

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.

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



Mixing Ratio 2 component version (volume) 100 parts Epoxy Primer 37035A
100 parts 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 Gardner Signature Zahn-Cup #1.



Potlife (21°C/70°F) 8 hours (3 component version)



Dry Film Thickness (DFT) 15 – 20 µm
.59 – .79 mils

Application Recommendations



Conditions Temperature: 15 – 35°C
59 – 95°F
Relative Humidity: 35 – 75%



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
Recoat minimum	4 hours
Recoat maximum	72 hours. If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch brite very fine.



Theoretical Coverage

27 m² 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

Epoxy Primer 37035A	<21°C / 70°F
Hardener 92140	<21°C / 70°F
Hardener 19162	<21°C / 70°F
Thinner C 25/90 S	<21°C / 70°F
Thinner 98064	>21°C / 70°F
Thinner 96184	<21°C / 70°F



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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