P-1025

Chromate Free High Solid Epoxy Primer

Product **P-1025 Epoxy Primer**

Item Class Epoxy Primer

P-1025 is a Non-Chrome - High Solid epoxy primer. It is a solvent, corrosion and chemical resistant used for both commercial and 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-1025 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:

A50TF107-S5 Class A - MIL-P-23377 Ty I, Cl C, N - MS 37.14
(Please check 3chem.com for complete specification list.)

Catalyst & Additives

Catalyst/Activator	Thinner
619	CM100

Surface Preparation Prepare substrate per OEM requirements. Contact your local 3Chem representative or distributor for assistance.

Mixing Instructions

Base	Catalyst/Activator	Thinner (Optional)	Mix Ratio
P-1025	619	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. Use of thinner is optional and not required.

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 18-24 Seconds with #2 Zahn cup

Pot Life 16 Hours @ 21° Celsius, 70° Fahrenheit

Film Thickness .5 - .8 mils DFT. Wet film thickness should be .75 – 1.25 mils total

Application Instructions

Temperature and Humidity	Minimum	Maximum
Temperature Celsius	11°	35°
Temperature Fahrenheit	52°	95°
Humidity	33%	74%

Spray Equipment

Spray Gun Type	Tip/Nozzle Size	Cap Pressure	Pot Pressure
Conventional Air	1.3 - 1.6 mm	40 to 60 psi	10 to 20 psi
HVLP	1.4 - 1.6mm	10 psi Maximum	10 to 20 psi
Electrostatic	1.2 - 1.5mm	45 to 60 psi	10 to 40 psi

Number of Coats:
Apply one even wet coat within film thickness recommendations.
Note: Maximum overcoat window without mechanical reactivation is 48 hours.

Application Instructions

Dry times: @ 21° Celsius, 70° Fahrenheit

Dust Free	Tack Free	Dry to Tape	Dry to Top Coat	Dry Hard	Full Cure
15 Minutes	2 Hours	2-3 Hours	1 Hour	3 Hours	6 Days

Theoretical Coverage

350-375 sq. ft / gallon @ 1 mil 8-9-m2 / liter @1 mil
*Coverage based on 100% transfer efficiency rate

Color

Green DN9295

Gloss

10 maximum @ 60 degrees

Volatile Organic Compound

300 g/l

Shelf Life

24 Months (When stored in climate-controlled environment between 60-80° F)
*Product may be re-certified upon inspection by 3Chem.

Safety Instructions

Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.