Aerodur HS Primer 37092

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics

Product Information

Aerodur HS Primer 37092 is a 2 component amine cured epoxy primer with improved adhesion properties for interior and exterior use.
- Adheres sealed and non-sealed anodized and alodined substrates.
- Resistance to aircraft hydraulic fluids and chemicals.
- Compatible with polyurethane, epoxy and acrylic topcoats.
- Corrosion inhibiting.
- High solid product, max. VOC 350 g/L.

Components

Base	Aerodur HS Primer 37092
Curing Solution	Hardener 92217

Specifications

Qualified Product List

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 04-04-041
Airbus	AIMS 04-04-042
Bombardier Canadair	BAMS 565-001, GR B CT1 TY1
Hawker Beechcraft	BAEP 3527-4PSD5
UK Ministry of Defense	BS2X 33 Type A and B
deHavilland	DHMS C4.01

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

- Prime chemical conversion coatings and anodized parts in a fresh condition.
- When Aerodur HS Primer 37092 is applied on non-chemically pretreated aluminum, the substrate should be thoroughly cleaned and degreased with Solvent Cleaning C 28/15 (normal conditions) or Solvent Cleaning 98068 (warm conditions).
- Treat new aluminum with an aluminum oxide non-woven abrasive pad grade very fine to a uniform and matt surface.
- Clean aged primer or epoxy / polyurethane finishes and sand with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad grade very fine to a uniform and matt surface.
- Remove dust and debris with clean tack rags or equivalent.

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Instruction for Use

Spray Application (Mix Ratio)

	Volume
Aerodur HS Primer 37092	100 parts
Hardener 92217	40 parts

- Allow products to acclimate to room temperature before use.
- Stir or shake Aerodur HS Primer 37092 until all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92217 and stir the catalyzed mixture thoroughly.
- The Hardener 92217 color can vary from pale yellow to red.

Induction Time

Not applicable. Product can be used directly after mixing.

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

28 – 38 seconds ISO Cup #4
17 – 21 seconds Gardner Signature Zahn Cup #2

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 (23ºC/73ºF)

2 hours

Dry Film Thickness (DFT)

20 – 30 µm
0.8 – 1.2 mils

Note

The application and mixing characteristics of High Solid products differ from conventional products. Mix base and hardener for at least 2 minutes thoroughly. The high solid content causes a rapid film build-up.

Application Recommendations

Conditions

Temperature:	20 – 35 °C 68 – 95 °F
Relative Humidity:	35 – 75 %

Note

Aerodur HS Primer 37092 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	1.4 mm	N/A	3-5 bar / 43-73 psi
HVLP / Next Generation	N/A	N/A	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	55-75 bar / 0.8-1.0k psi	0.011-0.013 inch/60°	260-300 mL/min	4-5 bar / 58-73 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-apply a homogeneous, wet and closed coat in order to achieve a dry film thickness of 20 – 30 µm / 0.8 –1.2 mils.

Cleaning of Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068.

Note

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and airflow 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.

Physical Properties

Drying Times

	23°C/73°F, 55% RH
Dry to Touch	1 hr
Dry Hard	2½ hrs

Recoatable Minimum is 20 minutes if overcoated with the Airbus approved refresh primer, e.g. Aerodur HS 2121. Recoatable minimum is 2½ hrs for all other products.

Recoatable Maximum is 48 hours. If a drying time of 48 hours is exceeded, condition the surface with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad grade very fine to a uniform and matt surface.

Theoretical Coverage

40 m² per base material at 20 µm dry film thickness.
1600 ft² per US gallon base material at 0.8 mil dry film thickness.

Dry Film Weight

1.8 g/m²/µm

Gloss (60°)

Maximum 20 GU

Color

Green/Yellow
BAC 452

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	Flash Point	Aerodur HS Primer 37092	< 21ºC /70ºF
		Hardener 92217	< 21ºC /70ºF
	Shelf life 5 - 35°C (41 - 95°F)	Aerodur HS Primer 37092	24 months
		Hardener 92217	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.

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IMPORTANT NOTE

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