

P-1040

Chrome Free Epoxy Primer



Product P-1040 Chrome Free Epoxy Primer

Item Class Epoxy Primer

P-1040 is a non-chrome, fluid resistant 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-1040 may be applied in multiple coats to achieve desired mil thickness. P-1040 is fully sandable and insures maximum adhesion and corrosion resistance properties. It may also be tinted into various colors.

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

AER-M-P.023 - AMS 3095 – Def Stan 00-80 - DHMS C4.01 Ty 3 Gr A - MIL-PRF-23377 Ty I, CI N

Catalyst & Additives Catalyst/Activator

631

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-1040	631	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 Induction time of 10 minutes is required for this product.

Spraying Viscosity 19-24 Seconds with #2 Zahn cup

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

Film Thickness .8 – 1.2 mils DFT. Wet film thickness should be 1.5 – 1.8 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	1.6 - 1.8 mm	40 to 60 psi	10 to 20 psi
HVLP	1.4 - 1.8 mm	10 psi Maximum	10 to 20 psi
Electrostatic	1.4 - 1.8 mm	45 to 60 psi	10 to 40 psi

Number of Coats:

Apply one even wet coat within film thickness recommendations. Additional coats may be applied to build product to greater mil thickness.

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
30 Minutes	2.5 Hours	3-4 Hours	1 Hour	4 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 White (Tintable to various other colors)

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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