

PRIMER P60-2K

COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

AkzoNobel

Product information



Strontium chromate-based, two component water-reducible epoxy primer, with high chemical resistance. This product is designed for the protection of metallic structures on aircraft.

P60-2K primer is recommended for use in combination with Mapaero F70-2K structural topcoat.

Components



Base P60-2K
Hardener / Catalyst H2K

Specifications



Qualified to:
Embraer: MEP 10-059 Type III

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
18 m²/l (800 ft²/gal) for 15 µm (0.6 mils) dry

DRY FILM WEIGHT
1.7

VOC
160 g/l (ISO11890-1) and 340 g/l (ASTM D3960)

COLOR
Green

SHELF LIFE / STORAGE
12 months for the base and hardener, stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.
12 months in P60-A Touch-Up Kits, 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 theoretical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation



P60-2K primer is used particularly on aluminium alloys that have had the following treatments:

Alodine 1200: Cr6 conversion
CAA: Chromic Acid Anodising
SAA: Sulphuric Acid Anodising
TSA: Tartaric Sulphuric Anodising
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.
P60-2K primer can also be used on sealants.

All recommendations 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	5 V
Hardener / Catalyst	18	1 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 P60-2K base should be mixed for 10 minutes in a pneumatic or oscillating mixer before use. Mix the base and hardener until the mixture is homogenous. The mixture must be made at a temperature between 15°C and 35°C (60°F and 95 °F). Sieve the paint through a 120-150 µm (4.0-6.0 mils) filter.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

ISO 4 Cup	Zahn 2 Cup
26 ± 3s	21 ± 3s

POT LIFE

4 hours at 23°C

NOTE

The paint viscosity may vary depending on the temperature and increases over the pot life.

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

ISO 4 cup is the reference cup. The others are given for informations purpose

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BRUSH APPLICATION

	Mixing ratio by weight	Mixing ratio by volume
Base	100	2V
Hardener / Catalyst	38	1V

MIXING PROCEDURE

Remove the safety ring and press down on the cap to release the hardener. Shake the container for approximately 1 minute. Remove the cap to be able to apply the P60-2K primer with a suitable brush. If the material after shaking 1min is not homogenous, please use a stick for further mixing (around 1min) until the material is homogen.



Do not hermetically close TUKs after mixing base and hardener.

POT LIFE

4 hours at 23°C

NOTE

Brush application has to be done with P60-A

Application recommendations



CONDITIONS

Temperature 15°C to 35°C (60°F to 95°F)

Relative humidity 20% to 85%

EQUIPMENT

Gravity compressed air gun Nozzle 0.8 to 1.8 mm

Electrostatic spray gun Nozzle 0.8 to 1.4 mm

DRY / WET FILM THICKNESS

15 to 25 µm (0.6 to 1 mil) dry / 50 to 80 µm (2 to 3.1 mils) wet

NUMBER OF COATS

Apply several coats to achieve 15 to 25 µm (0.6 to 1 mil) dry thickness.

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 a suitable cleaning solvent such as Mapaero D770-C aqueous cleaning solvent can also be used for cleaning the ready-to-use mixture.

NOTE

Spray with dry, oil-free air.

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Drying times



	23°C (73°F)	60°C (140°F)	80°C (176°F)
Dust free	15 minutes	N.A*	N.A*
Recoatable	1 hour to 72 hours	30 minutes to 2 hours	10 to 35 minutes
Fully Cured	3 days	3 hours	35 minutes

NOTE

Drying times have been determined using test pieces of a thickness < 2 mm and for 15 µm (0.6 mils) of dry film. Before accelerated drying 70°C, leave to flash off for at least 15 minutes at room temperature. Before recoating the P60-2K with the F70-2K finish, drying is recommended at 60°C (140°F) or more. To recoat P60-2K primer with another product, contact us. For the infrared drying of P60-2K primer, contact us.

*N.A. : Not applicable

Defects & corrections



In the event of a defect, contact your Quality Department. **In case of low thickness:**

Apply a thin coat of P60-2K to achieve the required thickness. If the above recommended recoating time is exceeded, reactivate with an abrasive pad.

For thick coats:

Contact your Quality Department.

If there are micro-bubbles, running, rejects or numerous inclusions:

Reactivate the surface using a abrasive paper (grade 220 to 320), remove the dust then clean the surface using an approved cleaning product. Apply a thin coat of P60-2K to achieve the required thickness.

If there are significant defects:

Remove the P60-2K 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



P60-2K base is available in 5 liters and 200 liters container.

H2K hardener is available in 1 liter and 200 liters container.

P60-2K kit is also available: 45 ml & 12 ml Touch-Up Kits (TUK) and a 6 liters Kit.

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.