

PRIMER Isomap P23

FINISHES FOR AIRCRAFT EXTERIORS

AkzoNobel

Product information



Polyurethane primer with strontium chromate, used for the protection of aircrafts interiors and exteriors.

Components



Base P23
Hardener / Catalyst P23
Thinner P2

Specifications



Qualified in accordance with:
French Air Force STPA-MA N°2859-LE-92

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

Physical properties



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

DRY FILM WEIGHT
1.8

VOC
720 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 (41-95°F) in full and sealed original cans.

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

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	2V
Hardener / Catalyst	38	1V
Thinner	40 to 60	1.2V to 1.8V

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

None

Spraying viscosity at 20°C / 68°F

Dilution	AFNOR 4	AFNOR 2.5
1,5V	14s ± 5s	45s ± 5s

POT LIFE

8 hours at 23°C (73.4°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.

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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 1.2mm to 2.1mm

Electrostatic gun Nozzle 1.2mm to 1.8mm

Pot under pressure or pump 0,8 to 1,2 mm

Airless 0,009 to 0,013 inch.

DRY / WET FILM THICKNESS

15 to 25µm (0.6-1 mil) dry/ 80 to 130 µm (3.2 - 5.1 mils) wet

NUMBER OF COATS

Apply 1 or 2 crossed coats to achieve the desired thickness.

EQUIPMENT CLEANING

Clean the equipment with a suitable thinner such as P2 or Diestone E.

NOTE

Spray with dry and oil-free air.

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Drying times



	23°C	40°C	60°C
Dust free	30 to 40 minutes	N.A.*	N.A.*
Dry to tape	1 hour	30 minutes	15 minutes
Recoatible	2 to 72 hours	1 to 24 hours	1 to 10 hours

NOTE

Drying times have determined using pieces of a thickness < 2mm and for 20µm (0.8 mil) of dry film. Let it flash off 1 hour at room temperature before accelerated drying.

N.A.*: Not Applicable

Primer P23 is recoatable with A1000, A1500-M, F14, F15. Please contact us for information on other finishes.

Defects & corrections



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

Health & Safety



See the product Safety Data Sheets.
The MSDS are available on our website www.mapaero.com

Packing



The P23 base is available in 1L and 4L.
The P23 hardener is available in 0.5L and 2L.
The P2 thinner is available in 1L and 5L.
The P23 Kit is available in 1.5L (1L base and 0.5L hardener).

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.