

Alumigrip 4001

Corrosion Inhibiting Primer / Sanding Surfacers

Technical Data Sheet

Product Group

Corrosion Inhibiting Primer / Sanding Surfacers

Characteristics



Product
Information

Alumigrip 4001 is a high build non-chrome epoxy primer-surfacer formulated to provide corrosion inhibition and primer surfacer performance in the reactivation of a basic structural process primer, or in a direct-to-metal application using a chemical conversion coating per MIL-C-5541 (Alodine). This product provides a unique combination of corrosion resistance and sanding properties

Components



Base,
Curing Solution,
Thinner/Reducer

Alumigrip 4001PS003 Base Component
Curing Solution CS4902
Thinner: TR-114 (VOC Compliant/Optional)

Specifications



Qualified
Product List

Bombardier/Lear	LES 1175, LES 1098, LES 1348
Cessna	CMFS043
Gulfstream	GMS 5008 (reference ECM 20001)
Ilyushin	TI 756.03.583
Irkut	741.140/21-00-00-0038-0T04/0B

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

Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process.

Application over primer:

- Follow the specification requirements for pretreatment, cleaning, application, and reactivation of the relevant primer (10P4-2NF, 10P8-10NF, 10P30-5, Alumigrip 10P8-11 or Alumigrip 4001).
- Abrade process primer with ScotchBrite® pad or equivalent.
- Solvent wipe with MEK, IPA or other suitable cleaning solvent.
- Apply Alumigrip 4001







Application direct to aluminum substrate:

- Follow cleaning and pretreatment instructions of MIL-PRF-23377 and MIL-C-5541 (Alodine)
- Apply Alumigrip 4001


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Instruction for Use

	Mixing Ratio (volume)	4.0 parts 1.0 parts 0.0-1.0 parts	Alumigrip 4001PS003 Alumigrip 4001 Curing Solution CS4902 TR-114 VOC Compliant Thinner (optional)
	Induction Time	15 minutes	
	Initial Spraying Viscosity (25°C/77°F)	Mixed 4.0:1.0 with no additional TR-114 18-25 seconds Ford Cup #4 20-28 seconds Signature Zahn Cup # 2 40-70 seconds ISO Cup #4	
	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)	2 hours mixed 4.0:1.0 with no TR-114 4 hours mixed 4.0:1.0:0.5-1.0 with TR-114	
	Dry Film Thickness (DFT)	As primer: 0.6–1.0 mils. / 15–25 microns (µm) As surfacer: 3–6 mils / 75–150 microns (µm) Dry time will be extended at higher film thicknesses	

Application Recommendations

	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

HVLP	1.4 mm (.055inch) nozzle orifice
Air Assist Airless HVLP	0.6 mm (.024inch) nozzle orifice
High Pressure Assist HVLP	0.5 mm (0.018 inch) nozzle orifice



Number of Coats

Apply Alumigrip 4001 using a Cross Coat method to achieve the desired film thickness.



Cleaning of Equipment

MEK, MPK, or equivalent

Physical Properties



Drying Times
(25 +/- 2°C / 77
+/- 2°F, 55 +/-
5% RH)

Dry to Sand Approx. 3 hours depending on film thickness.

Dry to Topcoat As primer: 2 hours minimum. 48 hours maximum.
As surfacer: 72 hours maximum after sanding.

Recoat minimum None, wet on wet application

Recoat maximum 1 hour



Theoretical Coverage

22.0 m² per liter ready to apply at 25 μm dry film thickness
899 ft² per US gallon ready to apply at 1 mil dry film thickness

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Corrosion Inhibiting Primer / Sanding Surfacer



Dry Film Weight

45.2 g/m²/ 25 micron
.009252 lbs/ft²/ at 1mil



Volatile Organic
Compounds

Max 350 g/l (per EPA Method 24)
Max. 2.92 lb/gal



Color

Off-White



Flash-point

4001PS003 -4°C / 25°F
CS4902 26.7°C / 80°F
TR-114 -17°C / 1°F



Storage

Store the product dry and at a temperature between 5 and 38°C / 40 and 100°F 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)

12 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 Safety Data Sheet (SDS) and label of the individual products carefully before using the products. The SDS'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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