

# 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:

Contact 3Chem for specification and product equivalency.

**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%

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

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