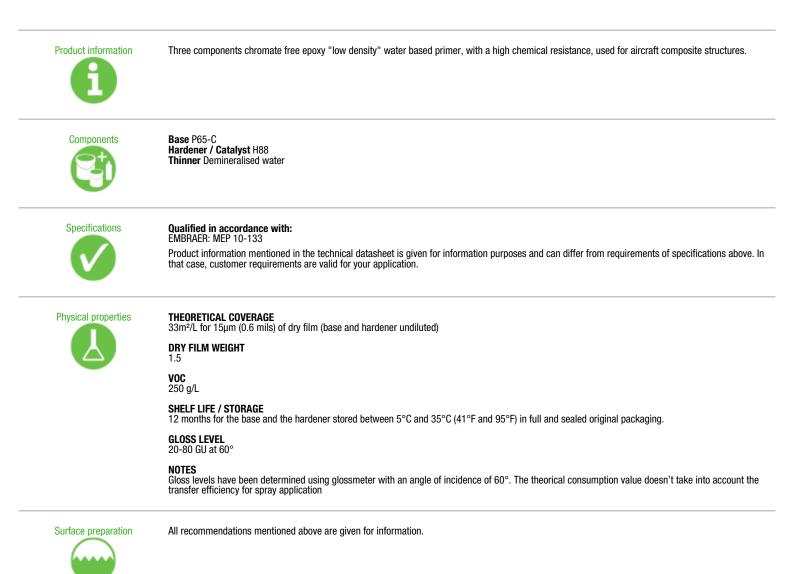
### PRIMER P65-C COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

## AkzoNobel



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#### Instructions for use

### SPRAY APPLICATION



#### MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	2V
Hardener / Catalyst	43	1V
Water	70 to 90	1.8V to 2.3V

**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. Mix the base and the hardener until the material is homogeneous. Then add the water and mix. The mixture must be made at a temperature between 15°C and 35°C. The water used to dilute the paint should be demineralised with a conductivity <  $25\mu$ S/cm.

INDUCTION TIME None

#### Spraying viscosity at 20°C / 68°F

Dilution rate in volume 2V	IS04	AFNOR4	Zahn2
	$39s \pm 6s$	19s ± 3s	$21 \pm 3s$

### POT LIFE

7 hours

#### NOTE

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.

Water based paints show a thixotropic behaviour. This implies that efflux time can vary according different parameters such as: type of mixing, mixing quantity, dilution, temperature, time between mixing and viscosity measurement

ISO 4 cup is the reference cup. The other are given for information purposes.

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CONDITIONS Temperature 15°C to 35°C (59-95°F) Relative humidity 30% to 70%

EQUIPMENT Gravity compressed air gun Nozzle 1.2mm to 1.5mm

DRY / WET FILM THICKNESS 15 to 25µm (0.6-1mils) dry / 45 to 75µm (1.8-3 mils) wet

NUMBER OF COATS Apply several coats to obtain 15 to 25µm of dry film EQUIPMENT CLEANING Clean the equipment with a suitable cleaning solvent such as D760 or D770-B from Mapaero. NOTE

Spray with dry and oil-free air.

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	Dry to touch Dry to handle Dry to tape Recoatable Total polymerization	23°C (73°F) 20 min 5 hours 6 hours 10 min to 3 days 3 days	<b>60°C (140°F)</b> N.A* 45 min 50 min 10 to 120 min 2h 30	<b>80°C (176°F)</b> N.A* 10 min 15 min 5 to 35 min 1 hour	<b>IR drying</b> N.A* 5 min 8 min 5 to 12 min 15 min		
	Total polymerization is performed in 2h30 at 60°C (140°F) for 50µm (2mils) of dry film. Drying times have been determined using tests pieces of a thickness < 2mm for 20µm (0.8mils) of dry film. Remark : Before accelerated drying up to 60°C (140°F), leave to flash off for at least 15 minutes at room temperature. *N.A. : Not applicable						
Defects & corrections	In the event of a defect, contact your Quality Department.						
Health & Safety	See the product Safety Data Sheet. The MSDS are available through our website www.mapaero.com						
Packing	The P65-C base is available in 4 The H88 hardener is available ir						

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.