



Product Group

Epoxy primer

Characteristics



Product
Information

- A chemically cured, two-component epoxy primer designed to provide maximum protection from various chemicals, hydraulic fluids, aviation fuels, phosphate ester (Skydrol®) fluids and corrosion causing media.

Components



Curing Solution,
Thinner/Reducer

Curing Solution CA-116
Thinner TR-19, TR-49, or C25/90S, as required

Specifications



Qualified Product
List

Boeing Long Beach	DMS 1786, Ty I, Comp A
General Electric	GE A50TF107-S5
Messier-Dowty	PCS-2500

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.

Follow specification requirements for cleaning and application of the required pretreatment.

Instruction for Use



Mixing Ratio
(volume)

1 part	Base 463-12-8
1 part	Curing Solution CA-116
0 – 0.25 parts	Thinner TR-19,TR-49, or C25/90S, as needed

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



Induction Time

Recommended, 30 minutes



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

26 – 34 seconds ISO Cup #3 @ 18°C – 22°C (64°F – 72°F) per PCS 2500
26 – 36 seconds Signature Zahn Cup # 1
14 – 22 seconds Signature Zahn Cup # 2



Note

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 provided as quality control values. 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 minimum.



Dry Film
Thickness
(DFT)

25 – 33 micron (µm)
1.0 – 1.3 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 nozzle orifice
HVLP 1.4 mm nozzle orifice
Air Assisted, Airless .28 – .33 mm nozzle orifice



Number of coats

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



Cleaning of
Equipment

MEK or Thinner TR-19



Physical Properties



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

Dust free	15 minutes
Dry to stack	1 hour
Dry through	4 hours
Dry to topcoat	1 hour minimum and 48 hours maximum



Theoretical Coverage

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



Dry Film Weight

45.19 g/m² at 25.4 microns
.0093 lbs/ft² at 1 mil



Volatile Organic Compounds

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



Gloss (60°)

20 maximum GU



Color

DN 9295 Green



Flash-point

463-12-8	-5°C (23°F)
CA-116	-5°C (23°F)
TR-19 / TR-49	-5°C (23°F)
C25/90S	-4°C (25°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: August 2009 (supersedes May 2009) - 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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