

PRIMER P65-C2K

COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

AkzoNobel

Product information



Chromate-free water-based epoxy primer two component.
P65-C2K primer is used on composite structures to guarantee their protection.

Components



Base P65-C2K
Hardener / Catalyst H2K

Specifications



Qualified in accordance with:
EMBRAER : MEP 10-133, MEP 10-118

Product information mentioned in the technical datasheet is given for information purposes and can differ from requirements of specifications above. In that case, customer requirements are valid for your application.

Physical properties



THEORETICAL COVERAGE
20 m²/L (815 ft²/gal) for 20 µm (0.8 mils) dry

DRY FILM WEIGHT
1.5

VOC
130 g/L (ISO11890-1) or 250 g/L (ASTM D3960)

COLOR
Beige RAL1001

SHELF LIFE / STORAGE
12 months for the base and hardener, stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

GLOSS LEVEL
80 GU at 60°

NOTES
Gloss levels have been determined using glossmeter with an angle of incidence of 60°. The theoretical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation



P65-C2K primer can be applied directly on composite parts, suitably degreased and sanded.
All recommendations mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	4 V
Hardener / Catalyst	24	1 V

MIXING PROCEDURE

Ideally, the unmixed products should be stored between 18°C and 25°C (64°F and 77°F) for 24 hours before use.

The P65-C2K should be mixed for 5 to 10 minutes in a pneumatic or oscillating mixer before use.

Mix the base and the hardener until the mixture is homogeneous. The mixing must be made at a temperature between 15°C (59°F) and 35°C (95°F). Sieve the paint through a 120-150 µm (4.5-6.0 mils) filter.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

Zahn 2 Cup

18 to 25s

POT LIFE

4 hours

NOTE

The paint viscosity may vary depending on the temperature and increase over the pot life.

Viscosities mentioned above are corresponding to the recommended range of viscosity to ensure compliant application. The range of dilution must be used to adjust viscosity to reach the recommended one.

Instructions for use



BRUSH APPLICATION

	Mixing ratio by weight	Mixing ratio by volume
Base	100	4 V
Hardener / Catalyst	24	1 V

MIXING PROCEDURE

Mix the base and hardener in proportions indicated above until the mixture is completely homogeneous.

INDUCTION TIME

None

POT LIFE

4 hours

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Application recommendations



CONDITIONS

Temperature 15°C to 35°C (60°F to 95°F)
Relative humidity 20 % to 85 %

EQUIPMENT

Gravity compressed air gun Nozzle 1 mm to 1.8 mm

DRY / WET FILM THICKNESS

15 µm to 25 µm (0.6 to 1 mil) dry / 20 µm to 45 µm (0.8 to 1.8 mil) wet.

NUMBER OF COATS

Apply 1 crossed coat to achieve a 15 µm to 25 µm (0.6 to 1 mil) dry thickness. Each coat has to be wet and of the same thickness. The number of coats depends on the size and the shape of the part to be painted. The recommended dynamic air pressure is 2 bar to 4 bar (30 to 60 psi).

EQUIPMENT CLEANING

Clean the equipment with a suitable cleaning solvent such as Mapaero D760. Mapaero D770-B aqueous cleaning solvent can also be used.

NOTE

Spray with dry, oil-free air.

Drying times



Dry to handle

23°C (73°F)

5 hours

60 ° C (140°F)

45 minutes

80 ° C (176°F)

10 minutes

Dry to tape

6 hours

50 minutes

15 minutes

Recoatable

10 minutes to 3 days

10 minutes to 2 hours

5 minutes to 35 minutes

Fully Cured

3 days

2 hours 30

1 hour

NOTE

Drying times have been determined using test pieces of 1 mm thickness, with a 20 µm (0.8 mils) dry film.

Before accelerated drying 70°C (158°F), let it flash off for at least 15 minutes at room temperature.

Parts whose drying was forced must cool down to below 35 °C (95°F) before proceeding to the next step. To recoat P65-C2K primer with another product/primer, contact us.

For the P65-C2K primer infrared drying, contact us.

Drying time and temperature (evaporation and curing) are given for information only and may vary depending on humidity, the shape, the nature of the workpiece and the thickness of the paint.

*N.A. : Not applicable

Defects & corrections



In the event of a defect, contact your Quality Department

For a dry thickness < 15µm (0.6 mils):

Apply a thin layer to obtain the right thickness. If the recoating time is exceeded, reactivate with a Scotch-Brite type® A.

If there are micro-bubbles, running, rejects or numerous inclusions:

Reactivate slightly, using an abrasive paper grade P240 or P320.

Remove dust using a suitable cloth and apply a thin coat of primer, as described above.

Health & Safety



See the product Safety Data Sheets.

The MSDS are available through our website www.mapaero.com.

Packing



The P65-C2K is available in 5L (4L base and 1L hardener)

WARRANTY : We guarantee our products against hidden defaults over material and preparation. Our Responsibility is limited to the obligation of freely replacing the defective material without there being a claim for any compensation. The advice we give is based on our experience but it might not be absolutely right. Consequently this does not imply our responsibility in case of inefficiency. Furthermore our company cannot be responsible for any material or corporal damages caused due to a misuse or mishandling of our products. Any concession to these clauses, to be valid, must be an official document issued by our offices and signed by our direction.