



AT 520 - ALPHATEK PRIMER EXTREME

NANO-CERAMIC COATING

APPLICATION INSTRUCTIONS

1. PRODUCT DESCRIPTION

AT 520 is a high performing primer specifically formulated for ultra high temperature applications (up to 1200°F/648°C). It is a VOC exempt solvent-based primer that provides adhesion in a wide variety of demanding environments. It adheres to almost anything and almost anything will adhere to it. AT 520 can be used as a primer on almost any substrate or as an intra-coating adhesive. AT 520 has been formulated for a broad range of uses including automotive exhaust pipes and direct flame contact.

2. SURFACE PREPARATION

- Primer may be applied directly to substrate surfaces where there are concerns regarding proper adhesion.
- Primer may also be used over other (tightly bonded) cured coatings to achieve good intra-coat adhesion.
- Surface cleanliness is extremely important. The surface should be clean, dry and free from oils and other containments.
- For metal & alloy component surfaces, it is preferable to have a light blasted profile if it is possible to do so. Recommended blasting media is 120 grit aluminum oxide, garnet or equivalent.
- Primer covalently bonds well to plastics and almost all types of metal (including aluminum, titanium, stainless steel and metal oxides).
- For composite substrate surfaces, it is preferable to have a very light abraded profile on the surface if it is possible to do so. This will aid in creating the physical bond.
- Gel-coated surfaces should not be abraded as this may damage the substrate.

3. APPLICATION (PRIMER)

- As with any new material, always test application and finished properties on a low value test article or panel before working on valuable surfaces.
- Slightly mix or shake the primer contents before applying. Shaking by hand is acceptable.
- Apply to a dry film thickness of 1-3 microns only. **More is not better.**
- **Spray:** Fine spray tip (0.08) or similar is optimal.
- **Wipe on:** Wet a lint free application cloth and lightly wipe over the substrate surface. If it appears to be too thick, use the same cloth to spread the primer over a larger surface area. A locked mohair roller may also be used.
- If the coating appears to be too thick, quickly use the same cloth or mohair roller to re-wipe and spread the primer over a broader surface area. Do not allow the primer to pool on the surface.
- Primer may be re-applied over itself (re-coated) if it is necessary to do so.



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4. APPLICATION (TOP COAT)

- Apply topcoat within 3 minutes of applying primer. Sooner is better. Wet on wet application is acceptable.
- If the primer dries longer than 3 minutes before top coating, re-apply the primer as above. Then apply the topcoat within the allotted 3-minute time limit.
- Not for use with high gloss finishes as the primer tends to reduce the surface gloss under certain conditions.
- Most topcoats are compatible with the primed surface. Contact your ALPHATEK representative for more information.

7. DRYING & CURING TIMES

Solids	<38%
Drying Time (Regular)	5-10 minutes at 80°F (26.5°C).
Drying Time (Accelerated)	30 seconds at 120°F (49°C).
Always apply top coat prior to primer drying	

8. COVERAGE RATE

Coverage will be approximately 5,160 square feet per gallon (125 square meters per liter) at dry film thickness of 3 microns.

9. STORAGE STABILITY & SHELF LIFE

The shelf life is one year when stored in the original, unopened container. Store containers in a well-ventilated and covered area away from extreme heat and moisture. Contact your ALPHATEK representative if you have any questions about the products or its uses.

10. SAFETY

Refer to the Safety Data Sheet for this product prior to use.