

Aerodur 2111

Technical Data Sheet

Product Group

Epoxy Primer

Characteristics



Product
Information

A chrome free, corrosion inhibiting, urethane compatible, phosphate ester hydraulic fluids 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 material	2111P001
Curing Solution	CS6018
Thinner	TR-114 (US EPA VOC exempt thinner)

Specifications



Qualified
Product List

Boeing	BMS 10-72 TY X, NC2
Embraer	MEP 10-068, TY II, CL A&B
Irkut	741.140/21-00-00-0038-0T04/0A
Pilatus	PMS0600-52-01, VV0607-22

Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

Surface Conditions



Cleaning

- 2111 can be applied directly over reactivated aged primer when the layer thickness is $>10 \mu\text{m}/0.4\text{mils}$.
- When applied over chemically stripped or uncoated metallic substrate, the substrate shall be pretreated according to the relevant OEM specification (Airbus SRM 10PEG1 or Boeing AMM/SRM per BAC 5075).
- 2111 is compatible with Metaflex SP 1050 in line with BMS 10-128 pretreatments and with qualified chromated pretreatments.
- Clean aged primer or epoxy/polyurethane finishes and sand/abrade to a uniform matt finish using grade P320 sandpaper or an aluminum oxide non-woven abrasive pad.
- Clean and degrease the surface with an approved cleaning solvent prior to application of the pre-treatment or primer.
- Remove dust and debris with a tack rag or equivalent.

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Instruction for Use



Mixing Ratio (volume)	2111P001	2 parts
	CS6018	1 part
	TR-114	1 part

Mixing Ratio
(By volume or by weight)

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.



Mixing Ratio (Weight)	2111P001	273.5 g
	CS6018	110.3 g
	TR-114	114.3 g

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



Induction Time 15 minutes



Initial Spraying 13-17 seconds Zahn-Cup #2
Viscosity 25-33 seconds #2 Ford Cup
(23°C/73°F) 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 4 hours
(23°C/73°F)

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Dry Film Thickness (DFT) 13–25 μm
0.5–1.0 mil



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.

Application Recommendations



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



Note Eclipse may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.



Equipment	Spray gun type	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet*
	Conventional	Gravity Feed: 1.2mm-1.4mm	350-475ml/min	Use enough Air Pressure. $\leq 100\text{psi}$ or (7 bar)
		Pressure Feed: 1.2mm-1.4 mm		
	HVLP/ next generation	Gravity Feed: 1.2mm-1.4mm,	240ml -350ml/min	maximize and ensure uniform fan pattern, not to exceed regulatory guideline for air pressure at the cap.
		Pressure Feed: 1.2mm -1.5mm		

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Air spray electrostatic	1.2mm & 1.5mm	1.2mm tip: fluid flow 230-240 ml/min	58-65 psi / 4-4.5 bar
		1.5mm tip-fluid flow rate up to 300-360 ml/min	

High pressure Air Assisted electrostatic	angle 0.09-0.13 inch/60°	260 – 300ml/min	Fluid pressure: 75-90 psi / bar 0.9-1.3 psi Air pressure at gun inlet: 58-65 psi / 4-4.5 bar
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Number of Coats

Spray a single uniform wet coat to a dry film thickness of 13–25 µm (0.5–1.0 mils).



Cleaning of Equipment

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

Physical Properties



Drying Times
(23°C/73°F)

Dry to topcoat	2.5 hours
Dry to tape	3-4 hours

Maximum recoat window, without reactivation	48 hours
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Theoretical Coverage

31.2 m² per liter ready to apply at 13 µm dry film thickness.
1272 ft² per US gallon ready to apply at 0.5 mil dry film thickness.



Volatile Organic Compounds

624 g/L / 5.21 lbs/gal
350 g/L / 2.92 lbs/gal - excluding exempt solvents acc. to US EPA.

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Gloss (60°) ≤10 GU



Color Tan



Flash-point	2111P001	16°C / 60°F
	CS6018	4°C / 40°F
	TR-114	-17°C / 1°F



Storage Store the product dry and at a temperature between 5 and 38°C / 41 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature and shelf life may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life	2111P001	24 months
5 - 38°C	CS6018	24 months
(41 - 100°F)	TR-114	24 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.

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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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