

# PRIMER P60-LC

## COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

**AkzoNobel**

### Product information



Water-reducible epoxy primer three components containing low amount of Strontium chromate. This product is designed for the protection of metallic structures on Aircraft.

### Components



**Base** P 60-LC  
**Hardener / Catalyst** P 60-A  
**Thinner** Demineralised water

### Specifications



**Qualified in accordance with:**  
Airbus: A2MS 565-001 Gr B Cat 1&2, Ty I  
Bombardier:  
BAMS 565-001 Grade B Category 1, Type I & Category 2, Type I  
DHMS C 4.01 Type 2

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**  
37 m<sup>2</sup>/l (1500 ft<sup>2</sup>/gal) for 15 µm (0.6 mils) dry (base and not diluted hardener)

**DRY FILM WEIGHT**  
1.7

**VOC**  
160 g/l (ISO11890-1) and 340 g/l (ASTM D3960)

**COLOR**  
Green

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

**GLOSS LEVEL**  
20 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



P60-LC primer is used particularly on aluminium alloys that have had the following treatments:

**Alodine 1200:** Cr6 conversion  
**CAA:** Chromic Acid Anodising  
**SAA:** Sulphuric Acid Anodising  
**TSA:** Tartaric Sulphuric Anodising  
**BAA:** Boric Acid Anodising

Observe the recoating time between the surface treatment and painting. This may vary depending on the treatment and industrial instructions.

Contact us for information on uses on other metallic structures, surface treatments or paints.  
P60-LC primer can also be used on sealants.

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	2 V
Hardener / Catalyst	38	1 V
Water	65 to 130	2 V to 4V

#### 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 P60-LC base should be mixed for 10 minutes in a pneumatic or oscillating mixer before use.

When using 200L drums, we recommend tumbling the drums on a roller or tumbler for 2 to 4 hours prior to placing under the impeller system, then an initial stirring at about 200 RPM for 2 to 3 hours to eliminate sedimentation that may have occurred during drum storage.

During high-speed stirring, constantly monitor temperature to keep it under 30°C. Stop and restart mixing as necessary to keep the base material under 30°C. While drums are in service, keep P60-LC base stirred at 30 to 50 RPM at least 4h per day up to continuously. Ensure the base material temperature does not exceed 30°C. If necessary, reduce RPM or stirring time.

Mix the base and hardener until the mixture is homogenous before adding demineralised water in two stages.

The mixture must be made at a temperature between 15°C and 35°C (59°F and 95 °F).

Sieve the paint through a 120-150 µm (4.7-5.9 mils) filter.

Never add additional water once the paint mixture has been made.

#### INDUCTION TIME

None

#### INITIAL SPRAYING VISCOSITY

The equipment used for application can determine the desired dilution.

The list below is a guide to the optimum viscosity for various types of equipment.

Air gun	18+/-3 sCA4
Electrostatic spray gun	18+/-3 sCA4
Pressurised pot	21+/-3 sCA4
Automatic Pump	21+/-3 sCA4
Mixing machine	23+/-3 sCA4

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

Dilution rate in Volume	Cup CA4	ISO4	Zahn2
2 V	27	65	44
2.5 V	19	38	23
3 V	18	26	23
3.5 V	16	24	20
4 V	14	20	18

#### POT LIFE

8 hours for a 4 V dilution

#### NOTE

Pot life depends on the dilution ratio.

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

The water used to dilute the paint should be demineralised with a conductivity < 25 µSiemens.

Depending on the material used and the application temperature, the dilution may vary between 2 V and 4 V of demineralised water.

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 others are given for information purpose

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### BRUSH APPLICATION

	Mixing ratio by weight	Mixing ratio by volume
Base	100	2V
Hardener / Catalyst	38	1V
Water	0 or 35 to 50	0 V or 1 V to 1.5 V

### MIXING PROCEDURE

Remove the safety ring and press down on the cap to release the P60-A hardener. Shake the container for approximately 1 minute. Remove the cap to be able to apply the P60-LC primer with a suitable brush. If the material after shaking 1 min is not homogenous please use a stick for further mixing (around 1 min) until the material is homogen.

