

P-2013

High Heat Epoxy Primer



Product P-2013 High Heat Epoxy Primer

Item Class Epoxy Primer

P-2013 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 aluminum and steel substrates. P-2013 can withstand intermittent temperatures of up to 450° F.

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

AIMS 04-04-019

Catalyst & Additives Catalyst/Activator

763

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-2013	763	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

Application Instructions

Temperature and Humidity	Minimum	Maximum
Temperature Celsius	11°	35°
Temperature Fahrenheit	52°	95°
Humidity	33%	74%

P-2013

High Heat Epoxy Primer



Application Instructions

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

Theoretical Coverage 350-375 sq. ft / gallon @ 1 mil 8-9-m² / liter @1 mil

*Coverage based on 100% transfer efficiency rate

Color Yellow

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.

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.