

TECHNICAL DATA

EP-2-GN1 / EH-12 / SC-11 HIGH SOLIDS GREEN EPOXY PRIMER

January 2011

PRODUCT DESCRIPTION:

A multi-component urethane compatible primer resistant to Filliform corrosion, skydrol and fluids. It is intended for use on commercial and general aviation aircraft exteriors and components. EP-2-Y1 has a V.O.C. of less than 350 g/l.

MEETS OR EXCEEDS THE PERFORMANCE REQUIREMENTS OF SPECIFICATION:

Boeing BMS 10-72, Type IX / Boeing BMS 10-79, Type II & III, Class B, Grade D / Boeing DMS 2104 / Bombardier BAMS 565-008, Type II, Class A, Grade B / SAE AMS 3095 / Embraer MEP 10-068 / Boeing DPM 6597 / Saab 51-33-00 / Airbus AIMS 04-04-013 / Northrop Grumman GP110AEE10 / MIL-PRF-23377 Type I, Class C2 and de Havilland DHMS C4.18 PQS 8.

SURFACE PREPARATION:

To insure proper adhesion, scotch brite or sandpaper abrade, then solvent clean with Axon SR-40, all surfaces prior to painting. All previously painted surfaces must be free from dirt, oils, and any contaminants prior to painting. Blow and tack surfaces to be painted immediately prior to application of primer.

MIXING / APPLICATION:

Mix thoroughly, by volume two parts EP-2-GN1 base with one part EH-12 hardener and one part SC-11 catalyst. Mix under agitation for 30-45 minutes prior to application. If temperatures are below 60°F then agitate 60-90 minutes. Material should remain under agitation during the entire application. The pot life of the mixed material will be 2-3 hours. Spray apply a single wet uniform coat to a dry film thickness of 0.6-0.8 mils, using air siphon, electrostatic, HVLP or air assisted airless spray equipment. Allow primer to dry for a minimum of 2-3 hours or a maximum of twenty four hours prior to topcoating. Please refer to the Axon Process Standard for Time/Temp overcoat information. When exceeding 48 hours dry time of primer, sanding and re-priming is recommended for optimum results. Reduce 5-20% as needed with SR-350 VOC Compliant Reducer to maintain VOC compliance or SR-12. Reduction will aid in film thickness control and provide a smooth film appearance.

Caution!! Do not apply primer below 55°F as Epoxy Amine bloom may occur on the primer surface and adversely affect topcoat adhesion.

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PHYSICAL PROPERTIES:

Appearance:		Translucent Green
Admixed Viscosity:		15 - 17 seconds, #2 Zahn signature @ 75°F, 50% RH
Volume Solids:	A) Admixed	52.44%
	B) Base (EP-2-Y1)	61.25%
	C) Hardener (EH-12)	47.86%
	D) Catalyst (SC-11)	39.40%
Coverage		@ 100% Usage - No Loss: 841 sq. ft/mil
Dry Film Weight:		Per dry mil 0.00794 lbs./sq.ft. (36 g/m ²)
VOC: Admixed EPA Method 24		350 g/L 2.9 #/gal
Cure times @ 75°F, 50% RH @ .8 mils		
Dust Free:		45 minutes to 1 hour
Tack Free:		1 to 1.5 hours
Dry to Tape:		3 hours
Dry to Top Coat:		2 hours
Shelf Life:		2 Years from date of manufacture

PRECAUTIONS:

This product can be applied safely when used as recommended. Avoid skin contact. If eye contact is made, flush immediately and consult a physician. Read and become familiar with the Material Safety Data Sheet. Keep away from children.