

Aerodur 2111

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics

A chrome free, corrosion inhibiting, urethane compatible, phosphate ester hydraulic fluids resistant primer for application to aircraft exterior surfaces. Aerodur 2111 provides excellent corrosion protection and optimizes the system adhesion of the exterior decoration finish.



Product Information

Components

Base	Aerodur 2111
Curing Solution	Curing Solution CS6018
Thinner	Thinner TR-114



Specifications

Boeing	BMS 10-72, TY X, NC2
Embarer	MEP 10-068, TY II, CL A&B
Pilatus	PMS0600-52-01



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

- Aerodur 2111 can be applied directly over reactivated aged primer when the layer thickness is >10 µm/0.4mils.
- Clean aged primer or epoxy/polyurethane finishes and sand/abrade to a uniform matt finish using grade P320 sandpaper or an aluminum oxide nonwoven abrasive pad.
- Clean and degrease the surface with an approved cleaning solvent prior to application of the pre-treatment or primer.
- Remove dust and debris with clean tack rags or equivalent.
- When applied over chemically stripped or uncoated metallic substrate, the substrate should be pretreated according to the relevant OEM specification (Boeing AMM/SRM per BAC 5075). Aerodur 2111 is compatible with BMS 10-128 pretreatments.



Surface Preparation/
Cleaning

Instruction for Use

	Volume	Weight
Aerodur 2111	2 parts	100 parts
Curing Solution CS6018	1 part	40.2 parts
Thinner*	1 part	41.5 parts



Spray Application (Mix Ratio)

* Thinner options: Thinner TR-114

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur 2111 base component until all pigment is uniformly dispersed before adding curing solution.
- Add the Curing Solution CS6018 and stir the catalyzed mixture thoroughly.
- Add the Thinner TR-114 and stir the catalyzed mixture again thoroughly.






If mixing is done for paint quantity less than 500 mL, it is always advised to refer to the standard weight calculation. It is recommended to continuously stir while using product system or mix again just prior to using.





Induction Time

15 minutes

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	Initial Spraying Viscosity (25°C/77°F)	13-17 seconds Zahn-Cup #2 25-33 seconds #2 Ford Cup 18-26 seconds ISO 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 (25°C/77°F)	4 hours
	Dry Film Thickness (DFT)	13 – 25 µm 0.5 – 1 mil
	Note	The application characteristics of VOC compliant products differ from conventional products in that the required film thickness will be achieved in fewer passes with the spray gun.

Application Recommendations


	Conditions	Temperature: 15 – 35 °C 59 – 95 °F
		Relative Humidity: 35 – 75 %
	Note	Aerodur 2111 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

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	1.2mm & 1.5mm	1.2mm tip: fluid flow 230-240 ml/min, 1.5mm tip: fluid flow up to 300-360 ml/min	58-65 psi / 4-4.5 bar
Pressure Atomizing (electrostatic)	N/A	55-70 bar / 0.8-1.0k psi	0.013 inch/60°	260-300 ml/min	4-5 bar / 60-75 psi

*Measured with an open trigger.

**General advice to meet the HVLP / next-generation spray gun requirements. Please validate with your local authorities.

	Number of Coats	Spray a single uniform wet coat to a dry film thickness of 13–25 µm (0.5–1.0 mil).
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	Cleaning of Equipment	Use TR - 36, Solvent Cleaning C28/15, Solvent Cleaning 98068 or MEK.
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Physical Properties



Drying Times

25°C/77°F

Dry to Topcoat	2.5 hours
Dry to Tape	3-4 hours
Recoatable Maximum	48 hours without reactivation.

If a drying time of 48 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 Aerodur 2111 is necessary after reactivation.



Theoretical Coverage

31.2 m² per liter ready to apply at 13 µm dry film thickness.
1272 ft² per US gallon ready to apply at 0.5 mil dry film thickness



Volatile Organic Compounds

624 g/L / 5.21 lbs/gal
350 g/L / 2.92 lbs/gal - excluding exempt solvents acc. to US EPA.



Gloss (60°)

Maximum 10 GU



Color

Tan



Flash Point

Aerodur 2111	16°C / 60°F
Curing Solution CS6018	4°C / 40°F
Thinner TR-114	-17°C / 1°F

Shelf life 5 - 38°C (41 - 100°F)

Aerodur 2111	24 months
Curing Solution CS6018	24 months
Thinner TR-114	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: November 2024 (supersedes June 2024) - 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

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