

TECHNICAL DATA SHEET**PRODUCT DESCRIPTION**

AEROPRIME is the trade name for Hentzen's Aerospace High Performance Primers. This product is a fast drying, two component, corrosion resistant epoxy primer. It meets the performance requirements of MIL-PRF-23377J, Type II, Class C2. Currently, not on QPL. Contains: Strontium Chromate

PHYSICAL CHARACTERISTICSAD9325-FD Aeroprime Low IR Green Epoxy Primer - Component A:

Weight per Gallon: 11.7 lbs. \pm 0.2

AD2298-FD Curing Agent - Component B:

Weight per Gallon: 7.1 lbs. \pm 0.2

Admixed Characteristics:

Catalyzation Ratio: 3:1 by volume
Weight per Gallon: 10.5 lbs. \pm 0.2
Weight Solids: 59.6% \pm 1.0
Volume Solids: 42.5% \pm 1.0
Viscosity: 18 - 23" #2 Zahn
Theoretical Coverage - 683 sq. ft./gal. @ 1.0 mil dry film thickness
Induction Time: None
Pot Life: 4 hours
Gloss @ 60° Meter: < 15 @ 1.0 mil DFT
Color: Dark Green

ENVIRONMENTAL REPORT

Volatile Content (Wt.%): 40.4%
Organic Volatile Content (Wt.%): 18.3%
Exempt Content (Wt.%): 22.1%
Exempt Content (Vol.%): 27.2%
VOC Minus Exempt: 2.8 lbs./gallon or 340 grams/liter

HANDLING & STORAGE

Shelf Life: 18 months from Date of Manufacture

- Store containers indoors at 60 - 90°F.
- Do not apply at temperatures below 50°F.
- Read all container labels.
- Read Material Safety Data Sheet.
- Keep away from open flame and sparks.

DIRECTIONS FOR USE

Mix Ratio by Volume: 3 Parts A to 1 Part B
No Induction time required before use.

Component A should be thoroughly agitated or shaken for a minimum of 15 minutes prior to blending. After agitating Component A, mix 3 volumes of Component A to 1 volume of Component B and mix the two components well. Use up admixture within 4 hours after mixing under ambient temperature to maintain coatings optimum properties.

APPLICATION DIRECTIONS

Substrate: Aluminum, Steel, or Composites

Preparation: Service Life of coating is directly related to the surface preparation. The surface to be coated must be properly prepared, dry, clean, and free of contamination.

Equipment: By HVLP, Air Spray, or Air-Assisted Airless.

	BINK'S	GRACO	GRACO
	MACH 1	Pro 3500	Pro AA4000
	<u>HVLP</u>	<u>Air Spray</u>	<u>AA-Airless</u>
Tip Size:	#91, #94	1.2-1.5 mm	#611, #613
Pot Pressure:	15-35 psi	15-35 psi	700-900 psi
Atomization Air:	9-10 psi	50-60 psi	40-50 psi

Application: Apply one uniform coat of primer to a dry film thickness of 0.6-0.9 mils. Topcoats may be applied after 30 minutes minimum cure time at 77°F.

DRYING SCHEDULE

Cure Schedule - Air Dry @ 60-90°F :

Tack Free:	>1 hour
Dry to Topcoat:	2-4 hours
Dry to Tape:	2-4 hours
Dry Hard:	4-6 hours
Full Resistance Properties:	7-10 days

Cure Schedule - Oven @ 150°F:

Flash Off	15 min. @ Room Temp.
Dry to Topcoat:	30-60 minutes
Dry to Hard:	2-4 hours
Full Resistance Properties:	24 hours

CLEAN-UP

Clean equipment immediately after use with MIL-T-81772, Type II Thinner, MEK, or equivalent solvent.

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