



P-1008 - Waterborne Epoxy Primer

Item Class

Waterborne Epoxy Primer

P-1008 is a strontium chromate based water-borne epoxy primer. This primer is chemical resistant and possesses excellent corrosion inhibiting properties. It was specifically formulated to meet stringent environmental regulations.

Specifications

Product is manufactured to meet the performance requirements of the following specifications:
MIL-PRF-85582, Ty II, Cl C2
G37.5422
Z-12.141/MIL-PRF-85582

Catalysts & Additives

CATALYST
633X

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-1008	633X	Distilled Water	1:1

*Shake Comp. "A" (Base) for 10-15 minutes. Mix comp. "A" (Base) and comp. "B" (Catalyst) 1:1 by volume. Make sure to thoroughly mix admixed material for at least 5 minutes. If desired, reduce admixed product 10% maximum using distilled water. (Thinning is optional, not required,)

Induction Time

Induction time of 30 minutes is required. 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.

Dry Times:

DUST FREE	1 HOUR
TACK FREE	2 HOURS
DRY HARD	4 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

Dark Green

Gloss

10 MAXIMUM @ 60 DEGREE

Volatile Organic Compound

340 g/l maximum

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.