PRIMER A530

FINISHES FOR AIRCRAFT EXTERIORS

AkzoNobel

Product information

Three components strontium chromate-based epoxy primer, with high chemical resistance. This product is designed for the protection of metallic structures on aircraft. The topcoat AEROPRIM 530 is recommended for use with a topcoat such as AEROMAP A1500-M.

Components

Base AEROPRIM 530
Hardener / Catalyst AEROPRIM 530
Thinner E

Specifications

Product information mentioned in the technical datasheet is given for information purposes and can differ from requirements of specifications above. In that case, customer requirements are valid for your application.

Physical properties

THEORETICAL COVERAGE
17 m²/L (937 sq.ft/gal) for 20 µm (0.8 mils) dry (base and hardener undiluted)

DRY FILM WEIGHT
1.8

VOC
600 g / L (base + hardener + thinner) for a 45% dilution (ISO 11890-1 and ASTM D 3960)

COLOR
Sand Yellow 21 530 000 B, blue 21 530 100 B, dark green 21 530 200 B

SHELF LIFE / STORAGE
24 months for the base and hardener stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.
48 months for the thinner stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

GLOSS LEVEL
20 GU below 60°

NOTES
Gloss levels have been determined using glossmeter with an angle of incidence of 60°C. The theorical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation

AEROPRIM 530 primer is used particularly on aluminium alloys that have had the following treatments:
Alodine 1200: Cr6 conversion
CAA: Chromic Acid Anodising Anodic oxidation sulphuric
TSA: Oxydation anodique tartrique
BAA: Boric Acid Anodising

Observe the recoating time between the surface treatment and painting. This may vary depending on the treatment and industrial instructions.
Contact us for information on uses on other metallic structures, surface treatments or paints.

All recommandations mentioned above are given for information.

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Instructions for use

SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	1 V
Hardener / Catalyst	58	1 V
Thinner	30 to 60	0.3 V to 0.6 V

MIXING PROCEDURE
Ideally, the unmixed products should be stored between 18°C and 25°C (64°F and 77°F) for 24 hours before use.
The A530 primer base should be mixed for 10 minutes in a pneumatic or oscillating mixer before use.
The mixture by weight is recommended.
Mix the base and the hardener until the mixture is homogeneous. Then add the thinner E in two stages.
The mixture must be made at a temperature between 15°C and 35°C (60-95°F)
Remark : It is recommended to sieve the mixture through a 120-150µm (4.7-5.9mils) filters.

INDUCTION TIME
None

Spraying viscosity at 20°C / 68°F

CA 4	CA 2.5
14 to 16 s	40 to 60 s

POT LIFE
8 hours or 4 hours at 30 °C (86°F).

NOTE
Viscosities mentioned above are corresponding to the recommended range of viscosity to ensure compliant application. The range of dilution must be used to adjust viscosity to reach the recommended one.

AFNOR 4 cup is the reference cup. The others are given for information purposes.

Application recommendations

CONDITIONS
Temperature 15 °C (59°F) to 35 °C (95°F)
Relative humidity 30 % to 75 %

EQUIPMENT
Gravity compressed air or suction gun Nozzle 1.2 mm to 1.8 mm
Electrostatic spray gun Nozzle 1.2 mm to 1.8 mm

DRY / WET FILM THICKNESS
15 µm to 25 µm (0.6 to 1 mils) dry

NUMBER OF COATS
The number of coats depends on the size and the shape of the part to which it is being applied.
The recommended dynamic air pressure is 1.5 bar to 4 bar (22 to 58 psi).

EQUIPMENT CLEANING
Clean the equipment with an appropriate cleaning thinner, such as Mapaero P.

NOTE
Spray with dry and oil-free air.

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Drying times

	23°C (73°F)	60°C (140°F)
Recoatable	4 hours to 72 hours	1 hour to 24 hours
Fully Cured	7 days	

NOTE
Drying times have been determined using tests pieces of a thickness < 2mm for 20µm (0.8mils) of dry film.

*N.A. : Not applicable

Defects & corrections

In the event of a defect, contact your Quality Department.

Before drying into the oven, leave to flash off 30 minutes at room temperature.

In case of thin coats:
Apply a thin coat of AEROPRIM 530 to achieve the required thickness. If the above recommended recoating time is exceeded, reactivate with Scotch-Brite.

If there are micro-bubbles, running, rejects or numerous inclusions:
Reactivate the surface using an abrasive paper (grade 220 to 320), remove the dust then clean the surface using an approved cleaning product. Apply a thin coat of AEROPRIM 530 to achieve the desired thickness.

In case of significant defects:
Remove the AEROPRIM 530 primer with an approved chemical paint remover or remove using a plastic medium (in this case, the surface treatment has to be repeated).

Health & Safety

See the product Safety Data Sheet.

The MSDS are available through our website www.mapaero.com .

Packing

The AEROPRIM 530 base is available in 1 L and 5 L for the Sand Yellow and 2 L for the other colors.
The AEROPRIM 530 hardener is available in 1 L and 5 L.
The thinner E is available in 1 L and 5 L.

WARRANTY : We guarantee our products against hidden defaults over material and preparation. Our Responsibility is limited to the obligation of freely replacing the defective material without there being a claim for any compensation. The advice we give is based on our experience but it might not be absolutely right. Consequently this does not imply our responsibility in case of inefficiency. Furthermore our company cannot be responsible for any material or corporal damages caused due to a misuse or mishandling of our products. Any concession to these clauses, to be valid, must be an official document issued by our offices and signed by our direction.

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