 3690 primer should be spray applied. For optimum adhesion, dry film thickness of Autoseal 3690 primer should be 2.5 micron (0.1 mil).

Drying/Curing – Primer adhesion to rubber develops in the topcoat curing oven at temperatures between 149-232°C (300-450°F), with dwell time depending on line speed and oven length. Typically, 3 minutes at 204-232°C (400-450°F) is sufficient.

Cleanup – Use a 50:50 parts blend of water and acetone for clean up. Immediately flush spray guns with water.

Shelf Life/Storage

Shelf life is six months from date of shipment when stored at 21-27°C (70-80°F) in original, unopened container. Do not freeze product. Keep container closed when not in use. Unused primer can be sealed and reused.

Typical Properties*

Appearance	Clear, Opaque Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT	15-35
Density kg/m ³ (lb/gal)	994.5-1030.5 (8.3-8.6)
Solids Content by Weight, %	10.9-13.9
Flash Point, °C (°F)	>93 (>200)

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

LORD TECHNICAL DATA

Cautionary Information

Before using this or any LORD product, refer to the Material Safety Data Sheet (MSDS) 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.

Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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