P-1067
Epoxy Primer

Product

P-1067 Epoxy Primer

Item Class

Epoxy Primer

P-1067 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-1067 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-23377K Ty I Cl N

Catalyst & Additives

Catalyst/Activator

652

Surface Preparation

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

Mixing Instructions

<table>
<thead>
<tr>
<th>Base</th>
<th>Catalyst/Activator</th>
<th>Thinner (Optional)</th>
<th>Mix Ratio</th>
</tr>
</thead>
<tbody>
<tr>
<td>P-1067</td>
<td>652</td>
<td>CM100</td>
<td>1:1</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Temperature and Humidity</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Temperature Celsius</td>
<td>11°</td>
<td>35°</td>
</tr>
<tr>
<td>Temperature Fahrenheit</td>
<td>52°</td>
<td>95°</td>
</tr>
<tr>
<td>Humidity</td>
<td>33%</td>
<td>74%</td>
</tr>
</tbody>
</table>

Spray Equipment

<table>
<thead>
<tr>
<th>Spray Gun Type</th>
<th>Tip/Nozzle Size</th>
<th>Cap Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>Conventional Air</td>
<td>1.3 - 1.6 mm</td>
<td>40 to 60 psi</td>
<td>10 to 20 psi</td>
</tr>
<tr>
<td>HVLP</td>
<td>1.4 - 1.6 mm</td>
<td>10 psi Maximum</td>
<td>10 to 20 psi</td>
</tr>
<tr>
<td>Electrostatic</td>
<td>1.2 - 1.5 mm</td>
<td>45 to 60 psi</td>
<td>10 to 40 psi</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Dust Free</th>
<th>Tack Free</th>
<th>Dry to Tape</th>
<th>Dry to Top Coat</th>
<th>Dry Hard</th>
<th>Full Cure</th>
</tr>
</thead>
<tbody>
<tr>
<td>15 Minutes</td>
<td>2 Hours</td>
<td>2-3 Hours</td>
<td>1 Hour</td>
<td>3 Hours</td>
<td>6 Days</td>
</tr>
</tbody>
</table>

Theoretical Coverage

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

Color
Green BAC 452

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.

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