

Code 20-16

Epoxy Primer 37035A

Product Group

Epoxy Primers

Characteristics



Product Information

Epoxy Primer 37035A is a 2 or 3-component amine cured epoxy primer with improved adhesion properties for interior and exterior use.

- Adheres to degreased, sealed and non-sealed anodized and alodined substrates.
- Resistance to aircraft hydraulic fluids and chemicals.
- Corrosion inhibiting.
- Compatible with polyurethane, epoxy and acrylic topcoats.

Components



Hardener Thinner or Activator Hardener 92140 (for 3 component version)

Hardener 92162 (for two component, plural mixing systems)

Thinner C 25/90 S (normal conditions)

Thinner 98064 (warm conditions, flashpoint >21°C)

Thinner 96184 (warm conditions)

Specifications



Qualified Product List Airbus AIMS 04.04.001 / 003 / 004

British Aerospace BAER 7004 AVRO AVP 3-003 Fairchild Dornier DOL 255

EFA SP-J-513-A-0016 type 1, Class A

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

Surface Conditions



Cleaning

- Prime chemical conversion coatings and anodized parts in a fresh condition.
- When Epoxy Primer 37035A is applied on non chemically pretreated aluminium, the substrate should be thoroughly cleaned and degreased with Solvent Cleaning C 28/15 (normal conditions) or Solvent Cleaning 98068 (warm conditions)
- Treat new aluminium with Scotch brite type A very fine to a uniform matt surface.
- Clean aged primer or epoxy / polyurethane finishes and sand with Scotch brite type A very fine to a uniform and matt surface.
- Remove dust with e.g. tack rags.

Instruction for Use

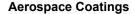


Mixing Ratio 3 component version (volume) 100 parts Epoxy Primer 37035A 50 parts Hardener 92140 Reduce to spraying viscosity with:

50 - 100 parts Thinner C 25/90S, Thinner 98064 or Thinner 96184

- Allow products to acclimate to room temperature before use
- Stir or Shake Epoxy Primer 37035A till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92140 and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.

September 2003 (supersedes October 2000)





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Induction Time

15 – 30 minutes after mixing (3 component system only)



Mixing Ratio 2 component version (volume) 100 parts 100 parts Epoxy Primer 37035A Hardener 92162

- Allow products to acclimate to room temperature before use
- Stir or Shake Epoxy Primer 37035A till all pigment is uniformly dispersed before adding hardener
- The 2 component version has been developed for use with plural mixing systems



Initial Spraying Viscosity (21°C/70°F)

32 - 36 seconds ISO-Cup 3.

25½ - 27 seconds Gardener Signature Zahn-Cup #1.



Potlife (21°C/70°F)

8 hours (3 component version)



Dry Film Thickness (DFT)

 $15 - 20 \mu m$.59 - .79 mils

Application Recommendations



Conditions

Temperature: $15 - 35^{\circ}\text{C}$ $59 - 95^{\circ}\text{F}$ Relative Humidity: $35 - 75^{\circ}$



Equipment

Air 1.4 mm nozzle orifice HVLP 1.4 mm nozzle orifice Air Electrostatic 1.2 mm nozzle orifice

Airless Electrostatic

6.11 - 6.13, (.011 - .013 inch) angle

60°



Number of Coats

Spray an even wet coat



Cleaning of Equipment Solvent Cleaning C 28/15 or Solvent Cleaning 98068



Note

The way of application, skills and experiences of the painter and surrounding conditions (temperature, relative humidity, airspeed) significantly affect the final appearance and dry film thickness. When using the product for the first time it is strongly recommended to apply some test panels first.

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Physical Properties



Drying Times (21°C/70°F) Set to touch 30 minutes
Dry hard 4 hours
Recoatable minimum 4 hours

Recoatable maximum 72 hours. If a drying time of 72 hours is

exceeded, condition surface with e.g.

Scotch brite very fine.



Theoretical Coverage

 27 m^2 per base material at 15 μm dry film thickness

1100 ft² per US gallon base material at 0.59 mil dry film thickness



Gloss (60°)

Maximum 20 GU



Color

Yellow / Green Green 702267 Green BAC 452

Black



Flash-point Epox



Storage

Store the product dry and at a temperature between 5 and 25°C/41 and

77°F.

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.

Warranty

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