

10P20-26

High Solids Impact Resistant Epoxy Primer

Technical Data Sheet

Product Group

Epoxy primer

Characteristics



Product
Information

A high solids, urethane compatible, Skydrol® resistant primer for the exterior of aircraft. This primer provides excellent corrosion resistance and excellent adhesion for urethane topcoats.

Components



Curing Solution

Curing Solution EC-234

Specifications



Qualified
Product List

Boeing Long Beach DMS 2144 Comp C

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.
- Follow the specification requirements for cleaning and pretreatment application.

Instruction for Use



Mixing Ratio
(volume)

3 parts Base 10P20-26
1 part Curing Solution EC-234

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

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Induction Time

15 minutes



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

10-16 seconds ISO-Cup 4
14-18 seconds 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)

3 hours.



Dry Film
Thickness
(DFT)

22.9-33.0 micron (μm)
0.9-1.3 mils

Application Recommendations

Standard suction, pressure pot, air assist airless, HVLP and electrostatic spray can apply this primer. It can also be roll applied.



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

Air	1.3-1.8 mm nozzle orifice
HVLP	1.2-1.4 mm nozzle orifice
Air Electrostatic	1.2-1.5 mm nozzle orifice

It can also be roll applied.



Number of Coats

Apply one wet closed coat. Avoid runs and sags.



Cleaning of Equipment

Use MEK

Physical Properties



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

Dry to topcoat	3½ - 4 hours minimum
Full cure	7 days

Recoat minimum	3½ - 4 hours
Recoat maximum	24 hours



Theoretical Coverage

24.6 m² per liter ready to apply at 25 µm dry film thickness
1000 ft² per US gallon ready to apply at 1 mil dry film thickness, no loss.



Dry Film Weight

43.1 g/m² per 25 micron
0.009 lbs/ft² per 1 mil



Volatile Organic Compounds

Max 350 g/l
Max. 2.9 lb/gal

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Gloss (60°)

40 – 95 GU



Color

Dark green



Flash-point

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EC-234

7°C / 45°F
7°C / 45°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)

12 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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