

# P-1019 - HIGH SOLID EPOXY PRIMER

E Item Class	High Solid Epoxy Primer			
	P-1019 is a high solids low VOC urethane compatible two component epoxy polyamide primer. In addition to promoting adhesion, it offers an excellent barrier to corrosion. This primer has excellent chemical and solvent resistant properties. It is specially recommended to inhibit and protect against, corrosion of aluminum and other plated and un-plated metallic surfaces. It may also be utilized on composite surfaces.			
<b>Specifications</b>	Product is manufactured to meet the performance requirements of the following specifications: AMS 3095 MIL-PRF-23377K Ty I CI N MIL-PRF-23377K Ty I CI N BAMS 565-008, Ty I & II, CI A, Gr B DHMS C4.18 Z-12.138/BMS 10-79 Ty I & II MEP 10-068, Ty II, CI A & B MIL-PRF-23377K Ty I CI N			
Catalysts & Additives	CATALYSTS 613	]		
Surface Preperation	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-1019 613 1:1   *Shake component "A" (Base) for 10-15 minutes. Mix comp. "A" (Base) and component "B" (Catalyst) 1:1 by volume. Always add component B catalyst to component A primer. Thoroughly mix admixed material for at least 5 minutes. (DO NOT ADD THINNER TO THIS PRODUCT). Although viscosity may seem high, the product will spray smooth, wet and uniformly at recommended viscositv.			
Induction Time	Although no induction time is needed. Once mixed together, insure that admixed material is continuously stirred for at least 5 minutes before proceeding.			
Spraying Viscocity	19-24 SECONDS WITH #2 ZAHN CUP			
Pot Life	4 HOURS (21 DEGREES C, 70 DEGREES F)			

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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 1.4 mm

#### Number of Coats:

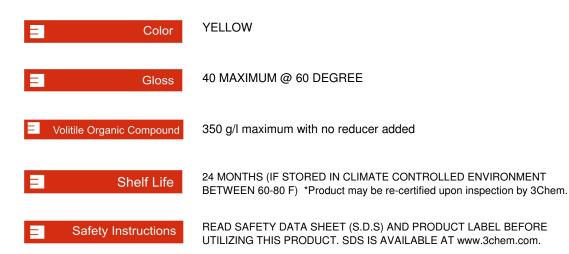
Apply a single even wet coat within film thickness recommendations. (Don not try to get hide from this product. Primer should be translucent in appearance once applied.

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#### Dry Times:

TACK FREE	2.5 HOURS	
DRY HARD	8-12 HOURS	
TO TOP COAT	3 HOUR	

850-900 sq. ft. / gallon @ 1 mil 22 m2 / liter @ 1 mil \*Coverage based on 100% transfer rate.



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Theoretical Coverage



3 Revised: 2017

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