

# 10P20-13

## Technical Data Sheet

### Product Group

### Epoxy Primer

### Characteristics

This low VOC two-component epoxy primer exhibits excellent corrosion resistance with good flexibility and chemical resistance.



Product Information

### Components



Base	10P20-13
Curing Solution	Curing Solution EC-213

### Specifications



Qualified Product List

US Military	MIL-PRF-23377, TYI CL C2
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### Surface Conditions



Surface Preparation/  
Cleaning

Surface pretreatment is an essential part of the painting process. Follow the specification requirements for cleaning and pretreatment application.

### Instruction for Use



Spray Application (Mix Ratio)

	Volume
10P20-13	3 parts
Curing Solution EC-213	1 part

Stir or Shake until all pigment is uniformly dispersed before adding curing solution.  
- Stir the catalyzed mixture thoroughly



Initial Spraying Viscosity  
(25°C/77°F)

21 – 30 seconds ISO Cup #4  
12 – 16 seconds Ford Cup #4



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

4



Dry Film Thickness (DFT)

15 – 23 µm  
0.6 – 0.9 mil

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## Application Recommendations



Conditions

Temperature: 15 – 35 °C  
59 – 95 °F

Relative Humidity: 35 – 75 %



Note

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.



Equipment Recommendation

Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *
Air (mm nozzle orifice)	1.4 mm (.055 inch)				
Air Electrostatic (mm nozzle orifice)	1.2 mm (.047 inch)				
Airless Electrostatic	.28 – .33 mm (.011 – .013 inch)				
Conventional / HVLP	1.4 mm (.055 inch)				

## Physical Properties



Drying Times



Theoretical Coverage

Unreduced:  
23.6 m<sup>2</sup>  
per liter ready to apply at 25 μm dry film thickness  
964 ft<sup>2</sup>  
per US gallon ready to apply at 1 mil dry film thickness

Reduced with either TR-114 or TR-49 thinner:  
18.9 m<sup>2</sup>  
per liter ready to apply at 25.4 μm dry film thickness  
771 ft<sup>2</sup>  
per US gallon ready to apply at 1 mil dry film thickness



Volatile Organic Compounds



Note

340 g/l, mix ratio 3:1 with EC-213  
340 g/l (per USA legislation), mix ratio 3:1:0.5-1 with EC-213/TR-114.

Where legislation permits > 340 g/l, mix ratio 3:1:0.5-1 with EC-213/TR49  
Maximum 438 g/l (3.66 lb/gal)



Gloss (60°)

60 – 95 GU

Flash Point

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15°C / 60°F

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	Curing Solution EC-213	7°C / 45°F
 Storage	TEST A	
Shelf life	10P20-13	Shelf life 5 - 38°C (40 - 100°F) 12 months per AkzoNobel Aerospace Coatings commercial specification for 10P20-13 and EC-213. 24 months for TR-49 and TR-114. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.
	Curing Solution EC-213	

## 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: - 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