

Epoxy Primer 37035A (3K Version)

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics



Product Information

Epoxy Primer 37035A is a corrosion-inhibiting, chromated 3-component amine-cured epoxy primer with improved adhesion properties for interior and exterior use.

- Adheres to degreased, sealed and non-sealed anodized and CCC (chemical conversion coating) treated substrates.
- Resistance to aircraft hydraulic fluids and chemicals.
- Corrosion inhibiting.
- Compatible with polyurethane, epoxy and acrylic topcoats.

Components



Base	Epoxy Primer 37035A
Curing Solution	Hardener 92140
Thinner	Thinner C 25/90 S
Thinner	Thinner 98064
Thinner	Thinner 96184

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
Dornier	DOL 255
Eurofighter	SP-J-513-A-0016 Type I Class A
Eurofighter	SP-J-513-M-0021 Type I Class C
UK Ministry of Defense	BS2X 33 Type A and B

Surface Conditions



Surface Preparation/
Cleaning

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

When Epoxy Primer 37035A is applied on non-chemically pretreated aluminum, the substrate should be thoroughly cleaned and degreased with Solvent Cleaning C28/15 (normal conditions) or Solvent Cleaning 98068 (warm conditions).

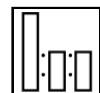
Treat new aluminum with grade P320 sandpaper or an aluminum oxide nonwoven abrasive pad to a uniform matt surface.

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

Remove dust with clean tack rags or equivalent prior to application of the primer.

Epoxy Primer 37035A (3K Version)

Instruction for Use



Spray Application (Mix Ratio)

	Volume	Weight
Epoxy Primer 37035A	2 parts	100 parts
Hardener 92140	1 part	33 parts
Thinner*	1-2 parts	33 parts

* Thinner options: Thinner C 25/90 S, Thinner 98064, Thinner 96184

Thinner Selection:

Thinner C 25/90 S (normal conditions, flashpoint <21°C)

Thinner 98064 (warm conditions, flashpoint >21°C)

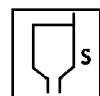
Thinner 96184 (warm conditions, flashpoint <21°C)

- Allow products to acclimatize to room temperature before use.
- Homogenize Epoxy Primer 37035A until all pigment is uniformly dispersed before adding the hardener.
- Add Hardener 92140 and stir the catalyzed mixture thoroughly.
- Add Thinner and stir the catalyzed mixture again thoroughly prior to application.



Induction Time

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



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

32 – 36 seconds ISO Cup #3
25 – 27 seconds Gardner Signature Zahn Cup #1



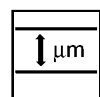
Note

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 (23°C/73°F)

8 hours



Dry Film Thickness (DFT)

15 – 20 μm
0.6 – 0.8 mil

Application Recommendations



Conditions

Temperature: 15 – 35 °C
59 – 95 °F

Relative Humidity: 35 – 75 %



Note

Epoxy Primer 37035A 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.

Epoxy Primer 37035A (3K Version)



Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *
Conventional	N/A	N/A	1.4 – 1.6 mm	400 mL/min ¹	4 – 4.5 bar / 58 – 65 psi ²
HVLP / Next Generation	N/A	N/A	1.4 – 1.6 mm	400 mL/min ¹	2 – 2.5 bar / 29 – 36 psi ³
Air Atomizing (electrostatic)	N/A	N/A	1.2 - 1.5 mm	400 mL/min	4 – 4.5 bar / 58 – 65 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

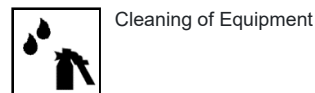
¹ Product Flow not applicable when using gravity/suction feed guns.

² Dynamic Air Pressure at gun-inlet measured with an open trigger.

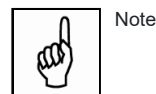
³ General advice to meet the HVLP / next generation spray gun requirements, please validate with your local authorities.



Spray-apply a homogeneous, wet and closed coat in order to achieve a dry film thickness of 15 – 20 µm / 0.6 – 0.8 mil.



Solvent Cleaning C 28/15 or Solvent Cleaning 98068 .



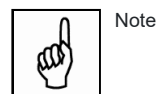
The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Physical Properties



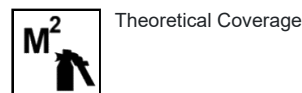
	23°C/73°F, 55% RH	60°C/140°F	80°C/176°F
Surface Dry	30 minutes	10 minutes*	10 minutes*
Dry to Handle	4 hours	N/A	N/A
Chemical Resistant	72 hours	45 minutes*	30 minutes*
Recoatable Minimum	30 minutes		
Recoatable Maximum	72 hours		

* Elevated temperature dry times refer to substrate surface temperature. The achieved surface temperature is independent on the curing method (convection oven, IR cure, etc.). When forced cured; allow the paint 5-minute ambient flash-off time with sufficient air movement before entering the component into the oven in order to obtain the best results.







If the maximum recoat time of 72 hours is exceeded, recondition the surface with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad to a uniform matt surface.

Dry times and recoat times will vary depending on combinations of temperature, humidity, and airflow.



16 m² per liter ready to apply at 15 µm dry film thickness
642 ft² per US gallon ready to apply at 0.6 mil dry film thickness

Epoxy Primer 37035A (3K Version)

	Dry Film Weight	1.8 g/m ² /μm 0.0094 lbs/ft ² /mil										
	Gloss (60°)	Maximum 20 GU										
	Color	Green Black										
	Flash Point	<table border="1"> <tbody> <tr> <td>Epoxy Primer 37035A</td> <td><21°C / 70°F</td> </tr> <tr> <td>Hardener 92140</td> <td><21°C / 70°F</td> </tr> <tr> <td>Thinner C 25/90 S</td> <td><21°C / 70°F</td> </tr> <tr> <td>Thinner 98064</td> <td>>21°C / 70°F</td> </tr> <tr> <td>Thinner 96184</td> <td><21°C / 70°F</td> </tr> </tbody> </table>	Epoxy Primer 37035A	<21°C / 70°F	Hardener 92140	<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
Epoxy Primer 37035A	<21°C / 70°F											
Hardener 92140	<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											
	Shelf life 5 - 35°C (41 - 95°F)	<table border="1"> <tbody> <tr> <td>Epoxy Primer 37035A</td> <td>24 months</td> </tr> <tr> <td>Hardener 92140</td> <td>24 months</td> </tr> <tr> <td>Thinner C 25/90 S</td> <td>36 months</td> </tr> <tr> <td>Thinner 98064</td> <td>36 months</td> </tr> <tr> <td>Thinner 96184</td> <td>36 months</td> </tr> </tbody> </table>	Epoxy Primer 37035A	24 months	Hardener 92140	24 months	Thinner C 25/90 S	36 months	Thinner 98064	36 months	Thinner 96184	36 months
Epoxy Primer 37035A	24 months											
Hardener 92140	24 months											
Thinner C 25/90 S	36 months											
Thinner 98064	36 months											
Thinner 96184	36 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.

Revision date: October 2023 (supersedes April 2023) - 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