

P-1029

Chromate Free High Build Epoxy Primer



Product P-1029 Epoxy Primer

Item Class Epoxy Primer

P-1029 is a Non Chrome - High build epoxy primer. It is solvent, corrosion and chemical resistant and used for both commercial and military aerospace applications. This coating is highly recommended for use on both aluminum and composite substrates. P-1029 may be applied in multiple coats to achieve desired mil thickness. P-1029 is fully sandable and insures maximum adhesion and corrosion resistance properties.

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

AIMS 04-04-031 - AIMS 04-04-032 - Z-12.145/AIMS 04-04-031

Catalyst & Additives Catalyst/Activator Thinner

| | |
|-----|-------|
| 623 | 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-1029 | 623 | 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

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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 |

Force Cure: If deemed necessary oven curing is possible to reduce dry to tape and handle times. After application, allow coating to air dry for 30 minutes at room temperature (75° F), then force cure for 1 hour at 120° F.

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

Color Cream RAL 1014

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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