



P-1019 - HIGH SOLID EPOXY PRIMER

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.

Specifications

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 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	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 viscosity.

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 Viscosity

19-24 SECONDS WITH #2 ZAHN CUP

Pot Life

4 HOURS (21 DEGREES C, 70 DEGREES F)



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Film Thickness

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.

Dry Times:

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

Theoretical Coverage

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

Color

YELLOW

Gloss

40 MAXIMUM @ 60 DEGREE

Volitile Organic Compound

350 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.

