AkzoNobel
Aerospace Coatings

Aerodur® Primer S 15/90

AkzoNobel
Tomorrow's Answers Today

Product Group

Polyurethane Primers

Characteristics

Product Information

Aerodur® Primer S 15/90 is a 3-component polyurethane primer for interior and exterior use:

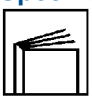
- Compatible with Metaflex® washprimer series, chemical conversion coatings and anodized surface treatments.
- Resistance to aircraft hydraulic fluids and chemicals.
- Corrosion inhibiting.
- Meets the performance requirements of MIL-P-23377 type 1 and BMS 10-79 type 1.

Components

Hardener
Thinner or
Activator

Hardener S 66/14 (faster drying)
Hardener S 66/22 R
Thinner C 25/90 S (normal conditions, flashpoint <21ºC)
Thinner 98064 (warm conditions, flashpoint >21ºC)
Thinner 96184 (warm conditions, flashpoint <21°C)

Specifications



Qualified
Product List

Airbus	AIMS 04.04.001 (NT 10.012 type 1) AIMS 04.04.003 (NT 10.012 type 2)
DIN-NL	WL 5.7050
BWB	TL 8010-001/2 class 2
MDC	DPS 4.50-187
FFV	FSD 7066
French Air Force	Approval nr. 035141

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

Surface Conditions

Cleaning

- Remove washprimer overspray with e.g. tack rags
- Primer Metaflex® washprimer series 2 – 8 hours after application.
- Prime chemical conversion coatings and anodized parts in a fresh condition.
- Clean and reactivate aged alodine film and sealed anodized surfaces with Metaflex® wash primer series (Depending on surface conditions use e.g. Scotch-Brite® type A very fine)
- Clean aged primer or epoxy / polyurethane finishes and sand with Scotch-Brite® type A very fine to a uniform and matt surface.
- Remove dust with e.g. tack rags.

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Aerodur® Primer S 15/90

Instruction for Use

Mixing Ratio (volume)

100 parts Aerodur® Primer S 15/90
50 parts Hardener S 66/14 or S 66/22 R

Reduce to spraying viscosity with:

50 - 100 parts Thinner C 25/90 S, Thinner 98064 or Thinner 96184

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur® Primer S 15/90 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener S 66/14 or S 66/22R and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.
- For application on structural parts use approximately 50 parts thinner C25/90S, for aircraft exterior use approximately 100 parts thinner.
- For warm conditions (temperature >26ºC) Thinner 98064 or 96184 are recommended.

Induction Time

15 – 30 minutes after mixing

Initial Spraying Viscosity (21ºC/70ºF)

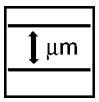
24 – 32 seconds ISO-Cup 3.
23 – 26 seconds Gardner Signature Zahn-Cup #1.

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 (21ºC/70ºF)

4 hours for Hardener S 66/14.
6 hours for Hardener S 66/22 R



Dry Film Thickness (DFT)

15 – 20 µm for exterior scheme; 20 – 30 µm for structural parts
0.6 – 0.8 mil for exterior scheme 0.8 – 1.2 mil for structural parts.

Application Recommendations

Conditions

Temperature:	15 – 35ºC 59 – 95ºF
Relative Humidity:	35 – 75%

Equipment

Air	1.4 mm nozzle orifice
HVLP	1.4 mm nozzle orifice
Air Electrostatic	1.2 mm nozzle orifice
Airless Electrostatic	6.11 – 6.13, (.011 - .013 inch) angle 60º

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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 (21ºC/70ºF)

Dry to tape	2 hours for S 66/14 4 hours for S 66/22 R
Recoatable minimum	2 hours for S 66/14 4 hours for S 66/22 R
Recoatable maximum	72 hours. If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.
Forced drying	30 minutes flash-off followed by 1 hour at 80ºC or 2 hours at 60ºC.

Dry Film Weight	+/- 1.8 g/m^2/µm +/- 0.0094 lbs/ft^2/mil
Theoretical Coverage	37 m^2 per liter base material at 15 µm dry film thickness 1484 ft^2 per US gallon base material at 0.6 mil dry film thickness
Gloss (60º)	Maximum 20 GU
Color	Yellow Green BAC 452

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Flash-point

Aerodur® Primer S 15/90	<21ºC / 70ºF
Hardener S 66/14	>21ºC / 70ºF
Hardener S 66/22 R	>21ºC / 70ºF
Thinner C 25/90S	<21ºC / 70ºF
Thinner 98064	>21ºC / 70ºF
Thinner 96184	<21ºC / 70ºF

Storage

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

Aerodur® Primer S 15/90	24 months
Hardener S 66/14	12 months
Hardener S 66/22 R	24 months
Thinner C 25/90S	36 months
Thinner 98064	36 months
Thinner 96184	36 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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