



P-2029 - CHROME FREE - HIGH BUILD EPOXY PRIMER

Item Class Chromate Free - High Build Epoxy Primer

P-2029 is a Non Chrome - High build epoxy primer. It is solvent, corrosion and chemical resistant and used for both commercial and military aerospace applications.. This coating is highly recommended for use on both aluminum and composite substrates. P-2029 may be applied in multiple coats to achieve desired mil thickness. P-2029 is fully sandable and insures maximum adhesion and corrosion resistance properties. It may also be tinted into various colors.

Specifications Product is manufactured to meet the performance requirements of the following
AMS 3095A
MIL-PRF-23377 Ty1, CI N

Catalysts & Additives

CATALYSTS
780

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-2029	780	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 19-24 SECONDS WITH #2 ZAHN CUP

Pot Life 16 HOURS (21 DEGREES C, 70 DEGREES F)



P-2029 - CHROME FREE - HIGH BUILD EPOXY PRIMER

Film Thickness

0.8 TO 1.2 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 - 1.8 mm
HVLP	1.2 to 1.8 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

CREAM RAL 1014
*Tintable to various other colors

Gloss

10 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.