

# PRIMER P65-C

## COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

**AkzoNobel**

### Product information



Three components chromate free epoxy "low density" water based primer, with a high chemical resistance, used for aircraft composite structures.

### Components



**Base** P65-C  
**Hardener / Catalyst** H88  
**Thinner** Demineralised water

### Specifications



**Qualified in accordance with:**  
EMBRAER: MEP 10-133

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**  
33m<sup>2</sup>/L for 15µm (0.6 mils) of dry film (base and hardener undiluted)

**DRY FILM WEIGHT**  
1.5

**VOC**  
250 g/L

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

**GLOSS LEVEL**  
20-80 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



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	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 < 25µS/cm.

### INDUCTION TIME

None

### Spraying viscosity at 20°C / 68°F

Dilution rate in volume	ISO4	AFNOR4	Zahn2
2V	39s ± 6s	19s ± 3s	21 ± 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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Application  
recommendations



## 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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### Drying times



#### NOTE

**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

**60°C (140°F)**

N.A\*

45 min

50 min

10 to 120 min

2h 30

**80°C (176°F)**

N.A\*

10 min

15 min

5 to 35 min

1 hour

**IR drying**

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](http://www.mapaero.com)

### Packing



The P65-C base is available in 4L.

The H88 hardener is available in 2L.

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.