

PRIMER P63

COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

AkzoNobel

Product information



Chromate free solvent based epoxy primer, semi gloss, with strong chemical resistance. This product offers anticorrosive protection on metallic parts and good adhesion on composite. Available in White.

Components



Base P63
Hardener / Catalyst P63
Thinner E

Specifications



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
29m²/L for 20µm dry (base and hardener not diluted)

DRY FILM WEIGHT
1.7 (approx)

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

GLOSS LEVEL
10-50 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

Base
Hardener / Catalyst
Thinner

Mixing ratio by weight

100
37
15 to 60

Mixing ratio by volume

2V
1V
0.5 to 2V

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 mixture is homogeneous. Then add the thinner and mix. The mixture must be made at a temperature between 15°C and 35°C (59-95°F)

INDUCTION TIME

none

Spraying viscosity at 20°C / 68°F

Dilution rate in volume
0.7V

AFNOR4
26s ± 4s

POT LIFE

6 hours at 20°C (68°F)

NOTE

The viscosity mentioned above is 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.

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Application
recommendations



CONDITIONS

Temperature 15 to 35°C

Relative humidity 30 to 75%

EQUIPMENT

Spray gun Nozzle 1.3 to 1.8 mm

DRY / WET FILM THICKNESS

15-100 µm/ 30-200 µm

NUMBER OF COATS

Application method:

Spray several coats to obtain a thickness between 15 and 100 µm dry, as required.

EQUIPMENT CLEANING

Clean the equipment with a suitable alcoholic thinner such as D760 or thinner E

NOTE

Spray with a dry and oil-free air

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Drying times



	23°C	60°C	IR
Dust free	20 minutes	N.A.	N.A
Dry to handle	40 minutes	20 minutes	N.A
Dry to sand	24 hours	1 hour @23°C + 1 hour @60°C**	N.A
Fully Cured	3 days	2 hours	15 minutes

NOTE

Drying times have been determined using tests pieces of a thickness < 2 mm for 60µm (2.4 mils) of dry film.

- **: Drying time for 100µm (4 mils)
- N.A : Not Applicable

Remark : Prior to operating accelerated drying superior to 60°C, allow to flash off minimum 15 minutes at room temperature.

Drying times have been determined using tests pieces of a thickness < 2 mm for 60µm (2.4 mils) of dry film.

** : Drying time for 100µm (4 mils)

*N.A. : Not applicable

Remark : Prior to operating accelerated drying superior to 60°C, allow to flash off minimum 15 minutes at room temperature.

Defects & corrections



In the event of a defect, contact your Quality Department.

Health & Safety



See the product Safety Data Sheets.

The MSDS are available through our website www.mapaero.com .

Packing



The P63 Kit is available in 6L.

The E thinner is available in 1L and 5L

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.