



P-1025 - CHROME FREE - HIGH SOLID EPOXY PRIMER

Item Class Chromate Free - High Solid Epoxy Primer

P-1025 is a Non Chrome - High Solid epoxy primer. It is a solvent, corrosion and chemical resistant used for both commercial and military aerospace applications.. This coating is highly recommended for use on both aluminum and composite substrates. When used as a base primer for specification approved systems, P-1025 insures maximum adhesion and corrosion resistance properties for TUF/FILM coatings, or any other paint or lacquer finish coats.

Specifications Product is manufactured to meet the performance requirements of the following specifications:
DMS 1786, Comp A, Ty I
A50TF107-S5 Class A

Catalysts & Additives

CATALYSTS
615

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	Thinners (Optional)	MIX RATIO
P-1025	615	CM100	1:1

*Shake Comp. "A" (Base) for 10-15 minutes. Mix comp. "A" (Base) and comp. "B" (Catalyst) 1:1 by volume. No induction time is necessary. However, make sure to thoroughly mix admixed material for at least 5 minutes. If desired, reduce admixed product 10% maximum using caution as VOC will increase with solvent use. (Thinning is optional, not required.)

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)

Film Thickness

0.5 TO 0.8 MILS



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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

If force cure is necessary:

If deemed necessary oven curing is possible to reduce dry to tape and handle times. After application allow coating to air dry for 30 minutes at room temperature (75° F), then force cure for 1 hour at 120° F.

Theoretical Coverage

350 - 375 sq. ft. / gallon @ 1 mil

9 m² / liter @ 1 mil

*Coverage based on 100% transfer rate

Color

GREEN DN9295

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.