

Aerodur HS 2121 CF Primer

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics

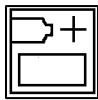


Product
Information

Aerodur HS 2121 CF Primer is a 3-component, chromate-free, low VOC (High Solids) amine cured epoxy primer for exterior use as refresh primer developed to meet all Airbus exterior system specifications, including the selective strippable intermediate coat systems

- Highly chemical resistant against e.g. hydraulic fluids;
- Excellent adhesion performance to uncoated metals (e.g. rivets) and aged reactivated coating systems, with and without the OEM prescribed pre-treatments.
- Available in two colors; beige for use in combination with the intermediate coat to see the contrast, and off-white for optimized process-ability when applying a light colored topcoat or basecoat.

Components



Base material	Aerodur HS 2121 CF Primer
Curing Solution	Hardener 6040
Activator	Activator A9026

Specifications



Qualified Product
List

Airbus	AIMS 04-04-031
	AIMS 04-04-032
	AIMS 04-04-033
	AIMS 04-04-034
	AIMS 04-04-037

British Aerospace Airbus	ABP 4-2364
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Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products

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Surface Conditions



Cleaning

- Clean aged basic primer or epoxy / polyurethane finishes with Solvent Cleaning 98068 or similar, and sand to a uniform and matt surface using grade P320 sanding paper or aluminum oxide non-woven abrasive material, type very fine;
- Rivets and fasteners should be cleaned with Solvent Cleaning 98068 or similar, and activated with aluminum oxide non-woven abrasive material type fine or very fine prior to application of Aerodur HS 2121 CF Primer;
- Remove dust with e.g. tack rags;
- Aerodur HS 2121 CF Primer is compatible with OEM approved 10PEG1 type sol-gel pre-treated surfaces.

Instruction for Use



Mixing Ratio

	Volume	Weight
Aerodur HS 2121 CF primer	5 parts	100 parts
Hardener 6040	1 part	12.4 parts
Activator A9026	1 part	9.7 parts

- Ensure all components are acclimatized to ambient conditions before using them
- When mixed volumes of <1L are used it is strongly advised to dose by weight to eliminate mixing ratio failures.
- Homogenize the base component until all pigment is uniformly dispersed before adding hardener and activator.
- Add Hardener 6040 to base component and stir thoroughly until a homogeneous mixture.
- Add Activator A9026 and stir the catalyzed mixture thoroughly until a homogeneous mixture.



Induction time

Not applicable; the product can be used directly after mixing



Initial Spraying
Viscosity
(23°C/73°F)

18 – 30 seconds ISO-Cup 4
16 – 22 seconds Gardner Signature Zahn-Cup 2

Measured within 30 seconds after mixing. Briefly stir or shake the mixed components thoroughly before measuring the viscosity.

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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
(23°C/73°F)

2 hours



Dry Film
Thickness
(DFT)

15 – 25 μm
0.6 – 1.0 mil

Application Recommendations



Conditions

Temperature: 15 – 35°C
59 - 95°F
Relative Humidity: 35 – 75%



Note

Aerodur HS 2121 CF Primer may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.



Equipment
recommendation

Conventional / HVLP	Nozzle orifice / tip-size	1.2 - 1.5mm
	Atomizing air pressure	2 - 4 bar / 29 - 58 psi
Low pressure (electrostatic)	Nozzle orifice / tip-size	1.2mm
	Product flow rate	280 - 300 mL/min
	Atomizing air pressure	4 - 4.5 bar / 58 - 65 psi
	Nozzle orifice / tip-size	1.5mm
	Product flow rate	230 - 260 mL/min
	Atomizing air pressure	4 - 4.5 bar / 58 - 65 psi
High pressure (electrostatic)	Nozzle orifice / angle	60°
	0.009 inch	70 bar / 1015 psi
	0.013 inch	30 bar / 435 psi
	Air pressure	4 - 4.5 bar / 58 - 65 psi

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Number of Coats

Spray a uniform wet coat to a dry film thickness of 15 - 25 μm / 0.6 - 1.0 mil



Cleaning of equipment

Use Solvent Cleaning C28/15 or Solvent Cleaning 98068.



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 to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Physical Properties



Drying Times
(23°C/73°F, 55% RH)

Dry to topcoat	2 hours
Dry to tape	3 hours
Dry to sand	4 hours
Recoat minimum	2 hours
Recoat maximum	168 hours

If a drying time of 168 hours is exceeded, condition surface with e.g. grade P320 sanding paper or aluminum oxide non-woven material, type fine or very fine.



Note

This is NOT applicable when re-coated with an intermediate coat.

When using Aerodur Sealer 42240 after Aerodur HS 2121, the following overcoat times apply:

Temperature \ RH	20-40%	41-60%	61-80%
15-20°C	1:00-4:00 hrs	1:00-4:00 hrs	1:00-4:00 hrs
21-25°C	1:00-3:00 hrs	1:00-3:00 hrs	1:00-3:00 hrs
26-30°C	0:30-3:00 hrs	0:30-2:30 hrs	0:30-2:30 hrs
31-35°C	0:30-3:00 hrs	0:30-2:15 hrs	0:30-1:15 hrs

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Note

Recommended application window for best product performances is 20-25°C and 20-60%RH.

Table above is provided as an indication for a product applied at the recommended DFT and may vary upon the exact temperature and humidity combination.



Theoretical Coverage

38 m² per liter mixed Aerodur HS 2121 CF Primer at 15 µm dry film thickness

1557 ft² per US gallon mixed Aerodur HS 2121 CF Primer at 0.6 mils dry film thickness



Dry film Weight

2.0 g/m²/µm

0.0104 lbs/ft²/mil



Volatile Organic Compounds

Maximum 350 g/l

Maximum 2.95 lb/gal



Color

Beige
Off-white



Flash-point

Aerodur HS 2121 CF Primer >21°C / >70°F

Hardener 6040 >21°C / >70°F

Activator A9026 <21°C / <70°F



Storage

Store the product dry and at a temperature between 5 and 35 °C / 40 and 95 °F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Refer to container label for specific storage life information.

Shelf life

5 – 35 °C

(41 – 95 °F)

Aerodur HS 2121 CF Primer 24 months

Hardener 6040 24 months

Activator A9026 36 months

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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 MSDS's are available on request.

Issue date: November 2020 (supersedes August 2020) - FOR PROFESSIONAL USE ONLY

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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