

Aerodur 2100 MgRP

Technical Data Sheet

Product Group

Corrosion Inhibiting Epoxy Primer using VOC exempt solvents

Characteristics

A corrosion inhibiting epoxy- modified polyamide primer formulated using unique chrome free inhibitors.



Product
Information

Components



Base material	2100P004 (Red Tint)
Curing Solution	Curing Solution CS6010
Thinner	TR-114 or TR-7005

Specifications



Qualified
Product List

AkzoNobel Aerospace Coatings	Certification
German Army (WIWEB)	TL8010-0046
Gulfstream	GMS 5008 (reference ECM 20001)
Italian Air Force	AER(EP)_M_P_001
US Military/Danish Air Force	MIL-PRF-32239 Ty II, Cl 1, Gr1
SAE International	AMS 3095B

Product specifications change constantly, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

Surface Conditions



Cleaning

Surface pretreatment is a recommended part of the painting process.

Substrate Cleaning Options:

1. Solvent clean, Scotch-Brite® abrade, DI rinse to water-break free condition, or
2. Scotch-Brite® abrade, alkaline clean with cleaner such as Turco 5948 or similar to manufacturer's instructions.

Followed by 1 of 4 pretreatment options:

1. Metaflex SP 1050 per instructions, or

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2. PreKote per manufacturer's instructions, or
3. AC-131 (Boegel) per manufacturer's instruction.
4. Direct to metal per TL8010-0046 specification.

Instruction for Use



Mixing Ratio

	Volume (v/v)	Weight (w/w)
2100P004	200.0 parts	
Curing Solution CS6010	4 parts	43.7 parts
TR-114 or	1 part	43.4 parts
TR-7005	1 part	43.75 parts
	1 part	

- Shake 2100P004 Primer Base until all pigment is uniformly dispersed before adding Curing Solution.
- Add CS6010 Curing Solution to 2100P004 Base.
- Stir the catalyzed mixture thoroughly.
- Slowly add TR-114 or TR-7005 Reducer while mixing or stirring.



Induction time

30 minutes



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

18 – 22 seconds #4 Ford Cup
33 – 59 seconds ISO Cup #4



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)

4 hours



Dry Film
Thickness
(DFT)

25 – 35 μm
1.0 – 1.4 mils

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Application Recommendations



Conditions

Temperature: 15 – 35°C
59 – 95°F
Relative Humidity (RH): 35 – 75%



Note

Aerodur 2100 MgRP may be applied in conditions outside of the limits shown above. Care must be exercised to ensure a satisfactory 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 recommendation

Air tip size: 1.2 – 1.4 mm
HVLP tip size: 1.2 – 1.4 mm, air pressure 25 – 30 psi
HP air assist airless electrostatic tip size: .011 - .013 inch / 0.28 - .033 mm (Graco Pro 4500, or Graco XS-4 e.g.), air pressure 40 psi (30:1 pump)



Number of Coats

Apply in one even coat to achieve the required film thickness of 25 – 35µm (1.0 – 1.4 mils).



Cleaning of equipment

MEK or similar.

Physical Properties



Drying Times
(25°C / 77°F,
55% RH)

Tack free	20 minutes
Recoat minimum	3 hours
Recoat maximum	48 hours

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Theoretical
Coverage

15.8 m² per liter ready to apply at 325.4 µm dry film thickness
644 ft² per US gallon ready to apply at 1.0 mil dry film thickness



Dry film weight

37.5 g/m²/µm
0.007677 lbs/ft²/mil



Volatile Organic
Compounds

TR-114	TR-7005
Max 340 g/l	Max 353 g/l
Max. 2.82 lbs/gal	Max 2.95 lbs/gal



Note

The use of TR-7005 will affect reportable VOC.



Color

Red Tint



Gloss (60°)

10 maximum GU



Flash-point

2100P004	35°C / 95°F
Curing Solution CS6010	12°C / 54°F
TR-114	-17°C / 1°F
TR-7005	-17°C / 1°F



Storage

Store the product dry and at a temperature between 5 – 38°C / 41 – 100°F. Store in the original unopened containers. Refer to container label for specific storage life information.

Shelf life
5-38°C / 41-
100°F

12 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.

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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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