PRIMER P60-A

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics

Product Information

Strontium chromate-based, three-component water-reducible epoxy primer, with high chemical resistance. This product is designed for the protection of metallic structures on aircraft. P60-A primer is recommended for use in combination with Mapaero F70-A structural topcoat.

Components

Base	P60-A Base
Hardener	P60-A Hardener
Thinner	Demineralized Water

Specifications

Qualified Product List

Airbus Canada	A2MS 565-001 Grade B Category 1, Type I & Category 2, Type I
Airbus	04JMD9
Airbus	04QAB2
Airbus	04QAC2
Airbus	A2MS 565-007 Ty E Class 2 Semi-Gloss (White FS 27875 and Dark Grey FS 26473)
Airbus	ABP 4-1123
Airbus	AIMS 04-04-001
Airbus	AIMS 04-04-003
Airbus	AIMS 04-04-004
Airbus	AIMS 04-04-038
Airbus	AIMS 04-04-040
Airbus	AIMS 04-04-041
Airbus	AIMS 04-04-042
Airbus	AIMS 04-04-063
Airbus	ASNA 5147, PQ N° 10050-230-01
Airbus	CML 16-063, 04DEB2
Airbus	IPS 04-04-038-07
Bombardier	BAMS 565-001 Grade B Category 1, Type I & Category 2, Type I
Dassault	DGQT 1.7.0.0120
Embraer	MEP 10-59 type III
Viking	VAMS 565-001 Grade B Category 1, Type I & Category 2, Type I

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.

AkzoNobel Aerospace Coatings
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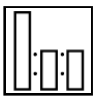
Surface Conditions

Surface Preparation/ Cleaning

P60-A 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-A primer can also be used on sealants. All recommendations mentioned above are given for information.

Instruction for Use



Spray Application (Mix Ratio)

	Volume	Weight
P60-A Base	2 parts	100 parts
P60-A Hardener	1 part	38 parts
Demineralized Water	2 - 4 parts	65 - 130 parts

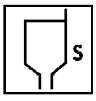
The water used to dilute the paint should be demineralized with a conductivity < 25 µSiemens.

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-A base should be stirred for 10 minutes in a pneumatic or oscillating mixer before use.
- Mix the base and hardener until the mixture is homogenous before adding demineralized 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

Not Applicable



Initial Spraying Viscosity (20°C/68°F)

The dilution is determined depending on the equipment that will be used for application
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
Pressurized pot	21+/-3 sCA4
Automatic Pump	21+/-3 sCA4
Mixing machine	23+/-3 sCA4

Viscosities mentioned above correspond 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.

Spraying viscosity at 20°C / 68°F

Dilution rate in Volume	Cup CA4	ISO4	Zahn2
2.0 V	27	65	44
2.5 V	19	38	23
3.0 V	18	26	23
3.5 V	16	24	20
4.0 V	14	20	18

Viscosity values are given ± 3sec for CA4 Cup and ± 4sec for the others.

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Water reducible paints show a thixotropic behaviour. This implies that efflux time can vary according to 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.

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 (20ºC/68ºF)

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.
Depending on the flow cup used and the application temperature, the dilution may vary between 2 V and 4 V of demineralized water.

Dry Film Thickness (DFT)

15 – 25 µm
0.6 – 1 mil

Wet Film Thickness (WFT)

50 – 80 µm
2 – 3.1 mils
Wet film thickness corresponds to 3V dilution.

Brush Application (Mix Ratio)

	Volume	Weight
P60-A Base	2 parts	100 parts
P60-A Hardener	1 part	38 parts
Demineralized Water	0 or 1 - 1.5 parts	0 or 35 - 50 parts

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-A primer with a suitable brush. If the material is not homogeneous after 1 min. shaking, please use a stick for further mixing (around 1 Min.) until the material is homogeneous.

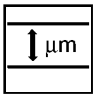
Do not hermetically close TUK after mixing base and hardener.

Note

When diluting, wait 3 minutes before adding demineralized water.

Pot life

2 hours not diluted



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Application Recommendations

Conditions

Temperature:	15 – 35 °C 59 – 95 °F
Relative Humidity:	20 – 85 %

Conditions

Primer P60-A may be applied in conditions outside the limits shown above. However, it is recommended to be careful to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions are outside of the recommended range.

Equipment Recommendation

Gravity compressed air gun - Nozzle 0.8 to 1.8 mm
Electrostatic spray gun - Nozzle 0.8 to 1.4 mm

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).

Note

DEFECTS & CORRECTIONS:
In the event of a defect, contact your Quality Department.
In case of too low thickness:
Apply a thin coat of P60-A to achieve the required thickness. If the above recommended recoating time is exceeded, reactivate with an abrasive pad.

For too thick coats:
Contact your Quality Department.

If there are micro-bubbles, runs, fish-eyes or numerous inclusions:
Reactivate the surface using a abrasive paper (grade 220 to 320), remove the dust then clean the surface using an approved cleaning product. Apply a thin coat of P60-A to achieve the required thickness.

If there are significant defects:
Remove the P60-A primer with an approved chemical paint stripper or remove using a plastic medium (in this case, the surface treatment has to be redone).

Cleaning of Equipment

Clean the equipment with a suitable cleaning solvent such as Mapaero D760.

Note

Spray with dry, oil-free air.

Physical Properties

Drying Times

	23°C/73°F	60°C/140°F	80°C/176°F
Dust Free	10 mins	5 mins	N.A
Dry to Handle	35 mins	15 mins	5 mins
Dry to Tape	1 hr 45 mins	30 mins	15 mins
Dry to Sand	1 hr	30 mins	15 mins
Recoatable	15 mins to 120 hrs	5 mins to 2 hrs	5 mins to 35 mins
Full Cure	3 days	2 hrs	35 mins

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Note	"Wet on Wet" application: P60-A / F70-A system can be used wet on wet. At room temperature, leave P60-A primer flash off for 15 minutes in the spray booth and then recover with F70-A topcoat. MEK resistance: After 23 hours at room temperature or 1 hour at 60°C, P60-A primer can be cleaned with MEK solvent. Before accelerated drying ≥ 70°C, leave to flash off for at least 15 minutes at room temperature. Recoating P60-A primer with another topcoat (Epoxy or Polyurethane) is possible. For process optimization, please contact us. Drying P60-A primer with Infra Red is possible. For process optimization, please contact us. Drying times have been determined using test pieces of a thickness < 2 mm and for 15 µm (0.6 mils) of dry film. *N.A. : Not applicable.
Theoretical Coverage	37 m²/l (1500 ft²/gal) for 15 µm (0.6 mils) dry (base and not diluted hardener).
Dry Film Weight	1.7
Volatile Organic Compounds	160 g/l (ISO11890-1) and 340 g/l (ASTM D3960).
Gloss (60°)	Minimum 20 GU
Note	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.
Color	RAL6021 Green
Flash Point	P60-A Base: N.A. P60-A Hardener: N.A. Demineralized Water: N.A.
Storage	Store the product dry and at a temperature between 5 and 35ºC / 41 and 95ºF per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature and shelf life may vary per OEM specification requirements. Refer to the container label for specific storage life information.
Shelf life	12 months in Touch-Up Kits, stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.
Shelf life 5 - 35°C (41 - 95°F)	P60-A Base: 18 months P60-A Hardener: 18 months Demineralized Water: N.A.

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.

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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

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