10P8-10NF

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 sub-assembly parts.

Components

Base	10P8-10NF
Curing Agent	Curing Solution EC-283

Specifications

Qualified Product List

Boeing	BMS 10-11, TY I CL A GR B
Embraer	MEP 10-059, TY II
Israel Aerospace Industries	MS100013E
Piper Aircraft Inc	PMS-F1003-8
Spirit Aerosystems	SMS-111202, TY 1 CL 1 GR B

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

Surface pretreatment is an essential part of the painting process. Follow the specification requirements for cleaning and pretreatment application.

Instruction for Use

Spray Application (Mix Ratio)

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

-Allow products to acclimatize to ambient conditions before use.
-Stir or shake the base component thoroughly to a homogeneous state prior to the addition of the curing solution.
-Add Curing Solution EC-283 and stir the catalyzed mixture thoroughly prior to application.

Induction Time

Not Applicable.

Initial Spraying Viscosity (25°C/77°F)

40 – 55 seconds ISO Cup #3
15 – 19 seconds EZ Zahn Cup #2
20 – 28 seconds Ford Cup #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

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Dry Film Thickness (DFT)

12.7 – 17.8 µm
0.5 – 0.7 mil

Application Recommendations

Conditions

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

Note

10P8-10NF may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.

Equipment Recommendation

Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *
Conventional	N/A	N/A	1.2-1.4 mm	N/A	3-5 bar / 43-73 psi
HVLP / Next Generation	N/A	N/A	1.2-1.4 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	75-90 bar / 1-1.3k psi, 25-35 bar / 0.4-0.5k psi	0.009 inch/60°, 0.013 inch/60°	260-300 ml/min	4-4.5 bar / 58-65 psi

*Measured with an open trigger.
**General advice to meet the HVLP / next-generation spray gun requirements. Please validate with your local authorities.

Note

For roll/brush application, a foam roller is recommended or a high-quality natural bristle brush. For woven fabric roller covers, remove loose nap with masking tape before using.

Number of Coats

Spray a single uniform wet coat to recommended dry film thickness.

Product can be rolled or brushed provided the 1:1 mix ratio is maintained and the primer meets the dry film requirements of BMS 10-11, Type I. Check the relevant specification document for application requirements.

Cleaning of Equipment

MEK

Physical Properties

Drying Times

	25°C/77°F, 55% RH
Dust Free	15 minutes
Tack Free	30 minutes
Dry to Topcoat	2 hours

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	25°C/77°F, 55% RH
Dry Through	4 hours
Recoatable Maximum	24 hours

If a drying time of 24 hours is exceeded, recondition the primer to a uniform matt surface with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad. Check the relevant specification to determine if reapplication of 10P8-10NF is necessary after reactivation.

Theoretical Coverage

8.6 m² per liter ready to apply at 25 µm dry film thickness.
350 ft² per US gallon ready to apply at 1 mil dry film thickness.

Dry Film Weight

47.8 g/m²/25 µm
0.01 lbs/ft²/1 mil

Volatile Organic Compounds

350 g/L / 2.9 lbs/gal – excluding exempt solvents according to US EPA
718 g/L / 6.0 lbs/gal

Gloss (60°)

Maximum 10 GU

Color

Green, BAC 452

Flash Point

10P8-10NF	-17°C / 1°F
Curing Solution EC-283	-17°C / 1°F

Shelf life 5 - 38°C (41 - 100°F)

10P8-10NF	24 months
Curing Solution EC-283	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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