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

AkzoNobel Aerospace Coatings
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Induction Time	15 minutes
Initial Spraying Viscosity (25ºC/77ºF)	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 (25ºC/77ºF)	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 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Dry to topcoat	3½ - 4 hours minimum
	Full cure	7 days
	Recoatable minimum	3½ - 4 hours
	Recoatable maximum	24 hours
Theoretical Coverage	24.6 m² per liter ready to apply at 25 µm dry film thickness 1000 ft^2 per US gallon ready to apply at 1 mil dry film thickness, no loss.	
Dry Film Weight	43.1 g/m^2 per 25 micron 0.009 lbs/ft^2 per 1 mil	
Volatile Organic Compounds	Max 350 g/l Max. 2.9 lb/gal	

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Gloss (60º)	40 – 95 GU	
Color	Dark green	
Flash-point	10P20-26 EC-234	7°C / 45ºF 7°C / 45ºF
Storage	Store the product dry and at a temperature between 5 and 38ºC / 40 and 100ºF 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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