

Spray2Fix 10P20-44SC

HS Epoxy Primer

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics



Product
Information

- A high solids urethane compatible, Skydrol® resistant primer for the exterior of aircraft . It provides excellent corrosion resistance and excellent adhesion for urethane topcoats.
- Aerosol Spray Can Application, the components (10P20-44 & EC-273) are packaged in a 250ml or 400 ml aerosol can for ease of use as a touch up and repair product.

Specifications



Qualified
Product List

AkzoNobel Aerospace Coatings
BMS 10-72 Type VIII & IX, Performance

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

Surface Conditions



Cleaning

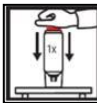
- Surface pretreatment is an essential part of painting process.
- Refer to Eclipse Process Standard for detailed instructions.
- Surface pretreatment is an essential part of the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

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 Remove red button from the bottom of the aerosol and push plastic pin with thumb, the pin should now move easily.

Mixing Turn activated can upside down and shake vigorously for 2 - 3 minutes.



Induction Time

15 minutes
Prior to application, invert can and spray until a light green color is visible to clear the nozzle.

Spray2Fix 10P20-44SC HS Epoxy Primer



Pot life
(25°C/77°F)

8 hours



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

After use, invert can and spray until clear to clear the nozzle.

If aerosol is left standing, shake vigorously prior to each use.

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Physical Properties



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

Dry to handle	8 – 12 hrs
Dry to topcoat	2.25 hrs
Dry to tape	2.25 hrs
Full cure	7 days

Accelerated Cure

To topcoat	Flash off 15 – 30 minutes @ ambient temperature and 50% RH, then ½ hr @ 60°C (140°F).
Full cure	Flash off 15 – 30 minutes @ ambient temperature and 50% RH, then 24 hrs @ 60°C (140°F)



Theoretical Coverage

Can size: A400 2.1 m² per can ready to apply at 25.4 µm dry film thickness 22.9 ft² per can ready to apply at 1 mil dry film thickness

Can size: A250 1.3 m² per can ready to apply at 25.4 µm dry film thickness 13.8 ft² per can ready to apply at 1 mil dry film thickness



Dry Film Weight

42 g/m²/25 micron
.008 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 O₃/g Complies

National Volatile Organic Compound Emission Standards for Aerosol Coatings, EPA:

Aviation Primer Product-Weighted Reactivity Limit: 2.0 g O₃/g Complies



Gloss (60°)

10 – 60 GU

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Color

Yellow



Flash-point

10P20-44SC

-16°C / 1°F



Storage

Store the product dry and at a temperature between 5 and 35°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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