

# Aerodur LV 2114

## Technical Data Sheet

### Product Group

Epoxy Primers

### Characteristics



Product  
Information

Aerodur LV 2114 is a VOC compliant (acc. to US legislation) corrosion inhibiting 3-component amine cured epoxy primer. It shows optimal chemical resistance and durability properties when applied in combination with specific exterior topcoat / basecoat clearcoat systems.

- Airbus OEM approved MRO coating system (Airbus structural repair manual) when applied in combination with the Airbus approved topcoats, basecoat / clearcoat and wing coating, can be used with or without intermediate coating Aerodur Sealer 42240. This single primer is the alternative to the traditional wash primer, PU primer, refresh primer system.
- AMS 3095A approved with many of AkzoNobel topcoats / basecoat-clearcoats for application over old paint layers.
- Can be applied on a Boeing aircraft fuselage when used in combination with a BMS 10-128 approved sol-gel type of pre-treatment.

### Components



Base material	2114P001
Curing Solution	CS6022
Thinner	TR-114 (VOC exempt solvent per US guidelines) or TR-102

### Specifications



Qualified  
Product List

Airbus	SRM, task 51-75-12-911-019 or 020, CML 477200
SAE International	AMS 3095A

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

# Aerodur LV 2114

## Surface Conditions



Cleaning

- Aerodur LV 2114 can be applied directly over an activated aged coating system when the layer thickness is  $>10 \mu\text{m}$ .
- When applied over chemically stripped or uncoated metallic substrate, the substrate needs to be pretreated according to the Airbus SRM (10PEG1, Socogel A0203) or Boeing AMM (BMS 10-128).
- Clean aged primer or epoxy / polyurethane finishes and sand with grade P320 sanding paper or aluminum oxide non-woven abrasive material grade very fine to a uniform and matt surface.
- Remove dust and debris with e.g. tack rags.
- Clean and degrease the surface with a sufficient and approved cleaning solvent prior to application of the assigned pretreatment or primer.

## Instruction for Use



Mixing Ratio

	Volume (v/v)	Weight (w/w)
Base 2114P001	2 parts	100 parts
Curing Solution CS6022	1 part	34 parts
Thinner TR-114* or TR-102**	1 part	32 parts

- Stir or shake base until all pigment is uniformly dispersed before adding curing solution and thinner.
- Add CS6022 and manually stir the catalyzed mixture for 1 minute to a homogeneous mixture.
- Add Thinner TR-114 or TR-102 and stir manually for an additional minute.  
\*TR-114 is a VOC exempt and HAPS free thinner, per US guidelines  
\*\*TR-102 is a non-exempt thinner that raises total VOC



Induction time

15 minutes after mixing



Initial Spraying Viscosity (23°C/73°F)

14 – 18 seconds Gardner Signature Zahn-Cup #2  
16 – 28 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.

## Aerodur LV 2114



Pot life  
(23°C/73°F)

3 hours



Dry Film  
Thickness  
(DFT)

15 – 25  $\mu\text{m}$   
0.6 – 1.0 mil

### Application Recommendations



Conditions

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



Note

Aerodur LV 2114 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  
recommend  
ation

Spray Gun Type	Nozzle Orifice	Product Flow <sup>1</sup>	Dynamic Air Pressure at gun-inlet <sup>2</sup>
Conventional	1.2 – 1.5 mm	260 – 300 mL/min	4 – 4.5 bar / 58 – 65 psi
HVLP / next generation	1.2 – 1.5 mm	260 – 300 mL/min	2 – 2.5 bar / 29 – 36 psi <sup>3</sup>
Air atomizing (electrostatic)	1.2 – 1.5 mm	260 – 300 mL/min	4 – 4.5 bar / 58 – 65 psi
Pressure atomizing (electrostatic)	0.09 inch/60°	65 – 75 bar/1.02 kpsi	4 – 4.5 bar / 58 – 65 psi
	0.013 inch/60°	25 – 35 bar/0.43 kpsi	

<sup>1</sup> Product Flow not applicable when using gravity/suction feed guns.

<sup>2</sup> Dynamic Air Pressure at gun-inlet measured with an open trigger.

<sup>3</sup> General advice to meet the HVLP / next generation spray gun requirements, please validate with your local authorities.

## Aerodur LV 2114



Number of Coats

Spray-apply a homogeneous, wet and closed coat in order to achieve a dry film thickness of 15 – 25 µm / 0.6 – 1.0 mil.



Cleaning of equipment

Thinner TR-36, Solvent Cleaning C 28/15, Solvent Cleaning 98068 or MEK (Methyl Ethyl Ketone).



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 to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

### Physical Properties



Drying Times

	23°C/73°F – 55% RH
Dry to topcoat	2 hours
Dry to tape	3 – 4 hours
Recoat maximum	48 hours

If the overcoat time of 48 hours is exceeded, recondition the aged primer with aluminum oxide non-woven abrasive, type very fine or P320 grade sanding paper before applying the subsequent coating.

When using Aerodur Sealer 42240 on top of Aerodur LV 2114 the following overcoat times apply:

Temperature \ RH	20 – 40%	41 – 60%	61 – 80%
20 – 25°C / 68 – 77°F	2 – 4 hrs	2 – 4 hrs	2 – 4 hrs
26 – 30°C / 78 – 86°F	2 – 4 hrs	2 – 4 hrs	2 – 3 hrs
31 – 35°C / 87 – 95°F	1 – 3 hrs	1 – 3 hrs	1 – 2 hrs



Note

Recommended application window for best product performances is 20-25°C and 20-60% RH.

Table above is provided as an indication for a product applied at the recommended DFT and may vary upon the exact temperature and humidity combination. If for sealer coat application the recommended overcoat time of Aerodur LV 2114 is exceeded, a fresh layer of primer must be applied according to the TDS to ensure optimal adhesion of the system.

## Aerodur LV 2114



Theoretical Coverage

21 m<sup>2</sup> per liter ready to apply at 20 µm dry film thickness  
857 ft<sup>2</sup> per US gallon ready to apply at 0.8 mil dry film thickness



Dry film Weight

2.017 g/m<sup>2</sup>/µm  
0.0090 lbs/ft<sup>2</sup>/mil



Volatile Organic Compounds

European guidelines

Maximum 588 g/l, with exempt solvent  
Maximum <4.9 lb/gal, with exempt solvent

US guidelines

Maximum 345 g/l  
Maximum 2.9 lb/gal



Color

Yellow



Gloss (60°)

Maximum 10 GU



Flashpoint

Primer 2114P001 <21°C / 70°F  
Curing Solution <21°C / 70°F  
CS6022 <21°C / 70°F  
Thinner TR-114 <21°C / 70°F  
Thinner TR-102



Storage

Store the product dry and at a temperature between 5 – 35°C / 41 – 95°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Refer to container label for specific storage life information.

Shelf life  
5 - 35°C  
(41 - 95°F)

Primer 2114P001 12 months  
Curing Solution 12 months  
CS6022 12 months  
Thinner TR-114 24 months  
Thinner TR-102

## Aerodur LV 2114

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### 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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