

# P-2018

## High Build Epoxy Primer



**Product** P-2018 High Build Epoxy Primer

**Item Class** Epoxy Primer

P-2018 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-2018 may be applied in multiple coats to achieve desired mil thickness. P-2018 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:

299-947-127B - STMB-M513 Type 2

**Catalyst & Additives** Catalyst/Activator

797

**Surface Preparation** Prepare substrate per OEM requirements. Contact your local 3Chem representative or distributor for assistance.

**Mixing Instructions**

Base	Catalyst/Activator	Mix Ratio
P-2018	797	1:1

Shake Comp. "A" (Base) for 10-15 minutes. Mix comp. "A" (Base) and comp. "B" (Catalyst) 1:1 by volume. Make sure to thoroughly mix admixed material for at least 5 minutes.

**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

**Application Instructions**

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

### 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. 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-m<sup>2</sup> / 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.

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