

Aerodur Barrier Primer 37045

Technical Data Sheet

Product Group	Epoxy Primers
Characteristics  Product Information	Aerodur Barrier Primer 37045 is a chromate free 3-component isocyanate cured epoxy primer for composites and plastics. <ul style="list-style-type: none">- Compatible with a wide range of composites and plastics.- Low water permeability due to the absence of leachable, hygroscopic pigments.- Resistance to aircraft hydraulic fluids and chemicals.
Components  Curing Solution Thinner / Activator	Hardener S 66/14 (faster cure) Hardener S 66/22 R Thinner C 25/90 S
Specifications  Qualified Product List	Airbus AIMS 04.04.002/045/046 (not for black) British Aerospace BAEP 3529 / BAEP 3546 Fokker TH 33.0140 AVRO AVN 7-005 type 1 / AVP 3-003 Jetstream PS-23-8-35 / PS 23-8-36
	Above specifications are only applicable for the white color! For most recent up-date or missing specifications please check the qualified product list (QPL) on www.akzonobel.com/aerospace .
Surface Conditions  Cleaning	<ul style="list-style-type: none">- Remove release agents from the substrate carefully.- Depending on surface conditions use e.g. Scotch-Brite® type A very fine- Prior to painting clean with an appropriate cleaning solvent, such as degreaser C 3/41 not aggressive to the substrate.

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Instruction for Use



Mixing Ratio
(volume)

100 parts
50 parts

Aerodur Barrier Primer 37045
Hardener S 66/14 or S 66/22 R

Reduce to spraying viscosity with:
100 – 125 parts Thinner C 25/90S

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur Barrier Primer 37045 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener S 66/14 or S 66/22R 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 – 43 seconds ISO-Cup 3.

26 – 29 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)

6 hours for Hardener S 66/14.

8 hours for Hardener S 66/22 R.



Dry Film
Thickness
(DFT)

15 – 20 μm

0.6 – 0.8 mil.

Application Recommendations



Conditions

Temperature:

15 – 35°C

59 – 95°F

Relative Humidity:

35 – 75%

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Equipment

Air	1.4 mm nozzle orifice
HVLP	1.4 mm nozzle orifice
Air Electrostatic	1.2 mm nozzle orifice
Airless Electrostatic	6.11 – 6.13, (.011 - .013 inch) angle 60°



Number of Coats

Spray an even wet coat.



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)

Dry to tape	2 hours for S 66/14 4 hours for S 66/22 R
Recoatable minimum	2 hours for S 66/14 4 hours for S 66/22 R
Recoatable maximum	72 hours. If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.
Forced drying	30 minutes flash-off followed by 1 hour at 80°C or 2 hours at 60°C.



Theoretical Coverage

35 m² per liter base material at 15 µm dry film thickness
1423 ft² per US gallon base material at 0.6 mil dry film thickness

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Gloss (60°)

Maximum 25 GU.



Color

Off white
Black (not qualified)



Flash-point

Aerodur Barrier Primer 37045	<21°C / 70°F
Hardener S 66/14	>21°C / 70°F
Hardener S 66/22 R	>21°C / 70°F
Thinner C 25/90 S	<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

Shelf life
(21°C/70°F)

Aerodur Barrier Primer 37045	24 months
Hardener S 66/14	24 months
Hardener S 66/22 R	24 months
Thinner C 25/90 S	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.



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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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