When diluting fill the hardener capsule in the cap with water then into the cup, close and shake again before use.



Do not hermetically close TUKs after mixing base and hardener.

### INDUCTION TIME

When diluting, wait 3 minutes before adding demineralised water.

### POT LIFE

2 hours not diluted

## Application recommendations



### CONDITIONS

**Temperature** 15°C to 35°C (59°F to 95°F)

**Relative humidity** 20% to 85%

### EQUIPMENT

**Gravity compressed air gun** Nozzle 0.8 to 1.8 mm

**Electrostatic spray gun** Nozzle 0.8 to 1.4 mm

### DRY / WET FILM THICKNESS

15 to 25 µm (0.6 to 1 mils) dry / 50 to 80 µm (2 to 3.1 mils) wet

### NUMBER OF COATS

Apply several coats to achieve 15 to 25 µm (0.6 to 1 mils) dry thickness.

The number of coats depends on the size and the shape of the part to which it is being applied.

The recommended dynamic air pressure is 1.5 bar to 4 bar (22 to 58 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 for cleaning the ready-to-use mixture.

### NOTE

Spray with dry, oil-free air.

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### Drying times



	23°C (73°F)	60°C (140°F)	65°C (150°F)	80°C (176°F)
<b>Dust free</b>	10 minutes	5 minutes	Not Applicable	Not Applicable
<b>Dry to handle</b>	35 minutes	15 minutes	10 minutes	5 minutes
<b>Dry to tape</b>	1 hour 45 minutes	30 minutes	25 minutes	15 minutes
<b>Dry to sand</b>	1 hour	30 minutes	25 minutes	15 minutes
<b>Recoatable</b>	8 hours to 48 hours	45 minutes to 1 hour 45 minutes	30 minutes to 1 hour 30 minutes	5 to 35 minutes
<b>Fully Cured</b>	3 days	2 hours	1 hour 45 minutes	35 minutes

#### NOTE

Drying times have been determined using test pieces of a thickness < 2 mm and for 15 µm (0.6 mils) of dry film. Before accelerated drying 70°C, leave to flash off for at least 15 minutes at room temperature. Recoatable times for P60-LC primer have been done using a high solid polyurethane topcoat.

Before recoating the P60-LC with a high solid polyurethane topcoat, drying is recommended at 60°C (140°F) or up to 80°C (176°F)

If P60-LC is recoated at room temperature by a high solid polyurethane topcoat, we do recommend to use one of the two processes mentioned below in order to ensure optimal adhesion of the system :

- Process N°1: Within 8 to 48 hours P60-LC drying, reactivate the surface with Scotch Brite Grade A then clean with IPA, MEK, Diestone DLS or Diestone HFP. Then Apply Topcoat immediately.
  - Process N°2 : Within 8 to 48 hours P60-LC drying, reactivate the surface with MAPAERO Surface Activator SA780 (See Technical and Safety Data Sheet). Then Apply Topcoat immediately
- \*N.A. : Non applicable

### Defects & corrections



In the event of a defect, contact your Quality Department. **In case of low thickness:**

Apply a thin coat of P60-LC to achieve the required thickness. If the above recommended recoating time is exceeded, reactivate with an abrasive pad.

#### For thick coats:

Contact your Quality Department.

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

Reactivate the surface using an abrasive paper (grade 220 to 320), remove the dust then clean the surface using an approved cleaning product. Apply a thin coat of P60-LC to achieve the required thickness **If there are significant defects:**

Remove the P60-LC primer with an approved chemical paint remover or remove using a plastic medium (in this case, the surface treatment has to be repeated).

### Health & Safety



See the product Safety Data Sheet.

The MSDS are available through our website [www.mapaero.com](http://www.mapaero.com)

### Packing



P60-LC base is available in 4 liters and 200 liters containers.

P60-A hardener is available in 2 liters and 200 liters containers.

P60-LC kits are also available:

- 45 ml Touch-Up Kits (TUK) (30 ml P60-LC Base + 15 ml P60-A Hardener);
- 12 ml Mini Touch-Up Kits (Mini TUK) (8 ml P60-LC Base + 4 ml P60-A 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.