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## Product Group

Corrosion Inhibiting Epoxy Primer using VOC exempt solvents

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## Characteristics



Product  
Information

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



Base,  
Curing Solution,  
Thinner/Reducer

Base: 2100P003  
Curing Solution: CS6010  
Reducer: TR-114

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## Specifications



Qualified Product  
List

AkzoNobel Aerospace Coatings	Certification
German Army (WIWEB)	TL8010-0046
Italian Air Force	AER(EP)_M_P_001
US Military	MIL-PRF-32239 Ty 1, Cl 1, Gr1 (performance)
SAE	AMS 3095* (*part of a system spec)

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The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: [www.akzonobel.com/aerospace](http://www.akzonobel.com/aerospace)

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## Surface Conditions



Cleaning

Surface pretreatment is a recommended part of the painting process.

### Substrate Cleaning Options:

1. Solvent clean, Scotch-Brite® abrade, DI rinse to water-break free condition, or
2. Scotch-Brite® abrade, alkaline clean with cleaner such as Turco 5948 or similar to manufacturer's instructions.

### Followed by 1 of 4 pretreatment options:

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



Mixing Ratio  
(volume)

Mix by volume:  
4 parts  
1 part  
1 part

(for large mixes)  
2100P003  
CS6010 Curing Solution  
TR-114 Reducer

**Instruction for Use**



Mixing Ratio  
(weight)

Mix by weight: (for smaller mixes)  
200.0 g 2100P003  
43.7 g CS6010 Curing Solution  
43.4 g TR-114 Reducer

- Shake 2100P003 Primer Base until all pigment is uniformly dispersed before adding Curing Solution.
- Add CS6010 Curing Solution to 2100P003 Base.
- Stir the catalyzed mixture thoroughly.
- Slowly add TR-114 Reducer while mixing or stirring.

**Note: Mix by weight for smaller mixes. For larger mixes, mix 4/1/1 by volume.**



Induction Time

15 minutes



Initial Spraying  
Viscosity  
(25°C/77°F)

18 – 22 seconds #4 Ford Cup  
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 micron (µm)  
1.0 – 1.4 mils.



**Application  
Recommendations**



Conditions

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



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



Equipment

**Air tip size:** 1.2 – 1.4 mm      **HVLP tip size:** 1.2 – 1.4 mm

**HP air assist airless electrostatic tip size:** .011 - .013 inch / 0.28 - .033 mm  
(Graco Pro 4500, or Graco XS-4 e.g.)

**Air spray electrostatic tip size:** 1.2 – 1.5 mm  
(Graco XS-3, Graco Pro 3500 e.g.)



Number of coats

Apply in one even coat to achieve the required film thickness of 25 – 35 micron (µm) 1.0 – 1.4 mils.



Cleaning of  
Equipment

MEK or similar

**Physical Properties**



Drying Times  
(25 +/- 2°C / 77  
+/- 2°F, 55 +/- 5%  
RH)

Tack free 20 minutes  
Recoat minimum 3 hours  
Recoat maximum 48 hours



Theoretical  
Coverage






15.8 m<sup>2</sup> per liter ready to apply at 25.4 µm dry film thickness  
644 ft<sup>2</sup> per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

37.5 g/m<sup>2</sup>/25.4 micron  
0.007677 lbs/ft<sup>2</sup>/mil



	Volatile Organic Compounds	Max 340 g/l Max. 2.82 lb/gal
	Gloss (60°)	10 maximum GU
	Color	Metallic Gray
	Flash-point	2100P003 35°C / 95°F CS6010 28°C / 82°F TR-114 -17°C / 1°F
	Storage	Store the product dry and at a temperature between 5 and 38°C / 40 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.
	Shelf life 5 - 38°C (40 - 100°F)	12 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

### 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 MSDSs are available on request.

### Issue date: May 2013 (supersedes January 2013) - 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.

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