



Product Group

High solids epoxy primer

Characteristics



Product
Information

- This two-component high solids epoxy primer is fast drying and has enhanced corrosion performance on ferrous and nonferrous metals. It is lead and chromate free. This HAPS-free formulation meets the maximum VOC content of 340 grams/liter (2.8 pounds/gallon) as packaged.

Components



Base
Curing Solution,
Thinner/Reducer

10301P001
CS10601
TR-115 (VOC exempt solvent)

Specifications



Qualified Product
List

US Military MIL-DTL-53022E, Type IV

The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: www.akzonobel.com/aerospace

Surface Conditions



Cleaning

Surface pretreatment is an essential part of the painting process.

Cold-rolled SAE1010 Steel → Zinc Phosphate coating (TT-C-490 Type I)
Bare 2024-T3 Aluminum Alloy → Alodine-5900 (MIL-DTL-5541 Type II)

Follow surface pretreatment process per MIL-DTL-53072D for Ferrous and Non-ferrous substrates.

Instruction for Use



Mixing Ratio
(volume)

4 parts Intergard Base 10301P001
1 part Curing solution 10601
1 part TR-115

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



	Induction Time	30 minutes
	Initial Spraying Viscosity (25°C/77°F)	20 – 24 seconds Ford #4 Cup @ 77 ± 2°F
	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)	33 – 43 micron (µm) 1.5 ± 0.2 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.
	Equipment	Air 1.4 mm (.055 inch) nozzle orifice HVLP 1.4 mm (.055 inch) nozzle orifice Air Electrostatic 1.2 mm (.047 inch) nozzle orifice Airless Electrostatic .28 – .33 mm (.011 – .013 inch) nozzle orifice at 60° angle nozzle orifice



Number of coats

Spray a uniform wet coat to recommended dry film thickness.



Cleaning of
Equipment

Use MEK.

Physical Properties



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

Set to touch	1 Hour
Dry hard	3 Hours
Dry through/Dry to tape	4 Hours
Dry to topcoat	3 Hours
Recoat window	48 Hours maximum



Theoretical
Coverage

20.58 m² per liter ready to apply at 25.4 µm dry film thickness
839 ft² per US gallon ready to apply at 1.0 mil dry film thickness



Dry Film Weight

1.74 g/m²/micron
0.0090 lbs/ft²/mil



Volatile Organic
Compounds

340 g/l (2.8 lbs. /gal.) Maximum



Gloss (60°)

10 - 40 GU, 15 Typical



Color

Light Gray



Flash-point

Intergard Base10301P001	6.7°C / 44.1°F
Curing Solution 10601	93.0 °C / 199.4°F
TR-115	-17.2°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)

24 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 Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDSs are available on request.

Issue date: July 2012 (supersedes none) - 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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