



P-2033 - Two-Part Epoxy Coating

Item Class

Epoxy Coating

P-2033 is a two-part epoxy coating formulated to protect fasteners used in aircraft assembly. This includes rivets, nuts, and other types of fasteners made of aluminum alloy. P-2033 has excellent adhesion properties and can be applied direct to substrate.

Specifications

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

AIMS 04-04-009
AIMS 04-04-010

Catalysts & Additives

Catalyst	Thinner (Optional)
783	CM100

Surface Preparation

Prepare substrate per OEM requirements. Proper treatment and cleaning of surface is important to insure good adhesion.

Mixing Instructions

BASE	CATALYST	SOLVENT	MIX RATIO
P-2033	783	CM100 (Optional)	1:1

*Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B catalyst to component A paint first. Mix ratio for material is 1 part component A paint, 1 part component B catalyst. 3CHEM thinner CM100 may be used to achieve desired viscosity, using caution as use of solvents will increase V.O.C.

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

18-22 SECONDS WITH #2 ZAHN CUP

Pot Life

6 HOURS (21 DEGREES C, 70 DEGREES F)
*Pot life is reduced depending on amount of fast solvent and accelerator used.

Film Thickness

2-3 MILS (1-1.5 MIL per coat)

Application Instructions

Temperature and Humidity

	MIN	MAX
TEMPERATURE C	14	37
TEMPERATURE F	52	110
HUMIDITY	33%	74%



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Application Instructions

Spray equipment

SPRAY GUN TYPE	TIP SIZE	CAP PRESSURE	POT PRESSURE
CONVENTIONAL AIR GUN	1.2 - 1.8 mm	45 – 60 psi	10 – 20 psi
HVLP	1.0 to 1.4 mm	10 – 12 psi	10 – 20 psi
ELECTROSTATIC AIR GUN	1.2 or 1.5 mm	45 – 60 psi	15 – 20 psi

Dry Times:

Dry to touch:	45 minutes
Dry to handle:	2-3 hours
Dry to tape:	6-8 hours
Full cure:	7 days

Theoretical Coverage

325 - 575 sq. ft. / gallon @ 1 mil *Coverage based on 100% transfer rate

Color

Gray M9001

Gloss

90 MINIMUM @ 60 DEGREE FOR GLOSS COLORS

Volitile Organic Compound

340 g/l max per U.S gallon

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.