Alumigrip® 10P8-11
VOC Compliant Epoxy Primer

Product Group
Epoxy primer

Characteristics

Product Information
- This two component, VOC compliant epoxy primer will provide a very smooth finish optimizing the appearance of the subsequent topcoat. This primer utilizes exempt solvents in meeting the required VOC level.

Components
Curing Solution: EC-286

Specifications
Qualified Product List
Bombardier/Lear
LES 1509
Cessna
CMFS035
Hawker Beechcraft
BS22455
Sino Swearingen
PS84
US Military
MIL-PRF-23377 Type I, Class C2

The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: www.akzonobel.com/aerospace

Surface Conditions
Cleaning
- Surface pretreatment is an essential part of the painting process.
- Apply over Alodine 1200 or similar MIL-C-5541 pre-treated aluminum substrates or as a reactivation primer over previously primed, painted and sanded paint systems.

Instruction for Use
Mixing Ratio
1 part Base 10P8-11
1 part Curing Solution EC-286

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly

Induction Time
None. For use with plural component equipment.
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Initial Spraying Viscosity
(25°C/77°F)

32 – 45 seconds ISO-Cup 4
17-23 seconds Zahn- Signature Cup #2

Note
Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.

Pot Life
(25°C/77°F)

4 hours.

Dry Film Thickness
(DFT)

15 – 23 micron (μm)
.6 -.9 mils

Application Recommendations

Any spray gun, disks or rotary bells can be used. Designed for use with electrostatic equipment.

Conditions

Temperature: 15 – 35°C
59 – 95°F
Relative Humidity: 35 – 75%

Note
The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Equipment

Air
1.2 – 1.4 mm nozzle orifice
HVLP
1.2 – 1.4 mm nozzle orifice
High Pressure
Airless Electrostatic
0.23 – 0.28 mm nozzle orifice

Number of coats
Apply 1 full wet coat to reach required film thickness.

Cleaning of Equipment
Use MEK, MPK or similar.
Physical Properties

Drying Times according to AITM 2-0011 (25 +/- 2°C / 77 +/- 2°F, 55 +/- 5% RH)

<table>
<thead>
<tr>
<th>Drying Method</th>
<th>Drying Time</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry to topcoat</td>
<td>2 hours</td>
<td>Full cure</td>
</tr>
<tr>
<td>Full cure</td>
<td></td>
<td>7 days air dry</td>
</tr>
<tr>
<td>Accelerated cure</td>
<td></td>
<td>Accelerated cure flashing 20 minutes at RT followed by 6 minutes at 180-220°F will result in a dry-to-handle, dry-to-topcoat, or dry-to-stack condition.</td>
</tr>
<tr>
<td>Option 1</td>
<td></td>
<td>Accelerated cure flashing 20 minutes at RT followed by 30 minutes at 120°F will result in a dry-to-handle, dry-to-topcoat, or dry-to-stack condition.</td>
</tr>
<tr>
<td>Accelerated cure</td>
<td></td>
<td>Ambient cure</td>
</tr>
<tr>
<td>Option 2</td>
<td></td>
<td>Set to touch in 30 minutes (77°F, 25°C, 50% RH)</td>
</tr>
</tbody>
</table>

Theoretical Coverage

12.95 m² per liter ready to apply at 25 μm dry film thickness
530 ft² per US gallon ready to apply at 1 mil dry film thickness, no loss.

Dry Film Weight

41.9 g/m²/micron
0.008 lbs/ft²/mil

Volatile Organic Compounds

Max 340 g/l admixed (contains exempt solvent)
Max. 2.8 lb/gal

Gloss (60º)

< 6 GU

Color

Green

Flash-point

10P8-11, EC-286
27°C / 81°F
43°C / 109°F
Storage
Store the product dry and at a temperature between 5 and 38°C / 40 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life
- 5 - 38°C (40 - 100°F)
24 months per AkzoNobel Aerospace Coatings commercial specification.
Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Safety Precautions
Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDSs are available on request.

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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