10P8-10NF
Fluid Resistant Epoxy Primer
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 subassembly parts.

Components

Curing Solution

Curing Solution: EC-283

Specifications

Qualified Product List

Boeing	BMS 10-11, Type I, Class A, Grade B
Embraer	MEP 10-059 Type II
Piper	PMS-F1003
Spirit	SMS 111202, Type 1, Class 1, Grade B

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 the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

Instruction for Use

Mixing Ratio (volume)

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

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.

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Induction Time	None
Initial Spraying Viscosity (25ºC/77ºF)	40 – 55 seconds ISO-Cup #3 17 ± 2 seconds Zahn Cup #2 24 ± 4 seconds Ford #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 (25ºC/77ºF)	8 hours.
Dry Film Thickness (DFT)	12.7 – 17.8 micron (µm) 0.5 – 0.7 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.	

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Equipment	Air	1.2 – 1.4 mm nozzle orifice
	HVLP	1.2 – 1.4 mm nozzle orifice
	High Pressure	
	Airless Electrostatic	0.23 – 0.28 mm nozzle orifice
Number of Coats	Spray a single uniform wet coat to recommended dry film thickness.	
Cleaning of Equipment	MEK	

Physical Properties

Drying Times (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Dust-free	15 minutes
	Tack free	30 minutes
	Dry to topcoat	2 hours
	Dry through	4 hours
Theoretical Coverage	8.6 m^2 per liter ready to apply at 25 µm dry film thickness 0.01 ft^2 per US gallon ready to apply at 1 mil dry film thickness	
Dry Film Weight	47.8 g/m^2/25 micron 0.01 lbs/ft^2/1 mil	
Volatile Organic Compounds	350 g/l (per US calculations) Max. 2.9 lb/gal	

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Gloss (60º)	<10 GU	
Color	Green, BAC 452	
Flash-point	10P8-10NF EC-283	-17°C / 1°F -17°C / 1°F
Storage	Store the product dry and at a temperature between 5 and 38ºC / 40 and 100ºF 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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