



P-1000R - LEAD FREE EPOXY PRIMER



Item Class

Conventional Epoxy Primer

P-1000R is non chrome fast dry epoxy primer. It is a solvent, corrosion and chemical resistant primer for general use on high-tech applications. This coating is highly recommended for use on aluminum and all plated or un-plated metallic surfaces to insure maximum protection. When used as a base primer for specification approved systems, P-1000 insures maximum adhesion and corrosion resistance properties for TUF/FILM coatings, or any other paint or lacquer finish coatings.



Specifications

Product is manufactured to meet the performance requirements of the following specifications:

BAMS 565-001 Gr A
DEF-STAN-80-184
DHMS C4.01 Ty 2
MEP 10-059
MIL-P-23377
7/208



Catalysts & Additives

CATALYSTS
601



Surface Preparation

Proper surface preparation and cleaning is essential to insure adhesion of primer to substrate. Prepare substrate per OEM requirements. Contact your local 3Chem representative for detailed preparation process depending on application.



Mixing Instructions

BASE	CATALYST	MIX RATIO
P-1000R	601	1:1

*Shake Comp. "A" (Base) for 10-15 minutes. Mix comp. "A" (Base) and comp. "B" (Catalyst) 1:1 by volume. *Shake Comp. "A" (Base) for 10-15 minutes. Mix comp. "A" (Base) and comp. "B" (Catalyst) 1:1 by volume. Only mix enough material to be applied on initial coat. Always add component B catalyst to component A primer.



Induction Time

Although no induction time is needed. Once mixed together, insure that admixed material is continuously stirred for at least 5-10 minutes before proceeding.



Spraying Viscosity

18-24 SECONDS WITH #2 ZAHN CUP



Pot Life

16 HOURS (21 DEGREES C, 70 DEGREES F)



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Film Thickness

0.5 TO 0.8 MILS

Application Instructions

Temperature and Humidity

	MIN	MAX
TEMPERATURE C	14	36
TEMPERATURE F	55	96
HUMIDITY	34%	74%

Spray equipment

SPRAY GUN TYPE	TIP SIZE
CONVENTIONAL AIR GUN	1.2 - 1.4 mm
HVLP	1.2 to 1.4 mm
ELECTROSTATIC AIR GUN	1.2 or 1.5 mm

Number of Coats:

Apply a single even wet coat within film thickness recommendations.

Note: Maximum overcoat window without reactivation is 48 hours.

Dry Times:

DUST FREE	15 MINUTES
TACK FREE	2 HOURS
DRY HARD	3 HOURS
TO TOP COAT	1 HOUR

Theoretical Coverage

350 - 375 sq ft / gallon @ 1 mil

9 m² / liter @ 1 mil

*Coverage based on 100% transfer rate

Color

GREEN BAC 452

Gloss

10 MAXIMUM @ 60 DEGREE

Volatile Organic Compound

300 g/l maximum with no reducer added

Shelf Life

24 MONTHS (IF STORED IN CLIMATE CONTROLLED ENVIRONMENT BETWEEN 60-80 F) *Product may be re-certified upon inspection by 3Chem.

Safety Instructions

READ SAFETY DATA SHEET (S.D.S) AND PRODUCT LABEL BEFORE UTILIZING THIS PRODUCT. SDS IS AVAILABLE AT www.3chem.com.