



Product Group

Epoxy Primers

Characteristics



Product
Information

Epoxy Primer 37035A is a 2 or 3-component amine cured epoxy primer with improved adhesion properties for interior and exterior use.

- Adheres to degreased, sealed and non-sealed anodized and alodined substrates.
- Resistance to aircraft hydraulic fluids and chemicals.
- Corrosion inhibiting.
- Compatible with polyurethane, epoxy and acrylic topcoats.

Components



Hardener
Thinner or
Activator

Hardener 92140 (for 3 component version)
Hardener 92162 (for two component, plural mixing systems)
Thinner C 25/90 S (normal conditions, flashpoint <21°C)
Thinner 98064 (warm conditions, flashpoint >21°C)
Thinner 96184 (warm conditions, flashpoint <21°C)

Specifications



Qualified
Product List

Airbus	AIMS 04.04.001 / 003 / 004
British Aerospace	BAER 7004
AVRO	AVP 3-003
Fairchild Dornier	DOL 255
EFA	SP-J-513-A-0016 type 1, Class A

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

Surface Conditions



Cleaning

- Prime chemical conversion coatings and anodized parts in a fresh condition.
- When Epoxy Primer 37035A is applied on non chemically pretreated aluminium, the substrate should be thoroughly cleaned and degreased with Solvent Cleaning C 28/15 (normal conditions) or Solvent Cleaning 98068 (warm conditions)
- Treat new aluminium with Scotch-Brite® type A very fine to a uniform matt surface.
- 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.

Instruction for Use



Mixing Ratio
3 component
version
(volume)

100 parts Epoxy Primer 37035A
50 parts Hardener 92140

Reduce to spraying viscosity with:

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

- Allow products to acclimatize to room temperature before use
- Stir or shake Epoxy Primer 37035A till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92140 and stir the catalyzed mixture thoroughly. Add thinner and stir again till a homogeneous mixture.



Induction Time

15 – 30 minutes after mixing (3 component system only)



Mixing Ratio
2 component
version
(volume)

100 parts
100 parts

Epoxy Primer 37035A
Hardener 92162

- Allow products to acclimate to room temperature before use
- Stir or shake Epoxy Primer 37035A till all pigment is uniformly dispersed before adding hardener
- The 2 component version has been developed for use with plural mixing systems



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

32 – 36 seconds ISO-Cup 3.
25 – 27 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
(21°C/70°F)

8 hours (3 component version)



Dry Film
Thickness
(DFT)

15 – 20 µm
0.6 – 0.8 mil

Application Recommendations



Conditions

Temperature: 15 – 35°C
59 – 95°F
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 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)

Set to touch 30 minutes
Dry hard 4 hours

Recoat minimum 4 hours
Recoat maximum 72 hours.
If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.



Theoretical Coverage

27 m² per base material at 15 µm dry film thickness
1100 ft² per US gallon base material at 0.6 mil dry film thickness



Dry Film Weight

+/- 1.8 g/m²/µm
+/- 0.0094 lbs/ft²/mil



Gloss (60°)

Maximum 20 GU



Color

Yellow / Green
Green 702267
Green BAC 452
Black



Flash-point

Epoxy Primer 37035A	<21°C / 70°F
Hardener 92140	<21°C / 70°F
Hardener 92162	<21°C / 70°F
Thinner C 25/90 S	<21°C / 70°F
Thinner 98064	>21°C / 70°F
Thinner 96184	<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.

Epoxy Primer 37035A	24 months
Hardener 92140	24 months
Hardener 92162	24 months
Thinner C 25/90 S	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.

Issue date: January 2010 (supersedes August 2009) - FOR PROFESSIONAL USE ONLY

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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