

Spray2Fix 10P20-13SC

Epoxy Primer

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics



Product
Information

- Aerosol Spray Can Application 10P20-13/EC-213.
- This low VOC two-component epoxy primer exhibits excellent corrosion resistance with good flexibility and chemical resistance.

Specifications



Qualified
Product List

US Military MIL-PRF-23377 Type I, CI C2

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

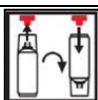
Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process.
- Primer should be applied per the requirements of MIL-PRF-23377

Instruction for Use



Activate

To Activate Remove the red button from the over cap and attach to the plastic pin at the bottom of the aerosol.



Activation Test Place aerosol upright on a flat surface and push down to break the inner seal. Remove red button from the bottom of the aerosol and push plastic pin with thumb, the pin should now move easily.



Induction Time

Turn can upside down. Shake the aerosol vigorously for 2 - 3 minutes after activation to thoroughly mix catalyst. Induct for 30 minutes.

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Pot life
(25°C/77°F)

48 hours at 77°F (25°C), and 50 ± 5% RH.



Dry Film
Thickness
(DFT)

15 – 23 micron (μm)
0.6 – 0.9 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.



Application
method

After activation and induction, spray in a normal fashion.

You will note that the delivery of material is faster than a normal aerosol, and that the fan is larger. Both features are designed to make the application similar to that of a spray gun.



Cleaning nozzle

Invert the aerosol and spray until clear.

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Physical Properties

	Drying Times (25 +/- 2°C / 77 +/- 2°F, 55 +/- 5% RH)	Dry to dust 1.5 – 2 hrs Dry to tape 4 – 5 hrs Full cure 7 days @ 77°F(25°C) 50% RH Dry to topcoat 5 hours @ 77°F(25°C) 50% RH
	Theoretical Coverage	31 ft²/ Aerosol @ 0.8 mil
	Dry Film Weight	47.28 g/m²/ 25 micron 0.00968 lbs/ft²/ 1 mil
	VOC not applicable to aerosols. Alternative regulations based on reactivity method of calculating emissions	Regulation for Reducing the Ozone Formed from Aerosol Coating Product Emissions by California Air Resources Board (CARB): Aviation Primer Product-Weighted MIR Limit: 2.0 g O ₃ /g Complies National Volatile Organic Compound Emission Standards for Aerosol Coatings, EPA: Aviation Primer Product-Weighted Reactivity Limit: 2.0 g O ₃ /g Complies
	Gloss (60°)	60 – 95 GU
	Color	Yellow
	Flash-point	10P20-13SC -16°C / 1°F

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Storage

Store the product dry and at a temperature between 5 and 38°C / 40 and 95°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 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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