

Aerodur 2100 MgRP

Technical Data Sheet

Product Group

Epoxy Primer

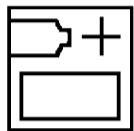
Characteristics



Product Information

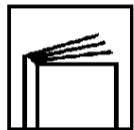
A corrosion inhibiting epoxy modified polyamide primer formulated using unique chrome free inhibitors.

Components



Base	2100P004
Curing Solution	Curing Solution CS6010
Thinner	Thinner TR-7005
Thinner	Thinner TR-114

Specifications



Qualified Product List

AkzoNobel	Certification
German Army WIWEB	TL 8010-0046
Gulfstream Aerospace	GMS 5008
Italian Air Force	AER(EP).M-P-001
US Military	MIL-PRF-32239, TY2, CL1, GR1

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

Surface Conditions

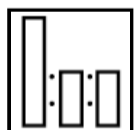


Surface Preparation/
Cleaning

Surface pretreatment is an essential part of the painting process. Clean and degrease the surface with an approved cleaning solvent then abrade the surface with P320 sandpaper or an aluminum oxide non-woven abrasive pad and rinse with DI water to a water-break free condition, or clean with a suitable alkaline based cleaner. Pretreat the surface using one of the following options:

1. Metaflex SP 1050 per instructions, or
2. PreKote per manufacturer's instructions, or
3. AC-131 (Boegel) per manufacturer's instructions, or
4. Direct to metal per TL8010-0046 specification.

Instruction for Use



Spray Application

	Volume	Weight
2100P004	4 parts	200 parts
Curing Solution CS6010	1 part	43.7 parts
Thinner*	1 part	TR-114: 43.4 & TR-7005: 43.75 parts

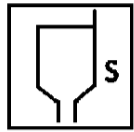
* Thinner options: Thinner TR-7005, Thinner TR-114

- Allow products to acclimatize to room temperature before use.
- Shake the 2100P004 base component thoroughly until all pigment is uniformly dispersed before adding the curing solution.
- Add the CS6010 curing solution and stir the catalyzed mixture thoroughly.
- Slowly add the TR-114 or TR-7005 thinner while stirring and stir the catalyzed mixture again thoroughly.

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Induction Time 30 minutes



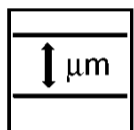
Initial Spraying Viscosity (25°C/77°F)
18 – 22 seconds Ford Cup #4
33 – 59 seconds ISO Cup #4



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)
25 – 35 µm
1 – 1.4 mils

Application Recommendations



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



Note Aerodur 2100 MgRP may be applied in conditions outside of the 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.



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	1.2-1.5 mm	230-350 ml/min	4-5 bar / 58-73 psi
Pressure Atomizing (electrostatic)	N/A	25-35 bar / 0.4-0.5k psi	0.011 inch/60°-0.013 inch/60°	260-300 ml/min	4-4.5 bar / 58-65 psi



Note Use of pot agitator is recommended. Removal of inline filters is also recommended.



Number of Coats Apply in one closed and wet coat to achieve the required film thickness of 25 – 35µm (1.0 – 1.4mils).

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Cleaning of Equipment

MEK or similar

Physical Properties



Drying Times

25°C/77°F, 55% RH

Tack Free	20 minutes
Recoat Minimum	3 hours
Recoat Maximum	48 hours

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 2100 MgRP is necessary after reactivation.



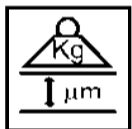
Note

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



Theoretical Coverage

15.8 m² per liter ready to apply at 25.4 µm dry film thickness
644 ft² per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

37.5 g/m²/25.4 µm
0.007677 lbs/ft²/mil



Volatile Organic Compounds

TR-114:
Max 340 g/l
Max. 2.82 lbs/gal

TR-7005:
Max 353 g/l
Max 2.95 lbs/gal



Note

The use of TR-7005 will affect reportable VOC.



Gloss (60°)

Maximum 10 GU



Color

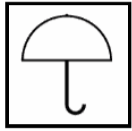
Red Tint



Flash Point

2100P004	35°C / 95°F
Curing Solution CS6010	12°C / 54°F
Thinner TR-7005	-17°C / 1°F
Thinner TR-114	-17°C / 1°F

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Storage

Store the product dry and at a temperature between 5 and 38°C / 41 and 100°F 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 5 - 38°C (41 - 100°F)

2100P004	24 months
Curing Solution CS6010	24 months
Thinner TR-7005	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: April 2024 (supersedes March 2023) - 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 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