

P-2060

Epoxy Primer



Product P-2060 Epoxy Primer

Item Class Epoxy Primer

P-2060 is a chrome free 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-2060 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

624

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

Mixing Instructions

| Base | Catalyst/Activator | Mix Ratio |
|--------|--------------------|-----------|
| P-2060 | 624 | 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

 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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