AkzoNobel
Aerospace Coatings

Alumigrip® 10P8-11
VOC Compliant Epoxy Primer

AkzoNobel
Tomorrow's Answers Today

Product Group

Epoxy primer

Characteristics

Product Information

- This two component, VOC compliant epoxy primer will provide a very smooth finish optimizing the appearance of the subsequent topcoat. This primer utilizes exempt solvents in meeting the required VOC level.

Components

Curing Solution

Curing Solution: EC-286

Specifications

Qualified Product List

Bombardier/Lear	LES 1509
Cessna	CMFS035
Hawker Beechcraft	BS22455
Sino Swearingen	PS84
US Military	MIL-PRF-23377 Type I, Class C2

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.
- Apply over Alodine 1200 or similar MIL-C-5541 pre-treated aluminum substrates or as a reactivation primer over previously primed, painted and sanded paint systems.

Instruction for Use

Mixing Ratio (volume)

1 part	Base 10P8-11
1 part	Curing Solution EC-286

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

None. For use with plural component equipment.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905, Fax (31) 71 308 2056

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Initial Spraying Viscosity (25ºC/77ºF)	32 – 45 seconds ISO-Cup 4 17-23 seconds Zahn- Signature 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)	4 hours.
Dry Film Thickness (DFT)	15 – 23 micron (µm) .6 -.9 mils

Application Recommendations

Any spray gun, disks or rotary bells can be used. Designed for use with electrostatic equipment.

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	1.2 – 1.4 mm nozzle orifice
	HVLP	1.2 – 1.4 mm nozzle orifice
	High Pressure Airless Electrostatic	0.23 – 0.28 mm nozzle orifice
Number of coats	Apply 1 full wet coat to reach required film thickness.	
Cleaning of Equipment	Use MEK, MPK or similar.	

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Physical Properties

Drying Times according to AITM 2-0011 (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Dry to topcoat	2 hours
	Full cure	7 days air dry
	Accelerated cure Option 1	Accelerated cure flashing 20 minutes at RT followed by 6 minutes at 180-220°F will result in a dry-to-handle, dry-to topcoat, or dry-to-stack condition.
	Accelerated cure Option 2	Accelerated cure flashing 20 minutes at RT followed by 30 minutes at 120°F will result in a dry-to-handle, dry-to topcoat, or dry-to-stack condition.
	Ambient cure	Ambient cure Set to touch in 30 minutes (77°F, 25°C, 50% RH)

Theoretical Coverage	12.95 m^2 per liter ready to apply at 25 µm dry film thickness 530 ft^2 per US gallon ready to apply at 1 mil dry film thickness, no loss.	
Dry Film Weight	41.9 g/m^2/micron 0.008 lbs/ft^2/mil	
Volatile Organic Compounds	Max 340 g/l admixed (contains exempt solvent) Max. 2.8 lb/gal	
Gloss (60º)	< 6 GU	
Color	Green	
Flash-point	10P8-11 EC-286	27°C / 81°F 43°C / 109°F

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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)

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.

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