

# P-1071

## Chrome-Free Epoxy Primer



**Product** P-1071 Chrome-Free Epoxy Primer

**Item Class** Epoxy Primer

P-1071 is a non-chrome beige epoxy primer developed for aircraft wheel, brake, and landing gear applications. It is solvent, corrosion and chemical resistant. This coating is highly recommended for use on both aluminum and steel substrates. When used as a base primer for specification approved systems, P-1071 insures maximum adhesion and corrosion resistance properties for polyurethane and epoxy coating systems.

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

LEH640

**Catalyst & Additives** Catalyst/Activator Thinner

655	CM100
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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-1071	655	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-m<sup>2</sup> / liter @1 mil  
\*Coverage based on 100% transfer efficiency rate

**Color** Beige

**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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