



## TECHNICAL DATA SHEET



# AEROPRIM EP 140

PRIMER  
Two component

Edition December 07

**EPOXY POLYAMINO-AMIDE PRIMER.  
With strontium chromate for a "high anti-corrosive  
protection" of aluminium, alloys and steel.  
Applicable in thin film**

## FEATURES

This primer can be applied on the aircraft interiors and exteriors.

Can be applied on Aluminium alloys, aluminium and steel ships above and below water line.

Very high chemical resistance.

Fast and easy recoatability with undercoat 215 HB, or with topcoat after a light sand polish (Scotch-Brite® Grade A).

Accepts epoxy fillers without sanding.

## RECOMMENDED USES

Two component yellow-colored epoxy-polyamide anti-corrosion primer, for Aluminium and Steel, with strontium chromate, providing the utmost protection from filiform Aluminium corrosion and resistant to hydraulic fluids (skydrol).

### CERTIFICATIONS :

Meets with MIL P 23377 D type I requirements.

## SPECIFICATION DATA

**COATING TYPE :** Polyamino-amide Epoxy Primer

**COLOR :** Yellow / Green

**GLOSS :** Semi-gloss

**COMPONENT :** Two component

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**COMPONENT RATIO :**

- Weight : 100 Base / 58 Hardener

- Volume : 1 Base / 1 Hardener

**INDUCTION TIME (at 23°C) :** 20 minutes (approximately)

**POT LIFE (at 23°C) :** 8 hours

**THINNER :** EP N° 3

**DENSITY AT 23°C :** 1,2 +/- 0,05%

**VOLUME SOLIDS :** 53,3 % +/-3%

**VOC :** 556,5 g/l

**THEORETICAL SPREADING RATE :**

8,5 Sq.m/L at 40 dry microns

**RECOMMENDED FILM THICKNESS PER COAT :**

Dry : 15 microns

Wet : 45 microns

**RECOMMENDED TOTAL THICKNESS :**

Steel : 40 to 45 dry microns

Aluminium : 20 to 30 dry microns

**DRY TIME (at 23°C - 40 to 60 % HR) :**

Dustfree: 30 to 45 minutes

To handle: 4 hours

**DRY TIME TO RECOAT (at 23°C - 40 to 60 % HR) :**

Minimum : 4 to 72 hours

Maximum : 72 hours (after 72 h, sanding with scotch-brite® grade A)

**MAXIMUM TEMPERATURE RESISTANCE:** 120°C

## SURFACE PREPARATION

All surfaces must be free of oil, grease salt and moisture before abrasive blasting to near white metal standard shot blasting to SA 2.5 or SA 3. The minimum steel profile after blasting should be 14 microns deep and be of a jagged nature. Surfaces must be free of grit dust.

The mechanical stripping by steel brush (SA 1) is tolerated in some cases for spot finishing.

On aluminium or aluminium alloys: Perfect cleaning and degreasing of substrates, do a treatment by chemical conversion type ALODINE 1200 (CFPI) or using WASH PRIMER WP 110 . It is not possible to use both systems. If you use the WP 110 you can not use ALODINE 1200 and vice versa.

Or, WASH PRIMER WP 110 can be applied directly on aluminium after blasting and sandblasting.

AEROPRIM EP 140 can be recoated by MIXFILL, SPRAYBLES FILLER or fillers UNDERCOAT EP 213/215 HB, EP 228 HB, l'INTERFACE EPU 221 and lacquer TOPCOAT COLOR PU 320.

For all other types of coatings, consult our technical department.

## MIXING AND THINNING

Before mixing the components, mix carefully the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion, add the hardener slowly with continued agitation. After adding the hardener, continue to mix slowly.

After 20 minutes of induction time, it's possible to diluate from 0 to 25 % of EP N°3 (depends on application conditions or method).

You must check the viscosity with cup DIN or AFNOR.

Spray gun application : check the viscosity every 2 hours. Don't forget to mix after every dilution.

## APPLICATIONS

APPLICATION METHOD		THINNER	TIP SIZES	PRESSURE
BRUSH	YES (spot finishing)			
ROLLER	YES (spot finishing)			
SPRAY GUN	YES	5 to 30%	1,2 to 2	2 to 5 BARS
AIRLESS SPRAY	YES	0 to 5%	0,011 to 0,013 mm	100 to 200 BARS

Before application, filter the mixture with a 80 microns filter.

### CONDITIONS FOR APPLICATION :

Optimum : 20 to 25 °C for 50 to 70 % HR

Limit : 16 to 35°C for 30 to 80 % HR

**Do not apply below 15°C**

The substrate temperature must be at least 3°C above the dew point to avoid any condensation – consult the conversion table available at Map Yachting.

**VISCOSITY :** 14s to 15s Cup AFNOR N°4      45s to 55s Cup AFNOR n°2,5

## PRECAUTIONS AND SHELF LIFE

See the material safety data sheet and product label for complete safety and precaution requirements

**PACKAGING :** KIT of 2 or 10 Liters

**CLASS ONU :** 1992

**SHELF LIFE :** 12 months in original unopened cans at + 5 and + 35 °C away from humidity - 9 months in tropical climate

**FLASH POINT :** Base and Hardener : between 21°C and 5°C

**LABEL :** Base = T : Poison   N : Dangerous for the environment   Hardener = Xn : Harmful



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