



#### DESCRIPTION

Winbond Combo Glass Paint Primer is an isocyanate and solvent-based primer specially developed to improve the adhesion and maximize the bonding of sealants on low surface energy substrates used in the transportation market and more specifically, glass bonding.

This all-in-one primer is compatible with Winbond polyurethane and hybrid sealants.

#### AREAS OF APPLICATIONS

The surface preparation can be made with Winbond Combo Glass Paint Primer either alone or in combination with Winbond Glass Wipe, to promote adhesion, improve bond durability and provide optimum protection against UV rays on organic or mineral glass.

Winbond Combo Glass Paint Primer is used on glass and silk-screened ceramic frit glass for the bonding of windscreens or glass (on cars, trains, buses, trucks and specialty vehicles) as well as on vehicle body frames.

It acts as a corrosion inhibitor on metal and can be applied on pinch-weld scratches and nicks.

Winbond Combo Glass Paint Primer is also recommended in the marine industry (for windshield or porthole bonding) to prime acrylic (PMMA) or polycarbonate windows, fiberglass and polyester.

Winbond Combo Glass Paint Primer can also be used as a multipurpose primer on many non-porous substrates used in the transportation market, like aluminium, metals, stainless steel, painted surfaces, ABS, wood and PVC).

For applications other than glass bonding, it is recommended to do preliminary adhesion and Compatibility tests - contact our technical service.

#### TECHNICAL DATA

|                                          |                |
|------------------------------------------|----------------|
| Color                                    | Black          |
| Viscosity (DIN cup Ø4 mm, 100,mm at 20°C | 11 to 14s      |
| Density at 20°C                          | 0.95 ± 0.05    |
| Application temperature                  | 5 to 35°C      |
| Drying time                              | 10 to 15 min * |

\* if the temperature is below 20°C, a longer drying time is recommended.

## INSTRUCTIONS FOR USE

### Substrates preparation:

The substrates to be treated must be clean, dry, free of dust or grease.

Contaminated surfaces must be cleaned beforehand with a solvent-based solution with or without the help of an abrasive like 3M SCOTCH BRITE® RED. Let evaporate for 5 minutes before next step.

We recommend treating the glass with the adhesion promoter, Winbond Glass Wipe (see the technical data sheet of the product) before applying Winbond Combo Glass Paint Primer.

Note: when using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer.

### Primer application:

To perfectly homogenize the product, shake thoroughly the bottle until agitator ball is moving, then shake additional 30 seconds. Dip a clean felt tip applicator into the bottle, roll it around the edges of the bottle to squeeze out the excess of product.

Winbond Combo Glass Paint Primer can also be applied with the 10 ml tube with foam applicator. Shake thoroughly the tube for 10 to 15 seconds in order to re-homogenize the product. Exert a uniform and light pressure to get a homogenous and opaque film. Hermetically seal the container immediately after use as this product is very sensitive to moisture. Any contact with humidity will make the primer cure.

On the glass: after drying (10 to 15 minutes \* depending on temperature and moisture conditions) apply the sealant within a one-hour deadline, proceeding according to instructions of its technical data sheet.

If the deadline is not respected or if the film of primer is contaminated (dust, etc.) lightly sand the primed surface, remove the dust and re-prime with Winbond Combo Glass Paint Primer.

On the vehicle: a surface treatment with Winbond Combo Glass Paint Primer is recommended on pinch-weld parts scratched during disassembling of the windscreen as well as on areas where traces of rust are visible. After abrasion followed by a cleaning (solvent), apply Winbond Combo Glass Paint Primer with a clean felt tip applicator to stop corrosion. Respect a drying time of 10 to 15 minutes \*.

\* If the temperature is below 20°C, a longer drying time is recommended.

### Cleaning:

During the few minutes following the application, it is possible to clean with mineral spirits; beyond that time, it is necessary to use a mixture of methylethylketone and toluene or methylethylketone and xylene.

## LIMITATIONS

Do not use if an increase in viscosity or a cured film on surface are observed.

Do not apply on frozen surfaces.

Do not apply Winbond Combo Glass Paint Primer to the existing trimmed polyurethane bead (windshield replacement).

Do not reuse the felt tip applicator.

Do not re-dip the felt tip applicator in the bottle (to avoid contamination).

## CONSUMPTION

Consumption is dependent on the nature of the substrates. Count 80 to 100 ml/m<sup>2</sup> on glass.

## STORAGE AND SHELF LIFE

12 months in unopened original packaging stored at a temperature between 5 and 25°C.

Winbond Combo Glass Paint Primer should be used during the month following the opening of the bottle. This time is reduced if the packaging remains opened or is not closed properly, and more so if temperature and humidity are high. Winbond Combo Glass Paint Primer in tube is intended for single use only and should be used quickly after opening.

#### PACKAGING

30ml, 250ml and 1000ml aluminium bottles.  
10ml tubes.  
Contact us for other packaging options.

#### SAFETY

Professional use.  
Read the material safety data sheet before use.  
Wearing safety glasses and gloves is mandatory.  
Provisional technical data sheet

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions, or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.