

10P8-10NF

Technical Data Sheet

Product Group

Epoxy Primer

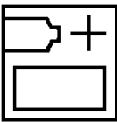
Characteristics



Product Information

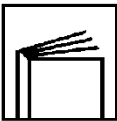
A chemically cured fluid-resistant epoxy primer designed to provide excellent corrosion and chemical resistance for aircraft detail and sub-assembly parts.

Components



Base	10P8-10NF
Curing Agent	Curing Solution EC-283

Specifications



Qualified Product List

Boeing	BMS 10-11, TY I CL A GR B
Embraer	MEP 10-059, TY II
Israel Aerospace Industries	MS100013E
Piper Aircraft Inc	PMS-F1003-8
Spirit Aerosystems	SMS-111202, TY 1 CL 1 GR B

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

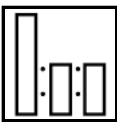
Surface Conditions



Surface Preparation/
Cleaning

Surface pretreatment is an essential part of the painting process. Follow the specification requirements for cleaning and pretreatment application.

Instruction for Use



Spray Application

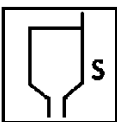
	Volume
10P8-10NF	1 part
Curing Solution EC-283	1 part

- Allow products to acclimatize to ambient conditions before use.
- Stir or shake the base component thoroughly to a homogeneous state prior to the addition of the curing solution.
- Add Curing Solution EC-283 and stir the catalyzed mixture thoroughly prior to application.



Induction Time

Not Applicable.



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

40 – 55 seconds ISO Cup #3
15 – 19 seconds EZ Zahn Cup #2
24 – 28 seconds Ford Cup #4



Note

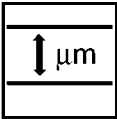
Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.



Pot life (25°C/77°F)

8 hours

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Dry Film Thickness
(DFT)

12.7 – 17.8 μm
0.5 – 0.7 mil

Application
Recommendations



Conditions

Temperature: 15 – 35 °C
59 – 95 °F

Relative Humidity: 35 – 75 %



Note

10P8-10NF may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.



Equipment
Recommendation

Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *
Conventional	N/A	N/A	1.2-1.4 mm	N/A	3-5 bar / 43-73 psi
HVLP / Next Generation	N/A	N/A	1.2-1.4 mm	N/A	2-2.5 bar / 29-36 psi**
Air Atomizing (electrostatic)	N/A	N/A	N/A	N/A	N/A
Pressure Atomizing (electrostatic)	N/A	75-90 bar / 1-1.3k psi, 25-35 bar / 0.4-0.5k psi	0.009 inch/60°, 0.013 inch/60°	260-300 ml/min	4-4.5 bar / 58-65 psi

*Measured with an open trigger.
**General advice to meet the HVLP / next-generation spray gun requirements. Please validate with your local authorities.



Number of Coats

Spray a single uniform wet coat to recommended dry film thickness.



Cleaning of Equipment

MEK

Physical Properties



Drying Times

25°C/77°F, 55% RH	
Dust Free	15 minutes
Tack Free	30 minutes
Dry to Topcoat	2 hours
Dry Through	4 hours
Recoatable Maximum	24 hours

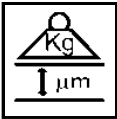
If a drying time of 24 hours is exceeded, recondition the primer to a uniform matt surface with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad. Check the relevant specification to determine if reapplication of 10P8-10NF is necessary after reactivation.

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Theoretical Coverage

8.6 m² per liter ready to apply at 25 µm dry film thickness.
350 ft² per US gallon ready to apply at 1 mil dry film thickness.



Dry Film Weight

47.8 g/m²/25 µm
0.01 lbs/ft²/1 mil



Volatile Organic
Compounds

350 g/L / 2.9 lbs/gal – excluding exempt solvents according to US EPA
718 g/L / 6.0 lbs/gal



Gloss (60°)

Maximum 10 GU



Color

Green, BAC 452



Flash Point

10P8-10NF	-17°C / 1°F
Curing Solution EC-283	-17°C / 1°F



Storage

Store the product dry and at a temperature between 5 and 38°C / 41 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature and shelf life may vary per OEM specification requirements. Refer to the container label for specific storage life information.

Shelf life 5 - 38°C (41 - 100°F)	10P8-10NF	24 months
	Curing Solution EC-283	24 months

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.

Revision date: March 2024 (supersedes October 2023) - FOR PROFESSIONAL USE ONLY

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. Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel