



P-1054 - HIGH SOLID EPOXY PRIMER

Item Class

High Solid Epoxy Primer

P-1054 is high solid epoxy primer. It is a solvent, corrosion and chemical resistant primer used in 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-1054 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: MIL-PRF-23377, Ty II, Cl C

Catalysts & Additives

CATALYSTS
641

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-1054	641	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. 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

18-24 SECONDS WITH #2 ZAHN CUP

Pot Life

16 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 1.5 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

Theoretical Coverage

350 - 375 sq ft / gallon @ 1 mil

9 m² / liter @ 1 mil

*Coverage based on 100% transfer rate

Color

Green FS 34533

Gloss

5 MAXIMUM @ 60 DEGREE

Volitile 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.