P250 METAL PRIMER

SPECIAL COATINGS

AkzoNobel

Product information

Low VOC chromate free epoxy primer resistant to high temperature up to 350 °C (660 °F) in peak.
This product can be applied directly on metal with surface treatment

Components

Base P250 Metal Base
Hardener / Catalyst P250 Metal Hardener

Specifications

Qualified in accordance with:
Bombardier : BAMS 565-013 Type II Class 2

Physical properties

THEORETICAL COVERAGE
18 m²/L (730 ft²/gal) for 20 µm (0.8 mils) dry

DRY FILM WEIGHT
1.4

VOC
350 g/L (ASTM D3960)

COLOR
Metal Grey

SHELF LIFE / STORAGE
1 year for the base and hardener, stored between 5°C and 35°C (40°F and 95°F) and in full and sealed original packaging.

GLOSS LEVEL
Below 40 GU at 60°

Surface preparation

Surface must be properly degreased and free from dust. P250 has been developped and tested on aluminum alloys with anodized surface or conversion coatings and stainless steel.

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Instructions for use

SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	8 V
Hardener / Catalyst	11	1 V

MIXING PROCEDURE
Ideally, the unmixed products should be stored between 18°C (64°F) and 25°C (77°F) for 24 hours before use.
The P250 base should be mixed for 5 to 10 minutes in a pneumatic or oscillating mixer before use.
Mix the base and the hardener until the mixture is homogeneous. The mixture must be made at a temperature between 15°C (59°F) and 35°C (95°F).
Sieve the paint through a 120-150 µm (4.7-5.9 mils) filter.

INDUCTION TIME
None

Spraying viscosity at 20°C / 68°F

ISO 4 Cup	Zahn 2 Cup
23 ± 6 s	21 ± 4 s

POT LIFE
3 hours

NOTE
Pot life depends on the temperature

The paint viscosity may vary depending on the temperature and increases over the pot life.

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Application recommendations

CONDITIONS
Temperature 15°C to 35°C (59°F to 95°F)
Relative humidity 35 % to 80 %

EQUIPMENT
Gravity compressed air gun Nozzle 1 mm to 1.5 mm

DRY / WET FILM THICKNESS
15 µm to 30 µm (0.6 to 1.2 mils) dry /20 µm to 45 µm (0.8 to 1.8 mils) wet.

NUMBER OF COATS
Apply 1 crossed coat to achieve 15 µm to 30 µm (0.6 to 1.2 mils) dry thickness. Each coat has to be wet and of the same thickness.
The number of coats depends on the size and the shape of the part to be painted.
The recommended dynamic air pressure is 2 bar to 4 bar (29 to 58 psi).

EQUIPMENT CLEANING
Clean the equipment with a suitable cleaning solvent such as D760 cleaner.

NOTE
Spray with dry, oil-free air.

Drying times

	60°C (140°F)	InfraRed (60°C - 140°F)
Dust free	30 minutes	15 minutes
Dry to handle	1 hour 15	20 minutes
Recoatable	30 minutes to 2 hours	20 minutes to 1 hour 30
Fully Cured	3 hours	2 to 3 hours

NOTE
Drying times have been determined using test pieces of 1 mm thickness, with a 20 µm (0.8 mils) dry film.
Drying time and temperature (evaporation and curing) are given for information only and may vary depending on humidity, air flow, the shape, the material of the workpiece and the thickness of the paint.
Parts whose drying was forced must cool down to below 35 °C (95°F) before proceeding to the next step.

Defects & corrections

In case of defect, please contact the Quality Department.

Health & Safety

See the product Security Data Sheets.

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