

P-1035

Acid Etch - Wash Primer



Product P-1035 Acid Etch - Wash Primer

Item Class Specialty Coating

P-1035 is a three-component metal pretreatment wash primer. It is an excellent adhesion promoter for various substrates including aluminum, galvanized metal, lead, brass, magnesium and other ferrous metals.

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

DOD-P-15328

Catalyst & Additives Catalyst/Activator Thinner

628	CM160
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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-1035	628	CM160	4:1:2

Shake Comp A P-1035 for 10-15 minutes. Add 2 parts CM160 thinner to 1 part of Comp B 628 catalyst/activator. Add this mixture to 4 parts of Comp A P-1035 by volume. No induction time is necessary. However, make sure to thoroughly mix admixed material for at least 5 minutes. Up to 5% addition CM160 thinner may be added to mixture if lower viscosity is desired.

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 14-18 Seconds with #2 Zahn cup

Pot Life Hours @ 21° Celsius, 70° Fahrenheit

Film Thickness .2 - .4 mils DFT. Wet film thickness should be .5 – .75 mils total

Application Instructions

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

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Application Instructions

Spray Equipment

Spray Gun Type	Tip/Nozzle Size	Cap Pressure	Pot Pressure
Conventional Air	1.2 - 1.4mm	40 to 60 psi	10 to 20 psi
HVLP	1.2 - 1.4mm	10 psi Maximum	10 to 20 psi
Electrostatic	1.2 - 1.4mm	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 4 hours.

Color Translucent Green

Gloss 10 maximum @ 60 degrees

Volatile Organic Compound 350 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.

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