

464-3-1

Epoxy Primer Surfacer

Technical Data Sheet

Product Group

Primer surfacer

Characteristics



Product
Information

This two-component epoxy primer surfacer is designed to provide a durable smooth surface ready for subsequent topcoat.

Components



Curing Solution
Thinner

Curing Solution CA-142
Thinner TL-52

Specifications



Qualified
Product List

Boeing Long Beach DPM 5766
VIAM TR 9-5.09-95

For most recent up-date or missing specifications please check the qualified product list (QPL) on www.akzonobel.com/aerospace

Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process
- **Steel surfaces:** Solvent clean and abrade, chemical treat or grit blast to remove grease, rust and contamination.
- **Plastic composite surfaces:** Solvent clean to remove oil, mold release compound and uniformly abrade to matte surface.

Instruction for Use



Mixing Ratio
(volume)

3 parts Base 464-3-1
1 part Curing Solution CA-142
0-0.4 as needed Thinner TL-52

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

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Induction Time

30 minutes



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

25 – 30 seconds Zahn-Cup #1



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)

5 hours



Dry Film
Thickness
(DFT)

75 – 125 micron (μm)
3 – 5 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.

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	Equipment	Conventional Air HVLP	1.4 mm (.055 inch) nozzle orifice 1.4 mm (.055 inch) nozzle orifice
	Number of Coats	Apply multiple cross-coats to 75 μ (0.003"). Additional applications may be made with solvent flash-off.	
	Cleaning of Equipment	Use a VOC compliant solvent blend.	
Physical Properties			
	Drying Times (25 +/- 2°C / 77 +/- 2°F, 55 +/- 5% RH)	Dry to handle Dry to recoat or sand Dry through	15-30 minutes 2-4 hours 24 hours
	Theoretical Coverage	15.7 m ² per liter ready to apply at 25 μ m dry film thickness 640 ft ² per US gallon ready to apply at 1 mil dry film thickness	
	Dry Film Weight	48 g/m ² /25 micron .01 lbs/ft ² /1 mil	
	Density	1.25 ± 0.02 g/l 10.4 ± 0.2 lb/gal	
	Volatile Organic Compounds	Max 508 g/l no reducer Max 538 g/l with TL-52 Max 4.2 lb/gal no reducer Max 4.5 lb/gal with TL-52	

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Gloss (60°)

5 maximum GU



Color

White



Flash-point

464-3-1
CA-142
TL-52

-5°C / 23°F
12°C / 53°F
-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 MSDS's 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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