



## P-1015 - HIGH SOLID EPOXY PRIMER



### Item Class

High Solid Epoxy Primer

P-1015 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.



### Specifications

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

Z-12.140/MIL-P-23377 Ty I

G37.5472

MIL-PRF-23377 Ty I, Cl C2



### Catalysts & Additives

CATALYSTS
609



### 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	THINNER (Optional)	MIX RATIO
P-1015	609	cm100	1:1:10

\*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. Admixed material may be reduced to desired viscosity using 3CHEM thinner CM100, using caution as use of solvents will increase VOC.



### 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

17-20 SECONDS WITH #2 ZAHN CUP



### Pot Life

4 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 1.4 mm

#### Number of Coats:

Apply a single even wet coat within film thickness recommendations.

**Note:** Maximum overcoat window reactivation is 48 hours.

#### Dry Times:

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

### Theoretical Coverage

Unreduced  
850-900 sq ft / gallon @ 1 mil  
22 m<sup>2</sup> / liter @ 1 mil  
Reduced (Admixed material 10% with CM100)  
700-750 sq ft / gallon @ 1 mil  
16-18 m<sup>2</sup> / liter @ 1 mil  
\*Coverage based on 100% transfer rate.

### Color

YELLOW

### Gloss

10 MAXIMUM @ 60 DEGREE

### Volatile Organic Compound

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