

Aerodur 2111 Non Chrome Primer

Technical Data Sheet

Product Group

High Solid Epoxy Chromate Free Primer

Characteristics



Product
Information

A, chrome free, corrosion inhibiting, urethane compatible, Skydrol® resistant primer for application to aircraft exterior surfaces. Aerodur 2111 provides excellent corrosion protection and optimizes the system adhesion of the exterior decoration finish.

Components



Base
Curing Solution,
Thinner/Reducer

2111P001
CS6018
TR-114 (VOC exempt solvent)

Specifications



Qualified
Product List

Embraer	MEP 10-068, TY II, CL A&B
Irkut	741.140/21-00-00-0038-0T04/0A
Boeing	BMS 10-72 TY X, NC2
Gulfstream	GMS 5008

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

Surface Conditions



Cleaning

Surface Pretreatment: Metaflex SP 1050
Refer to Metaflex SP 1050 Technical Data Sheet and Product Application Sheets for detailed instructions on the cleaning and surface pretreatment process.
AC-131, PreKote or alternative sol gel pre-treatment

Instruction for Use



Mixing Ratio
(volume)

Mixing Ratio
(By volume or by

2 parts	Base 2111P001
1 part	Curing Solution CS6018
1 part	Thinner TR-114*

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.

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weight)

- Stir the catalyzed mixture thoroughly.
*TR-114 is a VOC exempt and HAPS free thinner.



Mixing Ratio
(Weight)

Mixing proportions by weight for less than full kits, 400 ml volume:

273.5 grams	2111P001
110.3 grams	CS6018
114.3 grams	TR-114 or
88.9 grams	TR-115



Induction Time

15 minutes



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

13 – 17 seconds Zahn-Cup #2
12 – 14 seconds #4Ford Cup
18 – 26 seconds ISO Cup 4



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)

4 hours



Dry Film
Thickness
(DFT)

15 – 25 micron (μm)
0.6 – 0.9 mils



Note

The application characteristics of VOC compliant products differ from conventional products in that the required film thickness will be achieved in fewer passes with the spray gun.

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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.



Equipment

- Conventional air
Atomizing air pressure: 60 – 70 psi
Pot pressure (if applicable): 5 – 20 psi
- Air assist airless electrostatic
Fluid pressure: 850 – 1000 psi
Atomizing air pressure: 65 – 75 psi
Tip size: 0.013" (0.33mm) or smaller, preferably .011" (0.28mm)
- High pressure air assist electrostatic (i.e., Graco Pro 4500)
Fluid pressure: 1800 – 2500 psi
Atomizing air pressure: 60 – 75 psi
Tip size: 0.009-0.013" (0.23-0.28mm)



Number of Coats

Spray a single uniform wet coat to a dry film thickness of 15 – 25 micron (µm) (0.6 – 0.9 mils).









Cleaning of Equipment

Use TR - 36, Solvent Cleaning C28/15, Solvent Cleaning 98068 or MEK..

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Physical Properties

	Drying Times (25 +/- 2°C / 77 +/- 2°F, 55 +/- 5% RH)	Dry to topcoat with TR-114	2.5 hours
		Dry to tape with TR-114	3 – 4 hours
		Maximum recoat window, without reactivation	48 hours
	Theoretical Coverage	27.9m ² per liter per 19.1µm dry film thickness 1136 ft ² per US gallon at 0.75 mil dry film thickness	
	Dry Film Weight	0.0396 kg/m ² /25.4µm 0.0081 lbs/ft ² /mil	
	Gloss (60°)	≤10 GU	
	Color	Tan	
	Flash-point	2111P001	16°C / 60°F
		CS6018	4°C / 40°F
		TR-114	-17°C / 1°F

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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.

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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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