

## TECHNICAL DATA SHEET – LINE-X® SF-515 PRIMER

### PRODUCT MANUFACTURER:

LINE-X LLC  
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### DESCRIPTION:

LINE-X SF-515 Primer is an anti-corrosive, low viscosity, solvent-free two-component urethane primer with a long pot life. SF515 is designed for use as adhesion primer for various substrates (i.e. wood, aluminum, fiberglass, etc.) It is formulated as an adhesion primer for LINE-X polyurethane and polyurea spray systems. SF-515 can be top-coated in as little as 5 hours after applied, or as long as 15 hours after applied to substrate. SF-515 can be spray-applied, brushed or rolled.

### FEATURES:

- Solvent Free – Eliminates solvent blisters. Reduces long wait time. No flammability issues.
- Low Viscosity/Long Pot Life – spray with conventional HPLV guns, excellent flow, leveling and pinholes reduction.
- Anti-Corrosive – Significant improvements in corrosion resistance.
- Eliminates corrosion cells caused by pinholes.

### POTENTIAL APPLICATIONS

- Primer for Plywood or Compression Wood
- Urethane

### APPLICATION GUIDELINES:

Both Iso “A” Side and Resin “B” Side of SF-515 primer should be preconditioned between 70° F – 90° F before application.

SF-515 primer can be applied with conventional HPLV gun, brush, or rolled-on.

### MIXING INSTRUCTIONS:

After opening the “B” side can, use paint mixing stick to hand-stir the polyol and pigment to uniform consistency. Mix 1 part of RESIN with 1 part of ISO by volume. Mix by hand or with a mechanical mixer at low speed. DO NOT OVER MIX THE PRODUCT. Care must be taken to avoid introducing air into

the mixture as this will cause foam to generate during primer curing. Mix for approximately 1 minute or less to achieve a uniform mixture.

### POT LIFE AND COVERAGE:

Mix only the quantity needed for immediate use. Be sure to maintain the chemical temperature between 70° F and 90° F to achieve optimum pot life and sprayability.

- Pot life ~ 1 hour – elevated temperature will shorten pot life.
- 2 mils ~ 500 SF/Gallon of Primer

### SURFACE PREPARATION:

- Clean substrates to remove dirt, solvent and contaminants.
- Blow off any excess dirt and contaminants.
- Thoroughly inspect substrates for any visible dirt and contaminants.
- Apply SF-515 approximate 2 – 3 mils thick, enough to cover the surface profile.

### PROPERTIES OF CURED PRODUCT:

Density: 71.0 lbs/ft<sup>3</sup>  
Hardness: ~75 Shore D  
Pull-off Test Adhesion ASTM C297  
LINE-X XS -100:  
SF-515 Primer 1,930 PSI  
LINE-X XS-350:  
SF-515 Primer 1,870 PSI

### OPEN TIME:

Top coated @ 73° F 5 – 15 hours  
Make sure the surface of primer is not tacky and dry to the touch before applying top coat products.

### EQUIPMENT CLEAN-UP:

Spray equipment should be cleaned immediately after use following equipment manufacturer’s recommended procedures. Please refer to spray equipment operating and maintenance procedures for further details. SF-515 Primer should be cleaned with environmentally safe urethane-grade cleaners. Cleaning materials must be free of reactive contaminants such as water and alcohol. All gun cleaners and spray equipment cleaning materials must be used and disposed of as permitted under local rules and regulations.



### **MATERIAL STORAGE:**

SF-515 Primer has a shelf life of twelve (12) months from manufacture date in factory sealed containers. SF-515 Primer should be stored between 65° F – 80° F. Do not expose unused materials to high humidity conditions. Always provide airtight reseal conditions to unused materials.

### **SAFETY AND HANDLING:**

Please refer to MSDS for safety and handling of this material. All personnel working with this material are expected to read and understand all safety recommendations per MSDS. All personal protection equipment must be properly worn to comply with worker health and safety guidelines.

### **PRODUCT USER RESPONSIBILITIES:**

Users of SF-515 Primer product are responsible for reading the general guidelines, product data sheets, specifications and material safety data sheets (MSDS) before using this material. Printed technical data and instructions are subject to change without notice. Contact your local LINE-X representative or visit our website [www.LineX.com](http://www.LineX.com) for current technical data instructions.

### **PRODUCT DISCLAIMER:**

All guidelines, recommendations, statements, and technical data contained herein are based on information and tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. It is the user's responsibility to satisfy himself, by his own information and test, to determine suitability of the product for his own intended use, application and job situation and user assumes all risk and liability resulting from his use of the product. We do not suggest or guarantee that any hazards listed herein are the only ones which may exist. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements, whether in writing or oral, other than those contained herein shall not be binding upon the manufacturer, unless in writing and signed by

a corporate officer of the manufacturer. Technical and application information is provided for the purpose of establishing a general profile of the material and proper application procedures. Test performance results were obtained in a controlled environment and LINE-X LLC makes no claim that these tests or any other tests accurately represent all environments.

