



Product Group

Fluid resistant primers

Characteristics



Product Information

Epoxy Primer 37002 is a 3-component polyamide cured epoxy primer designed for application on structural parts and on the exterior of military aircraft:

- Compatible with Metaflex[®] CP Primer, chemical conversion coatings and anodized surfaces.
- Resistance to aircraft fluids and chemicals.
- Corrosion inhibiting.

Components



Hardener Thinner or Activator

Hardener 92057 (S 66/16)
Thinner C 25/90 S

Specifications



Qualified Product List

General Dynamics	FMS 3027
DIN-NL	WL 5.7011

For most recent up-date or missing specifications please check the qualified product list (QPL) on www.akzonobel.com/aerospace

Surface Conditions



Cleaning

- Apply Epoxy Primer 37002 on chemical conversion coatings, freshly anodized substrates or on Metaflex[®] CP Primer.
- Apply Epoxy Primer 37002 on Metaflex[®] CP Primer between 6 and 24 hours after application of the primer.
- Clean aged alodine films and sealed anodized surfaces and reactivate with Metaflex[®] CP Primer. Depending on surface condition, the use of Scotch-Brite[®] type A very fine should be considered
- Clean aged primer or epoxy/polyurethane finishes and use e.g. Scotch-Brite[®] type A very fine to obtain a uniform matt surface.
- Remove dust with e.g. tack rags.

Instruction for Use








Mixing Ratio (volume)

100 parts	Epoxy Primer 37002
100 parts	Hardener 92057







Reduce to spraying viscosity with:
50 - 75 parts Thinner C 25/90 S

- Allow products to acclimatize to room temperature before use.
- Stir or shake Epoxy Primer 37002 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.










	Induction Time	15 – 30 minutes after mixing	
	Initial Spraying Viscosity (21°C/70°F)	33 – 36 seconds ISO-Cup 3 26 – 27 seconds Gardner Signature Zahn-Cup #1.	
	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 (21°C/70°F)	8 hours	
	Dry Film Thickness (DFT)	Exterior camouflage & decoration scheme: 15 – 20 micron (µm) 0.6 – 0.8 mils	Structural parts: 20 – 30 micron (µm) 0.8 – 1.2 mils

Application Recommendations

	Conditions	Temperature:	15 – 35°C 59 – 95°F
		Relative Humidity:	35 – 75%
	Note	Epoxy Primer 37002 may be applied in conditions outside of the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.	
	Equipment	Air	1.4 mm nozzle orifice
		HVLP	1.4 mm nozzle orifice
		Airless	6.11 – 6.13 (.011 – 0.013 inch angle 60°)
	Number of coats	Spray an even wet layer	
	Cleaning of Equipment	Solvent Cleaning C 28/15 or Solvent Cleaning 98068	
	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 in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.	



Physical Properties

	Drying Times (21°C/70°F, 55% RH)	Set to touch Dry hard Recoat min. Recoat max.	30 minutes 6 hours 2 hours 72 hours. If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.
	Theoretical Coverage	38 m ² per liter base at 15 µm dry film thickness 1524 ft ² per US gallon base at 0.6 mil dry film thickness	
	Dry film weight	1.7 g/m ² /µm 0.0088 lbs/ft ² /mil	
	Gloss (60°)	Maximum 10 GU	
	Color	Yellow	
	Flash-point	Epoxy Primer 37002 Hardener 92057 Thinner C 25/90 S	<21 °C / 70 °F <21 °C / 70 °F <21 °C / 70 °F
	Storage	Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F. Stored in the original unopened containers.	
		Epoxy Primer 37002 Hardener 92057 Thinner C 25/90 S	24 months 24 months 36 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.

Issue date: September 2015 (supersedes October 2012) - FOR PROFESSIONAL USE ONLY

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.

Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.
Scotch-Brite® is a trademark of 3M.