

Alumigrip 10P8-11

VOC Compliant Epoxy Primer

Technical Data Sheet

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

EC-286

Specifications



Qualified
Product List

Bombardier/Lear	LES 1509, LES 1348
Cessna	CMFS025
Cessna	CMFS035
Hawker Beechcraft	BS22455
Emivest Aerospace	PS84
US Military	MIL-PRF-23377 Type I, Class C2
Textron	TM 3405, Type I, Class C

For most recent up-date or missing specifications please check the qualified product list (QPL) on 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.

May also be applied over Metflex SP 1050 (see process document)

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Instruction for Use



Mixing Ratio
(volume)

1 part
1 part

Base 10P8-11LC
Curing Solution EC-286

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



Induction Time

None. For use with plural component equipment. Product can also be sprayed with conventional spray equipment with pressure pot or siphon cup.



Initial Spraying
Viscosity
(25°C/77°F)

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
(25°C/77°F)

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%

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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.

Physical Properties



Drying Times
(25 +/- 2°C / 77
+/- 2°F, 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 / 82°-105°C 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/49°C 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)

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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.

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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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