

10P4-2 Fluid Resistant Epoxy Primer Lead and Cadmium Free

Product Group

Epoxy primer

Characteristics



Product Information

- A chemically cured epoxy primer that provides excellent corrosion and chemical resistance for aircraft detail and subassembly parts.
- When used as the base primer for specification approved epoxy and polyurethane topcoats, the primer/topcoat system provides the optimum protection for interior structural components.
- This product has excellent adhesion to a variety of substrates.

Components



Curing Solution
Thinner

Curing Solution: EC-117S or EC-117
Thinner: TR-19 or TR-20, as required

Specifications



Qualified Product List

Boeing	BMS 10-11, Type I, Class A, Grade A
Bombardier/Canadair	BAMS 565-001, Grade A
EADS (CASA)	Z-12.109/BMS 10-11, Ty I, CI A
Embraer	MEP 10-059
Rohr (Goodrich)	RMS 118, Type I, Class G

The complete Akzo Nobel Aerospace Coatings qualified product list (QPL) can be found at www.anac.com.

Surface Conditions and Pretreatment



Cleaning

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

Instruction for Use



Mixing Ratio
(volume)

1 part	Base 10P4-2
1 part	Curing Solution EC-117S or EC-117

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



Induction Time

30 minutes



Initial Spraying
Viscosity
(23°C/73°F)

25 – 55 seconds ISO Cup #3
25 – 35 seconds Signature Zahn Cup #1

The use of Signature Zahn #1 cup for viscosity is a requirement of the referenced specification, and the ISO cup measurement is provided only as a reference for field application. They are not

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provided as quality control values.



Pot life
(23°C/73°F)

16 hours minimum



Dry Film
Thickness
(DFT)

13 – 18 micron (μm)
0.5 – 0.7 mils

Application Recommendations



Conditions

Temperature: 15 – 35°C
59 – 95°F

Relative Humidity: 35 – 75%



Equipment

Air 1.2 – 1.4 mm nozzle orifice
HVLP 1.2 – 1.4 mm nozzle orifice
Air Assisted, Electrostatic .28 – .33 mm nozzle orifice



Number of
Coats

Spray a single uniform wet coat to recommended dry film thickness.



Cleaning of
Equipment

MEK or C28/15

Physical Properties



Drying Times
(23°C/73°F)

Dust free 15 minutes
Tack free 2 hours
Dry through 4 hours
Dry to topcoat 1 hour



Theoretical
Coverage

8.6 m² per liter ready to apply at 25 μm dry film thickness
350 ft² per US gallon ready to apply at 1 mil dry film thickness



Dry Film
Weight

46.91 g/m² at 25.4 microns
.0096 lbs/ft² at 1 mil



Volatile Organic
Compounds

650 g/l (5.4 lb/gal) maximum (without thinner), per ASTM D3960.



Gloss (60°)

10 maximum

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Color Green BAC 452



Flash-point	10P4-2	-5°C (23°F)
	EC-117S	12°C (53°F)
	EC-117	12°C (53°F)



Storage Store product under dry conditions and at a temperature between 5 - 38°C (40 - 100°F).
Shelf-life of this product is 2 years. (24 months from date of manufacture).

Safety Precautions

Avoid skin or eye contact. Use in well-ventilated areas and avoid excessive vapor inhalation. 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 MSDS's are available on request.

Warranty

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