

ARMIDUR® L158

Spray Primer “Wet-on-Wet” for Factory Coatings

Description

Chromate-free, universally overcoatable primer based on polyester for aluminum and steel substrates. Excellent adhesion, good formability, and corrosion resistance on cold-rolled and galvanized steel, Zincor sheets, as well as aluminum coil.

Specifically developed for spray-priming chromate-free pretreated aluminum parts that are subsequently top-coated wet-on-wet.

In combination with suitable topcoat systems, coatings of the highest weather resistance and flexibility are achieved. Suitable for façades, roller shutters, ceiling panels, gates, shelving, air-conditioning units, blinds, lighting fixtures, electrical housings, transportation applications, packaging strapping, windows or packaging.

Coatings Systems for Wet-on-Wet Applications

Aluminium	for exterior chromated	for interior de-greased + sanded
DFT L158	10 µm	10 µm
Flash-off time	5 – 10 min.	5 - 10 min.
Overcoating	Vernicon L451-L458 or 2K top coats	2K top coats
DFT Top coat	30 – 60 µm	30 – 60 µm
Forced drying 2K coatings	90 Min @ 80 °C	90 Min @ 80 °C

Steel	Sheet steel passivated or cleaned with thinner V42	Zincor sheet and hot-dip galvanising (cleaned with thinner V42)
DFT L158	25 - 30 µm	25 - 30 µm
Flash-off time	15 – 20 min.	15 – 20 min.
Overcoating	2K top coats or stoving enamels	2K top coats or stoving enamels
DFT Top coat	30 – 60 µm	30 – 60 µm
Forced drying 2K coatings	90 Min @ 80 °C	90 Min @ 80 °C
ISO 12944	Coatings systems comply C3 h or C4 m	

Processing and Thinning

Armidur L158 is suitable only as a factory coating, since the entire system must be baked or force-dried afterward.

As soon as Armidur L158 has a uniform matte appearance, it can be overcoated.

Application viscosity: 20 ± 2 s (DIN 4 mm @ 20 °C). Recommended nozzle size for air-conventional atomizing spray application 0.8 – 1.2 mm.

Technical Data Sheet

Binder	Polyester	
Colors	Grey-white	
Substrate	Aluminium + steel (see coating systems) Cleaning/pre-treatment of aluminium for exterior according to DIN EN 12487 with chemical conversion layer. The substrate has to be free of oxidation products, tinder, oil, grease or mold release agents.	
Thinner	V2	
Packaging	18 kg containers / 200 kg drums	
Storage	6 months in original, unopened packaging	
Temperature PMT (substrat temperature)	with stoving enamel 165 °C	with 2K top coat 80 °C
Dwell Time	30 – 45 min.	60 – 90 min.

Solids content	57 ± 3 % by weight 44 ± 3 % by volume	
Density	1,20 ± 0,02 g/ml	
DFT Dry Film Thickness	10 – 30 µm	
Practical Coverage	approx. 100 g/m ² @ 10 µm	

	Armidur L150	Thinner V2
VOC value	approx. 46 %	100 %

06.25

Special Notes

Our instructions are referring to normal climate 23/50. The information contained in this technical data sheet is based on general technical standards and is meant for specialists. Any changes in the recommended operating procedures or specified environmental conditions may have a significant impact on the results. Our guarantee covers only the quality of the material supplied. We do not accept any responsibility for the application. In case of doubt, we recommend contacting our Technical Service. Our products are under constant development. Therefore, please note the date of issue of our technical data sheet and ask for the latest edition (also available directly from our website).

Safety Measures

Armidur L158 contains solvents and is combustible. Protect from heat and keep away from naked flames. Ensure that ventilation is adequate. Do not inhale vapours. The Safety Data Sheet as well as the general regulations regarding work hygiene and operational measures must be observed.