AkzoNobel
Aerospace Coatings

464-3-1
Epoxy Primer Surfacer

AkzoNobel
Tomorrow's Answers Today

Product Group

Primer surfacer

Characteristics

Product Information

- This two-component epoxy primer surfacer is designed to provide a durable smooth surface ready for subsequent topcoat.

Components

Curing Solution, Thinner/Reducer

Curing Solution CA-142
Thinner TL-52

Specifications

Qualified Product List

Boeing Long Beach	DPM 5766
VIAM	TR 9-5.09-95

The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: **www.akzonobel.com/aerospace**

Surface Conditions

Cleaning

- Surface pretreatment is an essential part of the painting process
- **Steel surfaces:** Solvent clean and abrade, chemical treat or grit blast to remove grease, rust and contamination.
- **Plastic composite surfaces:** Solvent clean to remove oil, mold release compound and uniformly abrade to matte surface.

Instruction for Use

Mixing Ratio (volume)

3 parts	Base 464-3-1
1 part	Curing Solution CA-142
0-0.4 as needed	Thinner TL-52

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

Induction Time

30 minutes

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Initial Spraying Viscosity (25ºC/77ºF)	25 – 30 seconds 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 (25ºC/77ºF)	5 hours.
Dry Film Thickness (DFT)	75 – 125 micron (µm) 3 – 5 mils

Application Recommendations

Conditions	Temperature:	15 – 35°C 59 – 95°F
	Relative Humidity:	35 – 75%
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.	
Equipment	Conventional Air HVLP	1.4 mm (.055 inch) nozzle orifice 1.4 mm (.055 inch) nozzle orifice
Number of coats	Apply multiple cross-coats to 75µ (0.003”). Additional applications may be made with solvent flash-off.	
Cleaning of Equipment	Use a VOC compliant solvent blend.	

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Physical Properties

Drying Times (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Dry to handle	15-30 minutes
	Dry to recoat or sand	2-4 hours
	Dry through	24 hours
Theoretical Coverage	15.7 m^2 per liter ready to apply at 25 µm dry film thickness 640 ft^2 per US gallon ready to apply at 1 mil dry film thickness	
Dry Film Weight	48 g/m^2/25 micron .01 lbs/ft^2/1 mil	
Density	1.25 ± 0.02 g/l 10.4 ± 0.2 lb/gal	
Volatile Organic Compounds	Max 508 g/l no reducer Max 538 g/l with TL-52 Max 4.2 lb/gal no reducer Max 4.5 lb/gal with TL-52	
Gloss (60º)	5 maximum GU	
Color	White	
Flash-point	464-3-1	-5ºC / 23ºF
	CA-142	12ºC / 53ºF
	TL-52	-4ºC / 25ºF
Storage	Store the product dry and at a temperature between 5 and 38ºC / 40 and 100ºF 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.	
Shelf life 5 - 38°C (40 - 100°F)	24 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.	

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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 MSDSs are available on request.

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