

P-2050

High Build Epoxy Primer



Product P-2050 High Build Epoxy Primer

Item Class Epoxy Primer

P-2050 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-2050 ensures maximum adhesion properties for polyurethane based topcoat systems.

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

PCE 211

Catalyst & Additives Catalyst/Activator

794

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

Mixing Instructions

Base	Catalyst/Activator	Mix Ratio
P-2050	794	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%

P-2050

High Build 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. 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

 Gray RAL 7001

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.