

Aviox CF Primer 37124

Technical Data Sheet

Product Group

Epoxy Primers

Characteristics



Product
Information

Aviox CF Primer 37124 is a 2-component amine cured epoxy primer for exterior use.

- Developed as a refresh primer, to be applied over "basic" primers (Airbus OEM).
- Resistance to aircraft hydraulic fluids and chemicals.
- Corrosion inhibiting.
- Compatible with polyurethane and epoxy topcoats.
- High Solids.

Aviox CF Primer 37124 is a product part of the Aviox Advanced Series which utilizes the latest high solid technology and sets the standard for minimum process times and reduced process cycle costs.

Components



Curing Solution
Thinner /
Activator

Hardener 92245
Do not add any thinner.

Specifications



Qualified
Product List

Airbus	AIMS 04.04.031
	AIMS 04.04.032
	AIMS 04.04.033
	AIMS 04.04.034
	AIMS 04.04.036
	AIMS 04.04.037

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

Surface Conditions



Cleaning

- Clean aged basic primer or epoxy / polyurethane finishes with solvent cleaning 98068, and sand with Scotch-Brite® type A very fine to a uniform and matt surface.
- Rivets and fasteners should be cleaned with Solvent Cleaning 98068, and sanded with Scotch-Brite® type A very fine prior to application of the Aviox CF Primer 37124.
- Remove dust with e.g. tack rags.

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Instruction for Use



Mixing Ratio
(volume)

100 parts
50 parts

Aviox CF Primer 37124
Hardener 92245

- Allow products to acclimatize to room temperature before use.
- Stir or Shake Aviox CF Primer 37124 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92245 and stir the catalyzed mixture thoroughly for at least 2 minutes.



Induction Time

Not applicable.



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

23 – 33 seconds ISO-Cup 4.
16 – 19 seconds Gardner Signature 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)

2 hours



Dry Film
Thickness
(DFT)

15 – 25 μm
0.6 – 1.0 mils

Application Recommendations



Conditions

Temperature: 20 – 35°C
68 – 95°F
Relative Humidity: 35 – 75%

Note

Aviox CF Primer 37124 may be applied in conditions outside of the the limits shown above. Care must be excercised to ensure a satisfactory

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result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.



Equipment

Air	1.4 mm nozzle orifice
HVLP	1.4 mm nozzle orifice
Air Electrostatic	1.2 mm nozzle orifice
Airless Electrostatic	6.11 – 6.13, (.011 - .013 inch) angle 60°



Number of Coats

Spray an even closed wet coat.



Cleaning of equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068.



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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Physical Properties



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

Set to touch	1 hour
Dry hard	3 hours
Recoat minimum	3 hours
Recoat maximum	72 hours
Recoat maximum	If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.

When using Aerodur Sealer 42240 after Aviox CF Primer 37124, the following overcoat times apply:

Temperature	Relative Humidity	Aviox CF Primer 37124
20°C / 68°F	30 – 80%	1½ – 3 hrs
25°C / 77°F	20 – 70%	1 – 2½ hrs
30°C / 86°F	20 – 60%	1 – 2 hrs

Note: if for sealer coat application the recommended overcoat time of Aviox CF Primer 37124 is exceeded a fresh layer of the primer must be applied according to the TDS in order to ensure optimal adhesion of the system.



Theoretical
Coverage

37 m² per liter base material at 20 µm dry film thickness.
1484 ft² per US gallon base material at 0.8 mil dry film thickness.



Dry Film Density

1.5 g/µm/m²



Volatile Organic
Compounds

High Solids



Gloss (60°)

Maximum 60 GU



Color

Approximately RAL1014

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Flash-point

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Hardener 92245

>21°C /70°F
>21°C /70°F



Storage

Store the product dry and at a temperature between 5 and 35°C / 41 and 95°F. Stored in the original unopened containers.

Shelf life
5 - 38°C
(40 - 100°F)

Aviox CF Primer 37124
Hardener 92245

12 months
12 months

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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