AkzoNobel
Aerospace Coatings

10P4-2NF

Fluid Resistant Epoxy Primer
Lead and Cadmium Free

AkzoNobel
Tomorrow's Answers Today

Product Group

Epoxy primer

Characteristics

Product Information

- A chemically cured epoxy primer that provides excellent corrosion and chemical resistance for aircraft detail and subassembly parts.
- When used as the base primer for specification approved epoxy and polyurethane topcoats, the primer/topcoat system provides the optimum protection for interior structural components.
- This product has excellent adhesion to a variety of substrates.

Components

Curing Solution, Thinner/Reducer

Curing Solution: EC-117S
Thinner/Reducer: TR-19 or TR-20, as required

Specifications

Qualified Product List

Boeing	BMS 10-11, Type I, Class A, Grade A
Bombardier	BAMS 565-001, Grade A
Embraer	MEP 10-059
Rohr (Goodrich)	RMS 118, Type I, Class G

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.
- Follow specification requirements for cleaning and pretreatment application.

Instruction for Use

Mixing Ratio (volume)

1 part	Base 10P4-2NF
1 part	Curing Solution EC-117S
0 – 0.5 max.	As required, TR-19 or TR-20

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

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Internet: www.akzonobel.com/aerospace

Induction Time	30 minutes minimum
Initial Spraying Viscosity (25ºC/77ºF)	25 – 55 seconds ISO Cup #3 25 – 35 seconds Signature Zahn Cup #1
Note	The use of Signature Zahn #1 cup for viscosity is a requirement of the referenced specification, 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)	16 hours.
Dry Film Thickness (DFT)	13 – 18 micron (µm) 0.5 – 0.7 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.	
Equipment	Air HVLP	0.052 – 0.070 in. nozzle orifice 1.2 – 1.4 mm nozzle orifice

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Number of coats	Spray a single uniform wet coat to recommended dry film thickness.
Cleaning of Equipment	MEK or C28/15

Physical Properties

Drying Times (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Dust free	15 minutes
	Tack free	2 hours
	Dry through	4 hours
	Dry to topcoat	1 hour
Theoretical Coverage	8.6 m^2 per liter ready to apply at 25 µm dry film thickness 350 ft^2 per US gallon ready to apply at 1 mil dry film thickness	
Dry Film Weight	46.91 g/m^2 at 25.4 microns .0096 lbs/ft^2 at 1 mil	
Volatile Organic Compounds	Max 650 g/l Max 5.4 lb/gal Maximum (without thinner), per ASTM D3960.	
Gloss (60º)	10 maximum	
Color	Green BAC 452	
Flash-point	10P4-2NF	-5°C (23°F)
	EC-117S	12°C (53°F)
	TR-19	-4°C (25°F)
	TR-20	4°C (40°F)

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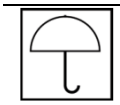

Storage

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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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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