



## P-1096 - Two-Part Epoxy Coating

### Item Class

Epoxy Coating

P-1096 is a two-part epoxy coating formulated to protect fasteners used in aircraft assembly. This includes rivets, nuts, and other types of fasteners made of aluminum alloy. P-1096 has excellent adhesion properties and can be applied direct to substrate.

### Specifications

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

AIMS 04-04-009

AIMS 04-04-010

### Catalysts & Additives

Catalyst	Thinner (Optional)
725	CM100

### Surface Preparation

Prepare substrate per OEM requirements. Proper treatment and cleaning of surface is important to insure good adhesion.

### Mixing Instructions

BASE	CATALYST	SOLVENT	MIX RATIO
P-1096	725	CM100 (Optional)	1:1

\*Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B catalyst to component A paint first. Mix ratio for material is 1 part component A paint, 1 part component B catalyst. 3CHEM thinner CM100 may be used to achieve desired viscosity, using caution as use of solvents will increase V.O.C.

### 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

18-22 SECONDS WITH #2 ZAHN CUP

### Pot Life

6 HOURS (21 DEGREES C, 70 DEGREES F)

\*Pot life is reduced depending on amount of fast solvent and accelerator used.

### Film Thickness

2-3 MILS (1-1.5 MIL per coat)

### Application Instructions

#### Temperature and Humidity

	MIN	MAX
TEMPERATURE C	14	37
TEMPERATURE F	52	110
HUMIDITY	33%	74%



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### Application Instructions

#### Spray equipment

SPRAY GUN TYPE	TIP SIZE	CAP PRESSURE	POT PRESSURE
CONVENTIONAL AIR GUN	1.2 - 1.8 mm	45 – 60 psi	10 – 20 psi
HVLP	1.0 to 1.4 mm	10 – 12 psi	10 – 20 psi
ELECTROSTATIC AIR GUN	1.2 or 1.5 mm	45 – 60 psi	15 – 20 psi

#### Dry Times:

Dry to touch:	45 minutes
Dry to handle:	2-3 hours
Dry to tape:	6-8 hours
Full cure:	7 days

### Theoretical Coverage

325 - 575 sq. ft. / gallon @ 1 mil \*Coverage based on 100% transfer rate

### Color

Light Blue

### Gloss

90 MINIMUM @ 60 DEGREE FOR GLOSS COLORS

### Volitile Organic Compound

340 g/l max per U.S gallon

### 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](http://www.3chem.com).