

# P-1025

## Chromate Free High Solid Epoxy Primer



**Product** P-1025 Epoxy Primer

**Item Class** Epoxy Primer

P-1025 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-1025 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:

A50TF107-S5 Class A - MIL-P-23377 Ty I, Cl C, N - MS 37.14 - PCS-2500, 32-09-01  
Section 36B  
(Please check 3chem.com for complete specification list.)

**Catalyst & Additives** Catalyst/Activator Thinner

619	CF3
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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-1025	619	CF3	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 CF3, 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 15 minutes at room temperature (75° F), then force cure for 45 minutes 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** Green DN9295

**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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