

# P-1024

## Acid Etch - Wash Primer



**Product** P-1024 Acid Etch - Wash Primer

**Item Class** Specialty Coating

P-1024 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 - HMS 15-1098 Ty II - MIL-C-8514C

**Catalyst & Additives** Catalyst/Activator Thinner

665	CM160
-----	-------

**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-1024	665	CM160	4:1:2

Shake Comp A P-1024 for 10-15 minutes. Add 2 parts CM160 thinner to 1 part of Comp B 618 catalyst/activator. Add this mixture to 4 parts of Comp A P-1024 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%

# P-1024

## Acid Etch - Wash Primer



### **Application Instructions**

#### **Spray Equipment**

<b>Spray Gun Type</b>	<b>Tip/Nozzle Size</b>	<b>Cap Pressure</b>	<b>Pot Pressure</b>
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 Yellow

**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.

#### 3Chem Corporation Disclaimer

All information, recommendations, statements, and technical data contained herein are not intended to be comprehensive or exhaustive, but instead are based on tests utilizing present knowledge and current laws. The accuracy and completeness of said tests are in no way guaranteed, nor should they be construed as an express or implied warranty. We believe such information, recommendations, statements, and technical data to be reliable and accurate, but we have no control over the quality or the condition of the many factors affecting the use and application of the product. The user shall depend upon its/his/her own information, data and testing to determine whether the product is suitable for the user's intended use and the user assumes all risks and liability resulting from its/his/her use of the product. Seller's and manufacturer's sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller. All products supplied, and technical advice given is subject to our standard terms and conditions of sale. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

\*Brand names mentioned above are either trademarks of or licensed to 3Chem Corporation.