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

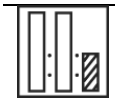
For most recent up-date or missing specifications please check the qualified product list (QPL) on **www.akzonobel.com/aerospace**

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.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905, Fax (31) 71 308 2056
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Induction Time	30 minutes
Initial Spraying Viscosity (25ºC/77ºF)	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 (25ºC/77ºF)	16 hours maximum
Dry Film Thickness (DFT)	13 – 18 micron (µm) 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 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Dust Free Tack Free Dry through Dry to topcoat	15 minutes 2 hours 4 hours 1 hour
Theoretical Coverage	8.6 m^2 per liter ready to apply at 25 μm dry film thickness 350 ft^2 per US gallon ready to apply at 1 mil dry film thickness	
Dry Film Weight	46.91 g/m^2 at 25.4 micron .0096 lbs/ft^2 at 1 mil	
Volatile Organic Compounds	Max 650 g/l Max 5.4 lb/gal, maximum (without thinner), per ASTM D3960	

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Gloss (60º)	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 38ºC / 40 and 100ºF 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.	

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AkzoNobel
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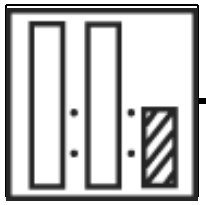
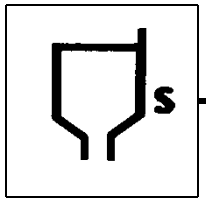
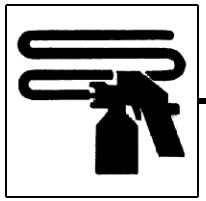


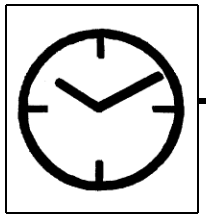
Base:	Curing Solution:	Thinner/Reducer:
10P4-3NF	EC-117	TR-19 or TR-20
1 parts	1 part	0-.5 part max. (as required)



At 77°F (25°C):		
Mix Viscosity:	25 – 35 Seconds Zahn Cup #1 12 – 16 Seconds Zahn Cup #2
Pot life:	16 hours maximum
Induction Time:	30 minutes

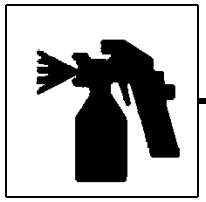


One coat needed:	Spray a single uniform wet coat to recommended dry film thickness
Dry film thickness:	0.5 to 0.7 mils (13 – 18 microns)



At 77°F ± 2°F 25°C ± 2°C & 55% ± 5% RH

Dust Free:	15 Minutes
Tack Free:	2 Hours
Dry to Topcoat:	1 Hour
Dry Through:	4 Hours



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

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