



## Product Group

Epoxy primers

## Characteristics



Product  
Information

Aerodur<sup>®</sup> HS Primer 37092 is a 2 component amine cured epoxy primer with improved adhesion properties for interior and exterior use.

- Adheres sealed and non-sealed anodized and alodined substrates.
- Resistance to aircraft hydraulic fluids and chemicals.
- Compatible with polyurethane, epoxy and acrylic topcoats.
- Corrosion inhibiting.
- High solid product, max. VOC 350 g/L

## Components



Hardener Thinner  
or  
Activator

Hardener 92179 (Bombardier / Canadair, Bae Systems)  
Hardener 92217 (Airbus, Embraer, Bombardier / Canadair)

Do not add any thinner.

## Specifications



Qualified Product  
List

### Hardener 92179

Bombardier / Canadair	BAMS 565-001 Grade B and D
Bae Systems	AVN 7-003
Shorts	SMS 89

### Hardener 92217

Airbus	AIMS 04-04-001/004
Embraer	MEP 10-059
Bombardier / Canadair	BAMS 565-001 Grade B and D
MOD	BSX 33

For most recent up-date or missing specifications please check the qualified product list (QPL) on [www.akzonobel.com/aerospace](http://www.akzonobel.com/aerospace)

## Surface Conditions



Cleaning

- Prime chemical conversion coatings and anodized parts in a fresh condition.
- When Aerodur<sup>®</sup> HS Primer 37092 is applied on non chemically pretreated aluminum, the substrate should be thoroughly cleaned and degreased with Solvent Cleaning C 28/15 (normal conditions) or Solvent Cleaning 98068 (warm conditions)
- Treat new aluminum with Scotch-Brite<sup>®</sup> type A very fine to a uniform matt surface.
- Clean aged primer or epoxy / polyurethane finishes and sand with Scotch-Brite<sup>®</sup> type A very fine to a uniform and matt surface.
- Remove dust with e.g. tack rags.



### Instruction for Use



Mixing Ratio  
(volume)

#### Hardener 92179

100 parts  
50 parts

Aerodur<sup>®</sup> HS Primer 37092  
Hardener 92179

#### Hardener 92217

100 parts  
40 parts

Aerodur<sup>®</sup> HS Primer 37092  
Hardener 92217

- Allow products to acclimatize to room temperature before use
- Stir or shake Aerodur<sup>®</sup> HS Primer 37092 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92179 or 92217, and stir the catalyzed mixture thoroughly.



Induction Time

Induction time not applicable. Product can be used directly after mixing.



Initial Spraying  
Viscosity  
(21°C/70°F)

28 – 38 seconds ISO-Cup 4.  
14 – 19 seconds Gardner Signature Zahn-Cup #2.



Note

Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.



Pot Life  
(21°C/70°F)

2 hours



Dry Film  
Thickness  
(DFT)

20 – 30 μm  
0.8 – 1.2 mil



Note

The application and mixing characteristics of High Solid products differ from conventional products. Mix base and hardener for at least 2 minutes thoroughly. The high solid content causes a rapid film build up.

### Application Recommendations



Conditions

Temperature: 15 – 35°C  
59 – 95°F  
Relative Humidity: 35 – 75%



Note

Aerodur<sup>®</sup> HS Primer 37092 may be applied in conditions outside of the the limits shown above. Care must be excercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.



Equipment

Air	1.4 mm nozzle orifice
HVLP	1.4 mm nozzle orifice
Airless Electrostatic	6.11 – 6.13, (.011 - .013 inch) angle 60°



Number of Coats

Spray an even wet coat



Cleaning of Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068



Note

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

## Physical Properties



Drying Times  
(21°C/70°F)

	<b>Hardener 92179</b>	<b>Hardener 92217</b>
Set to touch	2 hrs	1 hrs
Dry hard	5 hrs	2½ hrs
Recoatible minimum	5 hrs	2½ hrs
Recoatible maximum	48 hours*.	48 hours*.

\*) If a drying time of 48 hours is exceeded, condition the surface with e.g. Scotch Brite<sup>®</sup> type A very fine.



Theoretical Coverage

40 m<sup>2</sup> per base material at 20 µm dry film thickness  
1600 ft<sup>2</sup> per US gallon base material at 0.8 mil dry film thickness



Dry Film Weight

1.8 g/m<sup>2</sup>/µm



Gloss (60°)

Maximum 20 GU



Color

Green/Yellow  
BAC 452  
Black



Flash-point

Aerodur® HS Primer 37092	<21°C / 70°F
Hardener 92179	<21°C / 70°F
Hardener 92217	<21°C / 70°F



Storage

Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F. Stored in the original unopened containers.

Shelf life  
(21°C/70°F and  
55% RH)

Aerodur® HS Primer 37092	24 months
Hardener 92179	24 months
Hardener 92217	24 months

### Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDS's are available on request.

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. 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.

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Scotch-Brite® is a trademark of 3M.