



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

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
(volume)

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.



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**



Conditions

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

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)

Dry to topcoat
Full cure

2 hours
7 days air dry

Accelerated cure
Option 1

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.

Accelerated cure
Option 2

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.

Ambient cure

Ambient cure Set to touch in 30 minutes (77°F, 25°C, 50% RH)



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 (60°)

< 6 GU



Color

Green



Flash-point

10P8-11 27°C / 81°F
EC-286 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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