

L-319-1

Adhesive Primer / Corrosion Inhibiting



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Product Data Sheet

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Description

L-319-1 is a sprayable adhesive primer with corrosion inhibitors to enhance the life of adhesive bonded structures. L-319-1 may be used with 250°F (121°C) curing epoxy adhesive films without loss of mechanical properties. L-319-1 corrosion inhibiting adhesive primer may be applied with common airless spray equipment with a recirculating sump to prevent solids precipitation.

Advantages of L-319-1

- ❖ The life of bonded aluminum structures may be increased by using L-319-1 to prevent surface corrosion from progressing along the faying surfaces of the adhesive bondline.
- ❖ Aluminum detail parts may be store in the primed condition for up to 30 days prior to bonding without subsequent loss in mechanical properties of resultant bonded structures.

Physical Properties

- *Color :* Yellow
- *Solids Content:* 10%
- *Form:* Sprayable Liquid
- *Caution:* Flammable

Availability

- 1 Gallon (3.8 L)
- 5 Gallon (18.9 L)
- 55 Gallon Drum (208 L)

Shelf Life

- 6 months at 10°F (-12°C) or below
- 2 weeks at 75°F (24°C)



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Application

- *Prior to priming, aluminum detail parts should be cleaned and etched to a water break free condition. The details should be rinsed and dried.*
- *Apply L-319-1 immediately after drying is completed and within a time limit which prevents the reformation of aluminum oxides on the detail surface.*
 - 1) *Allow L-319-1 to reach room temperature before opening the container.*
 - 2) *Mix thoroughly and spray details with a uniform cross coat to a dry film thickness of 0.0001" to 0.0003" (0.0025-0.0076 mm) thick.*
 - 3) *Air dry detail parts for 30 minutes minimum, followed by an oven bake at 250°F (121°C) for 60 minutes.*
 - 4) *The details should be stored in a clean, dry environment prior to lay up and bonding.*

Average Mechanical Properties

Overlap Tensile Shear Strength

Coupons primed with L-319-1 and bonded with L-314 Film Adhesive, cured 1 hour at 250°F (121°C).

ASTM D1002

- *-67°F (-55°C) 6460 PSI (44.4 MPa)*
- *RT 5480 PSI (37.7 MPa)*
- *180°F (82°C) 4340 PSI (29.8 MPa)*
- *250°F (176°C) 2450 PSI (16.9 MPa)*

NOTICE:

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