

P-2024

High Build Epoxy Primer



Product P-2024 High Build Epoxy Primer

Item Class Epoxy Primer

P-2024 is a chrome free, high build/sandable epoxy primer intended for use on both aluminum and composite substrates. It is a solvent, corrosion and chemical resistant primer used for both commercial and military aerospace applications. When used as a base primer for specification approved systems, P-2024 ensures maximum adhesion properties for polyurethane based topcoat systems.

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

PCE 111

Catalyst & Additives Catalyst/Activator

775

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

Mixing Instructions

Base	Catalyst/Activator	Mix Ratio
P-2024	775	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 19-25 Seconds with #2 Zahn cup

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

Film Thickness .5 – 1.0 mils DFT. Wet film thickness should be .75 – 1.5 mils total

Application Instructions

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

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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-m² / liter @1 mil

*Coverage based on 100% transfer efficiency rate

Color

 White

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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