10PW20-4 Water Reducible Epoxy Primer

Product Group

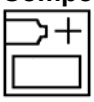
Epoxy primer

Characteristics

Product Information

This chemically cured, water reducible epoxy primer is designed to provide corrosion and chemical resistance over aluminum substrates. It may be topcoated with epoxy or polyurethane.

Components



Curing Solution
Thinner

Curing Solution: ECW-104
Thinner: DI water

Specifications

Qualified Product List

EADS (CASA)	Z-12.141
Lockheed Martin	G37.5422
US Military	MIL-PRF-85582 Ty I, Cl C2

The complete Akzo Nobel Aerospace Coatings qualified product list (QPL) can be found at: www.anac.com

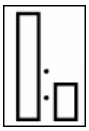
Surface Conditions

Cleaning

- Surface pretreatment is an essential part of the painting process
- Prepare surface per MIL-PRF-85582.

Instruction for Use

- Stir or Shake till all pigment is uniformly dispersed before adding hardener / curing solution.
- Pour the quart of ECW-104 curing solution into the gallon can of 10PW20-4 base. Place on shaker for two minutes, then remove. Check viscosity. If necessary, further reduce the mixture with DI water additions of 5% by volume of mixed coating up to a maximum of 15%. DO NOT add more than this amount. Allow the reduced material an induction time of 20 minutes before using. The material is now ready for spray application.



Mixing Ratio (volume)

3 parts	Base 10PW20-4
1 part	Curing Solution ECW-104
	Thinner DI water (15% by volume maximum)

Induction Time

20 minutes

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 Initial Spraying Viscosity (21ºC/70ºF)	37 – 60 seconds (reduced 10% by volume with DI water) ISO-Cup 4 20 – 26 seconds(reduced 10% by volume with DI water) Zahn-Cup Signature #2 18 - 25 seconds (reduced 10% by volume with DI water) #4 Ford The Zahn cup and ISO cup data are provided as application guidelines only. The quality control requierment per MIL-PRF-85582 is the Ford cup viscosity.
 Pot Life (25ºC/77ºF)	4 hours at 77°F (25°C)
 Dry Film Thickness (DFT)	15 – 25 micron (µm) 0.6 – 1.0 mils

Application Recommendations

Standard suction or pressure spray equipment

 Conditions	Temperature:	15 – 35°C 59 – 95°F
	Relative Humidity:	35 – 75%
 Equipment	Air HVLP	1.2 – 1.4 mm nozzle orifice 1.2 – 1.4 mm nozzle orifice

 Number of Coats	Spray a single uniform wet coat to recommended dry film thickness.
 Cleaning of Equipment	Flush equipment with water first. Then use TR-19 to clean residue from equipment. If material dries on equipment, omit water flush and use TR-19 only.
 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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Physical Properties

Drying Times (25ºC/77ºF)	Full cure	14 days (90% cure in 7 days)
	Dry to topcoat	2 hours
	Dry hard	6 hours
	Force cure	Allow to flash dry at 55°-80°F (13°-27°C) for a minimum of one hour before force curing at 145°-155°F (63°-68°C) for 24 hours.
Theoretical Coverage	20.3 m^2 per liter ready to apply at 18 µm dry film thickness 826 ft^2 per US gallon ready to apply at 0.7 mil dry film thickness	
Dry Film Weight	39.8 g/m^2/25 micron 0.008 lbs/ft^2/1.0 mil	
Volatile Organic Compounds	Max 340 g/l admixed Max. 2.8 lb/gal	
Gloss (60º)	<10 GU	
Color	Light green	
Flash-point	10PW20-4	93°C / 200°F
	ECW-104	23°C / 74°F
Storage	Store the product dry and at a temperature between 5 and 25ºC / 41 and 77ºF. Stored in the original unopened containers. Periodical short time exposure (max. 48 hrs at a time) to higher temperatures (max. 40°C / 104°F) will not negatively influence the shelf life of the products.	
Shelf life 5 - 38°C (41 - 77°F)	12 months per ANAC commercial specification Shelf life may vary due to OEM specification requirements	

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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.

FOR PROFESSIONAL USE ONLY

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