

# 10P4-3NF

## Fluid Resistant Epoxy Primer Lead and Cadmium Free

### Technical Data Sheet

#### Product Group

Epoxy primer

#### Characteristics



Product  
Information

- A chemically cured epoxy primer that provides excellent corrosion and chemical resistance for aircraft detail and subassembly parts.
- When used as the base primer for specification approved epoxy and polyurethane topcoats, the primer/topcoat system provides the optimum protection for interior structural components.
- This product adheres well to a variety of substrates.

#### Components



Curing Solution  
Thinner

Curing Solution: EC-117  
Thinner/Reducer: TR-19 or TR-20, as required

#### Specifications



Qualified  
Product List

Boeing BMS 10-11, Type I, Class A, Grade A  
Bombardier BAMS 565-001, Grade A

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

- Surface pretreatment is an essential part of the painting process.
- Follow specification requirements for cleaning and pretreatment application.

#### Instruction for Use



Mixing Ratio  
(volume)

- |             |                             |
|-------------|-----------------------------|
| 1 part      | Base 10P4-3NF               |
| 1 part      | Curing Solution EC-117      |
| 0 – 0.5 max | As required, TR-19 or TR-20 |
- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
  - Stir the catalyzed mixture thoroughly.

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Induction Time

30 minutes



Initial Spraying  
Viscosity  
(25°C/77°F)

25 – 55 seconds ISO-Cup #3  
25 – 35 seconds Signature Zahn Cup #1  
12 – 16 seconds 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  
(25°C/77°F)

16 hours maximum



Dry Film  
Thickness  
(DFT)

13 – 18 micron ( $\mu\text{m}$ )  
0.5 – 0.7 mils

#### Application Recommendations



Conditions

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



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.

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Equipment

Air  
HVLP

0.052 – 0.070 in nozzle orifice  
1.2 – 1.4 mm nozzle orifice



Number of  
Coats

Spray a single uniform wet coat to recommended dry film thickness.



Cleaning of  
Equipment

### Physical Properties



Drying Times  
(25 +/- 2°C / 77  
+/- 2°F, 55 +/-  
5% RH)

Dust Free	15 minutes
Tack Free	2 hours
Dry through	4 hours
Dry to topcoat	1 hour



Theoretical  
Coverage

8.6 m<sup>2</sup> per liter ready to apply at 25 µm dry film thickness  
350 ft<sup>2</sup> per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

46.91 g/m<sup>2</sup> at 25.4 micron  
.0096 lbs/ft<sup>2</sup> at 1 mil



Volatile Organic  
Compounds

Max 650 g/l  
Max 5.4 lb/gal, maximum (without thinner), per ASTM D3960

## 10P4-3NF

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Gloss (60°)

10 maximum GU



Color

Yellow BAC 377



Flash-point

10P4-3NF	5°C (23°F)
EC-117	12°C (53°F)
TR-19	-4°C (25°F)
TR-20	4°C (40°F)



Storage

Store the product dry and at a temperature between 5 and 38°C / 40 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life  
5 - 38°C  
(40 - 100°F)

24 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

#### 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.

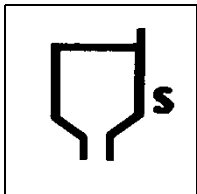
**Issue date: January 2015 (supersedes September 2011) - FOR PROFESSIONAL USE ONLY**

**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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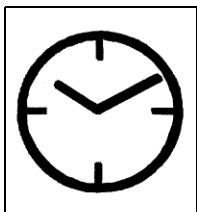
 <b>Base:</b> 10P4-3NF 1 parts	 <b>Curing Solution:</b> EC-117 1 part	 <b>Thinner/Reducer:</b> TR-19 or TR-20 0-.5 part max. (as required)
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At 77°F (25°C):  Pot life: Induction Time:	Mix Viscosity:  16 hours maximum 30 minutes	25 – 35 Seconds Zahn Cup #1 12 – 16 Seconds Zahn Cup #2
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One coat needed:  Dry film thickness:	Spray a single uniform wet coat to recommended dry film thickness  0.5 to 0.7 mils (13 – 18 microns)
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At 77°F ± 2°F 25°C ± 2°C & 55% ± 5% RH	
Dust Free: Tack Free: Dry to Topcoat: Dry Through:	15 Minutes 2 Hours 1 Hour 4 Hours



Type equipment	Tip Size	Gun Air Pres.	Pot Air Pres.	Other
HVLP	1.2 – 1.4 mm			

We have taken reasonable care in preparing the Mixing Guide and in collecting and preparing material for inclusion in it but do not represent or warrant that it is free from error or that the information content is complete or accurate. The information is advisory only and the use of the Material is solely at your own risk.