

10P4-2NF

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics

A chemically cured epoxy primer that provides excellent corrosion and chemical resistance for aircraft detail and subassembly parts. When used as the base primer for specification approved epoxy and polyurethane topcoats, the primer/topcoat system provides the optimum protection for interior structural components. This product has excellent adhesion to a variety of substrates.



Product Information

Components

Base	10P4-2NF
Curing Agent	Curing Solution EC-117S
Thinner	Thinner TR-19
Thinner	Thinner TR-20



Specifications

Allied Signal	51180208
Boeing	BMS 10-11, TYI CLA GRA
Bombardier Canadair	BAMS 565-001, GR A CT1 TY1
Embarer	MEP 10-059, TY I
Israel Aerospace Industries	MS100013E CL S
Rohr	RMS 118, TY I, CL G
Spirit Aerosystems	SMS-111202, TY 1 CL 1 GR B



Qualified Product List

Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products

Surface Conditions

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



Surface Preparation/
Cleaning

Instruction for Use

	Volume
10P4-2NF	1 part
Curing Solution EC-117S	1 part
Thinner*	0 - 0.5 part








Spray Application (Mix Ratio)



* Thinner options: Thinner TR-19, Thinner TR-20


- Allow products to acclimatize to room temperature before use.
- Stir or shake the 10P4-2NF base component thoroughly until all pigment is uniformly dispersed before adding the curing solution.
- Add the EC-117S curing solution and stir the catalyzed mixture thoroughly.
- Add the thinner, if required, and stir the catalyzed mixture again thoroughly.

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	Induction Time	30 minutes
	Initial Spraying Viscosity (25°C/77°F)	25 – 55 seconds ISO Cup #3 25 – 35 seconds Gardner Signature Zahn Cup #1 14 – 28 seconds EZ Zahn Cup #2
	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 (25°C/77°F)	16 hours.
	Dry Film Thickness (DFT)	13 – 18 µm 0.5 – 0.7 mil

Application Recommendations

	Conditions	Temperature: 15 – 35 °C 59 – 95 °F
		Relative Humidity: 35 – 75 %
	Note	10P4-2NF may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.

	Equipment Recommendation																															
		<table border="1"> <thead> <tr> <th>Spray gun type</th> <th>Product supply</th> <th>Fluid Pressure</th> <th>Nozzle orifice</th> <th>Product flow</th> <th>Dynamic air pressure at gun-inlet *</th> </tr> </thead> <tbody> <tr> <td>Conventional</td> <td>N/A</td> <td>N/A</td> <td>1.2-1.4 mm</td> <td>N/A</td> <td>3-5 bar / 43-73 psi</td> </tr> <tr> <td>HVLP / Next Generation</td> <td>N/A</td> <td>N/A</td> <td>1.2-1.4 mm</td> <td>N/A</td> <td>2-2.5 bar / 29-36 psi**</td> </tr> <tr> <td>Air Atomizing (electrostatic)</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> </tr> <tr> <td>Pressure Atomizing (electrostatic)</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> </tr> </tbody> </table>	Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *	Conventional	N/A	N/A	1.2-1.4 mm	N/A	3-5 bar / 43-73 psi	HVLP / Next Generation	N/A	N/A	1.2-1.4 mm	N/A	2-2.5 bar / 29-36 psi**	Air Atomizing (electrostatic)	N/A	N/A	N/A	N/A	N/A	Pressure Atomizing (electrostatic)	N/A	N/A	N/A	N/A	N/A
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	Note	*Measured with an open trigger. **General advice to meet the HVLP / next-generation spray gun requirements. Please validate with your local authorities.
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	Number of Coats	Spray a single uniform wet coat to achieve the recommended dry film thickness.
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	Cleaning of Equipment	MEK or C28/15.
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Physical Properties

10P4-2NF



Drying Times

25°C/77°F, 55% RH

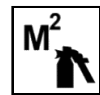
Dust Free	15 minutes
Tack Free	2 hours
Dry Through	4 hours
Dry to Tape	2 hours
Recoat Minimum	1 hour
Recoat Maximum	24 hours

If a drying time of 24 hours is exceeded, recondition the primer to a uniform matt surface with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad. Check the relevant specification to determine if reapplication of 10P4-2NF is necessary after reactivation.



Note

Dry times and recoat times will vary depending on combinations of temperature, humidity, and airflow.



Theoretical Coverage

8.6 m² per liter ready to apply at 25 µm dry film thickness.
350 ft² per US gallon ready to apply at 1 mil dry film thickness.



Dry Film Weight

46.91 g/m² at 25.4 µm
.0096 lbs/ft² at 1 mil



Volatile Organic Compounds

Max 650 g/l
Max 5.4 lbs/gal
Maximum (without thinner), per ASTM D3960



Gloss (60°)

Maximum 10 GU



Color

Green BAC 452



Flash Point

10P4-2NF	-5°C (23°F)
Curing Solution EC-117S	12°C (53°F)
Thinner TR-19	-4°C (25°F)
Thinner TR-20	4°C (40°F)

Shelf life 5 - 38°C (41 - 100°F)

10P4-2NF	24 months
Curing Solution EC-117S	24 months
Thinner TR-19	24 months
Thinner TR-20	24 months

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: August 2024 (supersedes April 2024) - FOR PROFESSIONAL USE ONLY

10P4-2NF

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