



### Product Group

Epoxy primer

### Characteristics



Product  
Information

- This high solids corrosion resistant primer displays excellent compatibility with sealants, intermediate primers and topcoats.
- It has excellent Skydrol<sup>®</sup>, water and chemical resistance, including TT-S-735 Type VII hydrocarbons
- May serve as a combination process and fuel tank primer.

### Components



Curing Solution,  
Thinner/Reducer

Curing Solution EC-275  
Thinner TR-115

### Specifications



Qualified Product  
List

Bombardier/Lear	LES 1091
Cessna	CMFS029, Type II
Gulfstream Aerospace	GMS 5005

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

### Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

### Instruction for Use



Mixing Ratio  
(volume)

3 parts	Base 10P30-5
1 part	Curing Solution EC-275
2 parts	Thinner TR-115

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



Induction Time

15 minutes.



Initial Spraying  
Viscosity  
(25°C/77°F)

14-18 seconds ISO Cup 4  
12-16 seconds Zahn-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)

8 hours.



Dry Film  
Thickness  
(DFT)

12.7 – 20.3 micron (µm)  
0.5 – 0.8 mils

**Application  
Recommendations**



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	1.4 mm (.055 inch) nozzle orifice
HVLP	1.4 mm (.055 inch) nozzle orifice
Air Electrostatic	1.2 mm (.047 inch) nozzle orifice
Airless Electrostatic	.28-.33 mm (.011-.013 inch) nozzle orifice



Number of coats

Spray an even closed wet coat.



Cleaning of  
Equipment

Use MPK, MEK or similar.



**Physical Properties**



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

Dry to handle 1 hour  
 Dry to recoat 4 hours  
 Force cure 30 minute flash followed by one hour at 160°F (71°C). Dry to recoat after one additional hour at ambient temperature.



Theoretical Coverage

15.7 m<sup>2</sup> per liter ready to apply at 25 µm dry film thickness  
 640 ft<sup>2</sup> per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

43.2 g/m<sup>2</sup> per 25 micron  
 0.009 lbs/ft<sup>2</sup> per mil



Volatile Organic Compounds

Max 350 g/l (per US calculations)  
 Max 2.9 lbs/gal



Gloss (60°)

30 maximum GU

Fineness of Grind

4½ minimum Hegman



Color

Green



Flash-point

10P30-5 15°C / 60°F  
 EC-275 7°C / 45°F  
 TR-115 -17°C / 1°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.

### Issue date: July 2009 (supersedes March 2007) - FOR PROFESSIONAL USE ONLY

**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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