

Alumigrip 10P8-11

Technical Data Sheet

Product Group

Epoxy primer

Characteristics



Product
Information

A two component, VOC compliant epoxy primer designed to provide a very smooth finish optimizing the appearance of the subsequent topcoat.

Alumigrip 10P8-11 utilizes exempt solvents in meeting the required VOC level.

Components



Base material	10P8-11
Curing Solution	EC-286

Specifications



Qualified
Product List

Cessna	CMFS035. CSFS084
Textron Aviation	TM 3405
US Military	MIL-PRF-23377 Type I, Class C2

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

- Surface pretreatment is an essential part of the painting process.
- Apply over similar MIL-C-5541 pre-treated aluminum substrates or as a reactivation primer over previously primed, painted and sanded paint systems.

May also be applied over Metaflex SP 1050.

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Instruction for Use



Mixing Ratio
(volume)

10P8-11
EC-286

1 part
1 part

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



Induction Time

Not Applicable.



Note

For use with plural component equipment. Product can also be sprayed with conventional spray equipment with pressure pot or siphon cup.



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

32-45 seconds ISO-Cup 4
17-23 seconds Zahn- Signature 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
(23°C/73°F)

4 hours



Dry Film
Thickness
(DFT)

15-23 μm
0.6-0.9 mils

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Application Recommendations



Conditions

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



Note

Alumigrip 10P8-11 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. ≤100psi 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



Number of Coats

Apply 1 full wet coat to reach required film thickness.



Cleaning of Equipment

Use MEK, MPK or similar.

Physical Properties



Drying Times
(23°C/73°F)

Dry to topcoat	2 hours
Full cure	7 days air dry
Ambient cure	Ambient cure Set to touch in 30 minutes (77°F/25°C @ 50% RH)
	- Accelerated cure, option 1: Accelerated cure flashing 20 minutes at RT followed by 6 minutes at 180°-220°F / 82°-105°C will result in a dry-to-handle, dry-to topcoat, or dry-to-stack condition.

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- Accelerated cure, option 2: Accelerated cure flashing 20 minutes at RT followed by 30 minutes at 120°F/49°C will result in a dry-to-handle, dry-to topcoat, or dry-to-stack condition.



Theoretical Coverage

21.5 m² per liter ready to apply at 15 µm dry film thickness.
876 ft² per US gallon ready to apply at 0.6 mil dry film thickness.



Dry Film Weight

1.66 g/m²/µm
0.00862 lbs/ft²/mil



Volatile Organic Compounds

825 g/L / 6.88 lbs/gal
340 g/L / 2.84 lbs/gal - excluding exempt solvents acc. to US EPA



Gloss (60°)

<6 GU



Color

Reddish Green



Flash-point

10P8-11	27°C / 81°F
EC-286	43°C / 109°F
TR-114	-17°C / 1.4°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 may vary per OEM specification requirements. Refer to container label for specific storage life information.

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Shelf life	10P8-11	24 months
5 - 38°C	EC-286	24 months
(41 - 100°F)		

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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