



# TECHNICAL DATA

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## STYRO-BOND 405 WATERBORNE FLEXIBLE PRIMER/SURFACER

### Product Description

A single package, flexible, primer-surfacer designed primarily for architectural finishes or as a professional refinishing of mold polyurethane or polyureas parts. It provides excellent hold-out and adhesion.

### Features

- Excellent Adhesion
- Fast filling Characteristics
- Sands Easily Without Clogging
- Meets S.C.A.Q.M.D. Rule 1151 requirements for primer type coatings
- Can applied to ABS, Nylon, EPDM, Polycarbonate, Polypropylene, Polyurethane and RIM polyurethane.

### Recommended Uses

Can be topcoated with waterborne architectural finishes, alkyd enamels, acrylic enamels, lacquer and polyurethane enamel systems.

### Typical Properties

<b>Solids by Volume</b>	49% ±1
<b>Volatile Organic Compounds</b>	1.1 lb/gal (134 g/l)
<b>Theoretical Coverage</b>	565 ft <sup>2</sup> /gal @ 1 mil (52 m <sup>2</sup> /gal @ 1mm)
<b>Recommend DFT</b>	1-3 mils (25-75 microns)
<b>Number of coats</b>	Normally one
<b>Shelf Life @ 40-80°F (4-27°C)</b>	6 months
<b>Color</b>	White

### Specification Data

<b>Substrate Adhesion</b> ASTM D-3359	5B
<b>Topcoat Adhesion</b> ASTM D-3359	5A
<b>Water Immersion</b> GM 4466P	Passes 240 hours @ 100%, 100°F(38°C) with no defects*
<b>Flexibility Test</b> GM 9503P	Rated 10 @ 73°F(23°C) and 22°F(-30°C) with no cracking

\*Same panel was tested for adhesion after water immersion with the same results.

### Ordering Information

<b>Packaging:</b>	5 gallon pails
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# APPLICATION INFORMATION

## STYRO-BOND 405

### Surface Preparation

Make sure surface to be coated is free of mold release. Contact the mold release company for instructions.

Rinse thoroughly with water, and then dry with a clean, lint-free towel.

### Mixing

Stir STYRO-BOND 405 thoroughly before using.

### Thinning

No thinning is necessary

### Application

Siphon Feed:

- Air pressure 40-50 psi at gun
- Apply 2-3 medium wet coats
- Allow 10 minutes flash between coats

Gravity Feed:

- Air pressure 40-50 psi at gun
- Apply 2-3 medium wet coats
- Allow 10 minutes flash between coats

### Clean Up

Clean equipment with water immediately after use, followed by a thinner rinse to prevent corrosion in the cup and gun

### Dry Time to Sand

Temperature	Relative Humidity	Dry Time
60°F (15°)	50%	3.5 Hours
	75%	4.0 hours
70°F (21°C)	50%	2.5 hours
	75%	3.0 hours
85°F (29°C)	50%	2.0 hours
	75%	2.5 hours
140°F (60°C)	50%	30 minutes
	75%	45 minutes

- Allow to dry completely before sanding
- Excessive application, low temperatures and high humidity will extend dry times.
- When topcoating directly over STYRO-BOND 405, best results are achieved when finish is sanded with 320-400 grit sandpaper. Sealing is not required.
- Dry times may be reduced with the use of infrared lamps

### Safety Information

- See the Material Safety Data Sheet and product label for details.
- Protect eyes and skin from contact with this product.
- Wear a properly fitted respirator rated for organic solvents in confined spaces; wear a fresh air-supplied fact mask.
- Provide good ventilation throughout the working area at all times.
- **This product is intended for industrial use by properly trained professional applicators only.**

### Storage Conditions

- Coatings need to be protected from moisture contamination store drums and pails in a dry location at 55-8°F (11-27°C).
- Materials must be kept above 50°F (10°C).

ITW FUTURA COATINGS, 1685 GALT INDUSTRIAL BLVD., ST LOUIS, MO, (314) 733-1110

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