

PRIMER Isomap P21

FINISHES FOR AIRCRAFT EXTERIORS

AkzoNobel

Product information



Three components, chromate free polyurethane primer, used for aircraft outside on aluminium alloy or composite substrate.

Components



Base P21
Hardener / Catalyst P21
Thinner P2

Physical properties



THEORETICAL COVERAGE
16m²/L for 20µm (0.8 mils) dry

DRY FILM WEIGHT
1.5

VOC
685 g/L (ISO 11890-1 and ASTM 3960)

SHELF LIFE / STORAGE
24 months for the base and the hardener, 48 months for the thinner stored between 5°C and 35°C in full and sealed original cans

NOTES

The theoretical consumption value don't take into account the transfer efficiency for spray application.

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

Base
Hardener / Catalyst
Thinner

Mixing ratio by weight

100
42
40 to 80

Mixing ratio by volume

2V
1V
1V to 2V

MIXING PROCEDURE

Ideally, the unmixed products should be stored between 18°C (64°F) and 25°C (77°F) for 24 hours before use.

The mixture by weight is recommended.

Mix the base and hardener until the material is homogeneous. Then add thinner and mix.

The mixture must be made at a temperature between 15°C and 35°C (59-95°F).

Remark : It is recommended to sieve the material using 80µm (3.2 mils) filter.

INDUCTION TIME

20 minutes

Spraying viscosity at 20°C / 68°F

Dilution
60%

AFNOR 2.5
50s ± 5s

POT LIFE

8 hours at 23°C

NOTE

- The viscosity mentioned above is 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.

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Application
recommendations



CONDITIONS

Temperature 15°C to 35°C (59-95°F)

Relative humidity 30% to 75%

EQUIPMENT

Gravity compressed air gun Nozzle 1.8mm to 2.1mm

Electrostatic gun Nozzle 1.4mm to 1.8mm

DRY / WET FILM THICKNESS

20 to 30µm (0.8-1.2mils) dry

NUMBER OF COATS

Apply one thick crossed coats to achieve the desired thickness.

EQUIPMENT CLEANING

Clean the equipment with a suitable equipment such as P2 from Mapaero

NOTE

Spray with dry and oil-free air.

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Drying times



Dust free
Dry to tape
Recoat able

23°C	40°C	60°C
20 minutes	N.A	N.A
2 hours	1 hours	30 minutes
6 to 72 hours	2 hours	1 hour

NOTE

Drying times have determined using pieces of a thickness < 2mm and for 25µm (1 mil) of dry film.
Let it flash off 1 hour at room temperature before drying at 60°C (140°F).

N.A : Not Applicable

Defects & corrections



In the event of defect, please contact our Quality Department.

Health & Safety



See the product Safety data Sheet.
MSDS are available through our website www.mapaero.com upon request.

Packing



The P21 base is available in 4L.
The P21 hardener is available in 2L.
The P2 thinner is available in 1L and 5L.

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.