Aerodur LV 2114

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics

Product Information

Aerodur LV 2114 is a VOC-compliant (acc. to US legislation) corrosion-inhibiting 3-component amine-cured epoxy primer. It shows optimal chemical resistance and durability properties when applied in combination with specific exterior topcoat and basecoat / clearcoat systems.

Airbus OEM-approved MRO coating system (Airbus structural repair manual) when applied in combination with the Airbus-approved topcoats, basecoat / clearcoat, and wing coating.

Can be used with or without intermediate coating Aerodur Sealer 42240.

This single primer is the alternative to the traditional wash primer, PU primer refresh primer system.

AMS 3095 approved with many of AkzoNobel topcoats and basecoat / clearcoats for application over old paint layers.

Can be applied on a Boeing aircraft fuselage when used in combination with a BMS 10-128 approved sol-gel type of pre-treatment.

Components

Base	2114P001
Curing Solution	CS6022
Thinner	Thinner TR- 102
Thinner	Thinner TR-114

Specifications

Qualified Product List

Airbus	CML 477200
Airbus	SRM task 51-75-12-911-019 or 020
SAE International	AMS3095B

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 Preparation/ Cleaning

-Aerodur LV 2114 can be applied directly over a properly activated aged coating system when the layer thickness is >10 µm.

-When applied over chemically stripped or uncoated metallic substrate, the substrate needs to be pretreated according to the Airbus SRM (10PEG1, Socogel A0203) or Boeing AMM (BMS 10-128).

-Clean aged primer or epoxy/polyurethane finishes and sand with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad to a uniform and matt surface.

-Remove dust and debris with clean tack rags.

-Clean and degrease the surface with a sufficient and approved cleaning solvent prior to the application of the assigned pretreatment or primer.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200,
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71308 2905
Mail: aerospace@akzonobel.com / Online: aerospace.akzonobel.com

Aerodur LV 2114

Instruction for Use

Spray Application (Mix Ratio)

	Volume	Weight
2114P001	2 parts	100 parts
CS6022	1 part	34 parts
Thinner*	1 part	32 parts

* Thinner options: Thinner TR- 102, Thinner TR-114

-Allow products to acclimate to room temperature before use.
-Stir or shake the base until all pigment is uniformly dispersed before adding curing solution and thinner.
-Add CS6022 and manually stir the catalyzed mixture for 1 minute to a homogeneous mixture.
-Add Thinner TR-114 or TR-102 and stir manually for an additional minute.

TR-114 is a VOC-exempt solvent and HAPS-free thinner, per US guidelines.
TR-102 is a non-exempt thinner that raises total VOC.

Induction Time

15 minutes after mixing.

Initial Spraying Viscosity (23°C/73°F)

14 – 18 seconds Gardner Signature Zahn Cup #2
16 – 28 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 (23ºC/73ºF)

3 hours

Dry Film Thickness (DFT)

15 – 25 µm
0.6 – 1 mil

Application Recommendations

Conditions

Temperature:	15 – 35 °C 59 – 95 °F
Relative Humidity:	35 – 75 %

Note

Aerodur LV 2114 may be applied in conditions outside of the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200,
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71308 2905
Mail: aerospace@akzonobel.com / Online: aerospace.akzonobel.com

Aerodur LV 2114

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 – 1.5 mm	N/A	4 – 4.5 bar / 58 – 65 psi
HVLP / Next Generation	N/A	N/A	1.2 – 1.5 mm	N/A	2 – 2.5 bar / 29 – 36 psi**
Air Atomizing (electrostatic)	N/A	N/A	1.2 – 1.5 mm	260 – 300 mL/min	4 – 4.5 bar / 58 – 65 psi
Pressure Atomizing (electrostatic)	N/A	65 – 75 bar/1.02 kpsi, 25 – 35 bar/0.43 kpsi	0.009 inch/60°, 0.013 inch/60°	260 – 300 mL/min	4 – 4.5 bar / 58 – 65 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-apply a homogeneous, wet and closed coat in order to achieve a dry film thickness of 15 – 25 µm / 0.6 – 1.0 mil.

Cleaning of Equipment

Thinner TR-36, Solvent Cleaning C 28/15, Solvent Cleaning 98068 or MEK (Methyl Ethyl Ketone).

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 to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Physical Properties

Drying Times

	23°C/73°F, 55% RH
Dry to Topcoat	2 hours
Dry to Tape	3 – 4 hours
Dry to Sand	4 hours
Recoatable Maximum	48 hours

If the overcoating time of 48 hours is exceeded, recondition the aged primer with an aluminum oxide non-woven abrasive, type very fine, or P320 grade sandpaper before applying the subsequent coating.

Note

When using Aerodur Sealer 42240 on top of Aerodur LV 2114 the following overcoat times apply:

The recommended application window for best product performance is 20-25ºC (68-77ºF) and 20-60% RH.
The table below is provided as an indication for product applied at the recommended DFT and may vary upon the exact temperature and humidity combination. For sealer coat application, if the recommended overcoat time of Aerodur LV 2114 is exceeded, a fresh layer of primer must be applied according to the TDS to ensure optimal adhesion of the system.

Temperature \ RH	20-40%	41-60%	61-80%
20-25ºC / 68-77ºF	2:00-4:00 hrs	2:00-4:00 hrs	2:00-4:00 hrs
26-30ºC / 78-86ºF	2:00-4:00 hrs	2:00-4:00 hrs	2:00-3:00 hrs
31-35ºC / 87-95ºF	1:00-3:00 hrs	1:00-3:00 hrs	1:00-2:00 hrs

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200,
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71308 2905
Mail: aerospace@akzonobel.com / Online: aerospace.akzonobel.com

Aerodur LV 2114

Theoretical Coverage	21 m² per liter mixed Aerodur LV 2114 per 20 µm dry film thickness 857 ft² per US gallon mixed Aerodur LV 2114 at 0.8 mil dry film thickness		
Dry Film Weight	2.017 g/m²/µm 0.0090 lbs/ft²/mil		
Volatile Organic Compounds	European guidelines	Maximum 588 g/l, with exempt solvent. Maximum <4.9 lbs/gal, with exempt solvent.	
	US guidelines	Maximum 345 g/l. Maximum 2.9 lbs/gal.	
Gloss (60°)	Maximum 10 GU		
Color	Yellow		
Flash Point	2114P001	<21°C / 70°F	
	CS6022	<21°C / 70°F	
	Thinner TR- 102	<21°C / <70°F	
	Thinner TR-114	<21°C / 70°F	
Shelf life 5 - 35°C (41 - 95°F)	2114P001	24 months	
	CS6022	12 months	
	Thinner TR- 102	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: July 2024 (supersedes February 2024) - FOR PROFESSIONAL USE ONLY

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200,
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71308 2905
Mail: aerospace@akzonobel.com / Online: aerospace.akzonobel.com