AkzoNobel
Aerospace Coatings

10P20-44
High Solids Epoxy Primer

AkzoNobel
Tomorrow's Answers Today

Product Group

High solids epoxy primer

Characteristics

Product Information

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

Components

Curing Solution, Thinner/Reducer

Curing solution: EC-265, EC-273
Thinner: TR-114, TR-102

Specifications

Qualified Product List

Air France	SMI 70 010-2
Boeing	BMS 10-72 Type VIII & IX
Boeing	BMS 10-79 Type II & III, Cl B, Gr D
Bombardier/Canadair	BAMS 565-008,Type I & II, Cl A, Gr B
Bombardier/deHavilland	DHMS C4.18 Type 3, Cl B, Gr B
EADS (CASA)	Z-12.138
Embraer	MEP 10-068, Cl A & B
FedEx	99-015
Saab	TEK00-0161MT

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.
- Refer to Eclipse Process Standard for detailed instructions.
- Surface pretreatment is an essential part of the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

Instruction for Use

- Stir or Shake base component until all pigment is uniformly dispersed before adding curing solution.
- Add curing solution and thinner/reducer and stir the catalyzed mixture thoroughly.

Mixing Ratio (volume)

3 parts	Base 10P20-44
1 part	Curing Solution EC-265 or EC-273
1 part	Thinner TR-114 or TR-102 (use of thinner optional but recommended)

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Mixing Ratio (volume) Continued	EC-265 Qualified to meet BMS 10-72, BMS 10-79, CMS565-08 and DMS 2104. EC-273 Formulated for application by maintenance market and select OEMs. Qualified to meet DHMS C4.18. TR-114 VOC- and HAPS-free reducer TR-102 Non-exempt thinner TR-114 is a VOC and HAPS-free thinner approved to BMS 10-72, BMS 10-79, BAMS 565-008, DMS 2104 and DHMS C4.18 at a mix ratio of 3:1:1 (10P20-44:EC-265:TR-114). The system pot life is extended up to 4 hours when the thinner is used in the 3:1:1 mix ratio. TR-102 non-exempt thinner can be used if VOC compliance is not needed and BMS 10-72 conformance is not required.
Induction Time	None
Initial Spraying Viscosity (25ºC/77ºF)	23 – 30 seconds ISO Cup # 4 3:1 mix ratio 16 – 23 seconds Signature Zahn Cup # 2 3:1 mix ratio 15 – 21 seconds ISO Cup # 4 3:1:1 mix ratio 13 – 19 seconds Signature Zahn Cup # 2 3:1:1 mix ratio The uses of Signature Zahn Cups for viscosity are requirements of the referenced specifications, and the ISO Cup measurement is provided only as a reference for field application. They are not provided as quality control values.
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)	1 hour. No thinner 4 hours. With 1 part TR-114 or TR-102 (recommended)
Dry Film Thickness (DFT)	15 – 23 micron (µm) 0.6 – 0.9 mils
Note	The application and mixing characteristics of high solid products differ from conventional products. Mix base and hardener for at least two minutes thoroughly. The high solid content causes a rapid film build up.

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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

Conventional air	1.4 mm (.055 inch) nozzle orifice
Air assist airless electrostatic	.28 - .33 mm (.011 - .013 inch) nozzle orifice
Air electrostatic	1.2 mm (.047 inch) nozzle orifice
HVLP	1.4 mm (.055 inch) nozzle orifice

Number of coats

Single uniform wet coat

Cleaning of Equipment

Use TR-36 or MEK.

Physical Properties

Drying Times according to AITM 2-0011 (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)

Dry to handle	8 – 12 hrs
Dry to topcoat	2.25 hrs
Dry to tape	2.25 hrs
Full cure	7 days
Accelerated Cure To topcoat	Flash off 15 – 30 minutes @ ambient temperature and 50% RH, then ½ hr @ 60°C (140°F).
Full cure	Flash off 15 – 30 minutes @ ambient temperature and 50% RH, then 24 hrs @ 60°C (140°F)

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Theoretical Coverage	- **Unreduced:** 22.2 m^2 per liter ready to apply at 25.4 µm dry film thickness 905 ft^2 per US gallon ready to apply at 1 mil dry film thickness - **Activated with EC-265** and thinned with either Reducer: 17.8 m^2 per liter ready to apply at 25.4 µm dry film thickness 724 ft^2 per US gallon ready to apply at 1 mil dry film thickness - **Activated with EC-273** and thinned with either Reducer: 17.4 m^2 per liter ready to apply at 25.4 µm dry film thickness 709 ft^2 per US gallon ready to apply at 1 mil dry film thickness
Dry Film Weight	- Activated with EC-265: 42.9 g/m^2 at 25.4 microns .0088 lbs/ft^2 at 1 mil - Activated with EC-273: 43.4 g/m^2 at 25.4 microns .0089 lbs/ft^2 at 1 mil
Volatile Organic Compounds	**- Activated with EC-265:** 42.9 g/m^2 at 25.4 microns .0088 lbs/ft^2 at 1 mil **- Activated with EC-273:** 43.4 g/m^2 at 25.4 microns .0089 lbs/ft^2 at 1 mil
Gloss (60º)	10 - 60 GU
Color	Yellow
Flash-point	10P20-44 7°C / 45°F EC-265 7°C / 45°F EC-273 7°C / 45°F TR-114 -17°C / 1°F TR-102 7°C / 45°F
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.

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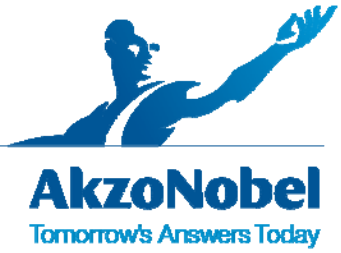

Safety Precautions

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.

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