

P-1001

High Impact Epoxy Primer



Product P-1001 Epoxy Primer

Item Class Epoxy Primer

P-1001 is a high impact resistant epoxy primer. It is a solvent, corrosion and chemical resistant primer that also offers improved Skydrol® resistance for general use or high-tech applications. This coating is highly recommended for use on aluminum and all plated or un-plated metallic surfaces to insure maximum protection. Also available in low V.O.C formulation.

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

BAMS 565-018 - DHMS C4.18 Ty III, Cl A, Gr A

Catalyst & Additives Catalyst/Activator Thinner

602 / 602LV	CF3
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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-1001	602/602LV	CF3	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 CF3, using caution as use of solvents will increase VOC. Use of thinner is optional and not required. 602LV Catalyst available for low V.O.C requirements.

Induction Time Although no induction time is needed. Once mixed together, ensure 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

Force Cure: If deemed necessary oven curing is possible to reduce dry to tape and handle times. After application, allow coating to air dry for 15 minutes at room temperature (75° F), then force cure for 45 minutes at 120° F.

Theoretical Coverage 350-375 sq. ft / gallon @ 1 mil 8-9-22m2 / liter @1 mil
*Coverage based on 100% transfer efficiency rate

Color Green BAC 452

Gloss 10 maximum @ 60 degrees

Volatile Organic Compound 376 g/l when using 602 Catalyst
329 g/l when using 602LV Catalyst

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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