

# 10P3-2

## Zinc Dust Epoxy Primer

### Technical Data Sheet

#### Product Group

Epoxy Primer

#### Characteristics



Product  
Information

A chemically cured zinc dust pigmented epoxy primer designed to provide corrosion and chemical resistance for steel surfaces. This primer provides excellent protection without a topcoat, however it is completely compatible with enamel and aliphatic polyurethane topcoats.

#### Components



Curing Solution  
Thinner

Curing Solution EC-113  
Thinner TR-49 (for use with MIL-PRF-26915)  
Thinner TR-19 or TR-20

#### Specifications



Qualified  
Product List

BAE Systems (Regional Aircraft) AVP 3-034  
US Military MIL-PRF-26915, Ty I, CI B

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

#### Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

#### Instruction for Use



Mixing Ratio  
(volume)

4 parts Base 10P3-2  
1 part Curing Solution EC-113  
As required to achieve DFT Thinner TR-49, 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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Induction Time

30 minutes



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

20 – 22 seconds Zahn-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)

8 hours minimum



Dry Film  
Thickness  
(DFT)

63.5 micron ( $\mu\text{m}$ )  
2.5 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.

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Equipment

Spray gun with agitated pot recommended.



Number of  
Coats

An agitated pot is recommended to keep the zinc dust suspended. Spray all cross coats to achieve a dry film thickness of 2 mils (50 microns) per coat.



Cleaning of  
Equipment

Use TR-49 or MEK. These balanced thinners will minimize the possibility of residue remaining on the equipment.

### Physical Properties



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

Dry to Touch	15 minutes
Dry to overcoat	30 minutes
Dry hard	8 hours



Theoretical  
Coverage

18 m<sup>2</sup> per liter ready to apply at 25 µm dry film thickness  
733 ft<sup>2</sup> per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

81 g/m<sup>2</sup>/ 25 µm  
.017 lbs/ft<sup>2</sup>/ 1 mil  
WPG = 16.07 lbs/gal (1930 g/l)







Volatile Organic  
Compounds

Max 451 g/l  
Max 3.8 lb/gal  
Zinc content: 80% minimum of non-volatile

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## Zinc Dust Epoxy Primer

	Gloss (60°)	< 30 GU										
	Color	Bluish grey										
	Flash-point	<table border="0"> <tr> <td>10P3-2</td> <td>-4°C / 25°F</td> </tr> <tr> <td>EC-113</td> <td>12°C / 53°F</td> </tr> <tr> <td>TR-49</td> <td>-5°C / 23°F</td> </tr> <tr> <td>TR-19</td> <td>-4°C / 25°F</td> </tr> <tr> <td>TR-20</td> <td>4°C / 40°F</td> </tr> </table>	10P3-2	-4°C / 25°F	EC-113	12°C / 53°F	TR-49	-5°C / 23°F	TR-19	-4°C / 25°F	TR-20	4°C / 40°F
10P3-2	-4°C / 25°F											
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TR-49	-5°C / 23°F											
TR-19	-4°C / 25°F											
TR-20	4°C / 40°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 for base and curing solution. 24 months for thinners: TR-49, TR-19 and TR-20. 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 MSDS's are available on request.

**Issue date: January 2015 (supersedes December 2009) - 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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