

Aerowave 2001

Technical Data Sheet

Product Group

Characteristics



Product Information

Epoxy Primer

Aerowave 2001 is a chromated corrosion inhibiting, low VOC, water-based, 2- component amine cured epoxy primer.

- Water-based technology.
- Compatible with all products of the Aerowave Series.
- Designed for optimal mixing properties for both manual and plural mixing application.
- Corrosion inhibiting.
- Low VOC emission.
- Low dry-film-weight (DFW).
- Resistance to aircraft hydraulic fluids and chemicals.

Aerowave 2001 is a product part of the Aerowave Series which utilizes the latest water-based technology and sets the standard for minimum process times, reduced process cycle costs and environmental care.

Components



Base	Aerowave 2001
Hardener	Hardener 6005

Specifications



Qualified Product List

Airbus Canada	A2MS 565-001 Grade B Category 2 Type I
Airbus	AIMS 04-04-001
Airbus	AIMS 04-04-003
Airbus	AIMS 04-04-004
Airbus	AIMS 04-04-038
Airbus	AIMS 04-04-040
Airbus	AIMS 04-04-042
Bombardier	BAMS 565-001 Class CR Grade B Cat 2 Type 1
Embraer	MEP 10-059 TY III
Eurofighter	SP-J-513-A-0016 Type III Class A

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



Surface Preparation/
Cleaning

Prime chemical conversion coatings and anodized parts in a fresh condition according the OEM guideline.

Clean aged primer or finish and activate the substrate using grade P320 sandpaper or an aluminum oxide non-woven abrasive pad to a uniform matt surface.

Remove dust with e.g. tack rags prior to application of the primer.

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Instruction for Use



Spray Application (Mix Ratio)

	Volume	Weight
Aerowave 2001	3 parts	100 parts
Hardener 6005	1 part	28 parts

When mixing <1L dose by weight.

- Allow products to acclimatize to room temperature before use.
- Homogenize Aerowave 2001 until all pigment is uniformly dispersed before adding the hardener.
- Add Curing Solution 6005 and stir the catalyzed mixture thoroughly for at least 60 seconds.
- Automated dispensing units in combination with plural mixing devices can be applied for Aerowave 2001.



Induction Time

Not applicable. The product can be used directly after mixing.



Initial Spraying Viscosity
(23°C/73°F)

35 – 65 seconds ISO Cup #4
17 – 30 seconds Gardner Signature Zahn Cup #2



Note

Stir the mixed components thoroughly shortly before measuring the viscosity. 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. Shaking the components can entrap air which is not favourable for viscosity measurements.



Pot life (23°C/73°F)

6 hours at 23°C / 73°F
4 hours at 30°C / 86°F



Note

The end of pot life is not visible by means of viscosity increase. Please respect pot life as described, and mind that pot life depends on the temperature.



Dry Film Thickness (DFT)

15 – 25 µm
0.6 – 1 mil

Application Recommendations



Conditions

Temperature: 15 – 35 °C
59 – 95 °F

Relative Humidity: 25 – 80 %



Note

Aerowave 2001 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.

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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 – 1.5mm	350 mL/min ¹	4 – 4.5 bar / 58 – 65 psi ²
HVLP / Next Generation	N/A	N/A	1.2 – 1.5mm	350 mL/min ¹	2 – 2.5 bar / 29 – 36 psi ³
Air Atomizing (electrostatic)	N/A	N/A	1.2 – 1.5mm	350 mL/min ⁴	4 – 4.5 bar / 58 – 73 psi ²
Pressure Atomizing (electrostatic)	N/A	N/A	0.009 inch/60° 0.013 inch/60°	65 – 75 bar/1.02 kpsi 25 – 35 bar/0.43 kpsi	4 – 4.5 bar / 58 – 65 psi ²



Note

- ¹ Product Flow not applicable when using gravity/suction feed guns.
- ² Dynamic Air Pressure at gun-inlet measured with an open trigger.
- ³ General advice to meet the HVLP / next generation spray gun requirements, please validate with your local authorities.
- ⁴ When using water-based products ensure you select suitable electrostatic equipment.

To avoid contamination of water- / solvent-based coating products it is advised to use dedicated water-/ solvent-based spray equipment. For the application of water-based products use noncorrosive spray equipment (e.g. stainless steel).



Number of Coats

Spray-apply a homogeneous, wet and closed coat in order to achieve a dry film thickness of 15 – 25 µm / 0.6 – 1.0 mil.



Cleaning of Equipment

Selecting the correct cleaning solvent for cleaning the spray equipment (gun, hoses, pumps) will prevent coagulation or clogging of the paint material inside the equipment due to incompatibility. Clean and rinse the equipment with water directly after use. If necessary, semi-cured material can be cleaned with organic solvents like cleaning solvent C 28/15, 98068 or Thinner C 25/90 S. In case of the switch from water-based to solvent-based always first clean and rinse with water, followed by two times rinsing with fresh Thinner C 25/90 S. Due to the chemical composition, this material is compatible with water.



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 to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Physical Properties



Drying Times

	23°C/73°F, 55% RH	60°C/140°F	80°C/176°F
Surface Dry	30 minutes	15 minutes*	10 minutes*
Dry to Handle	2 hours	NA	NA
Chemical Resistant	48 hours	45 minutes*	30 minutes*

* Elevated temperature dry times refer to substrate surface temperature. When force cured, allow the paint 5-minute ambient flash-off time with enough air movement before entering the component into the oven in order to obtain the best results.

In combination with Aerowave Series products, Aerowave 2001 is recoatable when surface dry with maximum recoat time of 168 hours. If a drying time of 168 hours is exceeded, recondition the surface with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad to a uniform matt surface.

In combination with solvent-based products, the minimum recoat time is 8 hours and the maximum recoat time is 48 hours without reconditioning.

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	Note	The curing of waterborne products depends on temperature, relative humidity and airflow. Increased temperatures, low RH and efficient airflow can decrease the drying times significantly.	
	Theoretical Coverage	22 m² per liter ready to apply at 15 µm dry film thickness 895 ft² per US gallon ready to apply at 0.6 mil dry film thickness	
	Dry Film Weight	1.6 g/m²/µm 0.0084 lbs/ft²/mil	
	Volatile Organic Compounds	< 120 g/L (1.0 lbs/gal) product ready to apply < 250 g/L (2.1 lbs/gal) exempt water according to ASTM D-3960	
	Gloss (60°)	Maximum 20 GU	
	Color	RAL 6021 Olive Green & BAC 452 Green	
	Flash Point	Aerowave 2001	>21°C / 70°F
		Hardener 6005	>21°C / 70°F
	Storage	Store the product dry and at a temperature between 5 and 35°C / 41 and 95°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 - 35°C (41 - 95°F)	Aerowave 2001	12 months
		Hardener 6005	12 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.
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Revision date: July 2026 (supersedes May 2026) - 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