

# P-2058

## High Build Epoxy Primer



**Product** P-2058 High Build Epoxy Primer

**Item Class** Epoxy Primer

P-2058 is a non-chrome - high build 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-2058 may be applied in multiple coats to achieve desired mil thickness. P-2058 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:

AIMS 04.04.002/035/045 - AMS 3095A - MIL-PRF-23377K Ty I, CI N

**Catalyst & Additives** Catalyst/Activator Thinner

845	CM100
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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-2058	845	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

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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

**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** Beige

**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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