



Product Group

Polyurethane Primers

Characteristics



Product
Information

Aerodur[®] Primer S 15/90 is a 3-component polyurethane primer for interior and exterior use:

- Compatible with Metaflex[®] washprimer series, chemical conversion coatings and anodized surface treatments.
- Resistance to aircraft hydraulic fluids and chemicals.
- Corrosion inhibiting.
- Meets the performance requirements of MIL-P-23377 type 1 and BMS 10-79 type 1.

Components



Hardener
Thinner or
Activator

Hardener S 66/14 (faster drying)

Hardener S 66/22 R

Thinner C 25/90 S (normal conditions, flashpoint <21°C)

Thinner 98064 (warm conditions, flashpoint >21°C)

Thinner 96184 (warm conditions, flashpoint <21°C)

Specifications



Qualified
Product List

Saab

STD 175417

Airbus Industries

TN A.007.10012

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

Surface Conditions



Cleaning

- Remove washprimer overspray with e.g. tack rags
- Primer Metaflex[®] washprimer series 2 – 8 hours after application.
- Prime chemical conversion coatings and anodized parts in a fresh condition.
- Clean and reactivate aged alodine film and sealed anodized surfaces with Metaflex[®] wash primer series (Depending on surface conditions use e.g. Scotch-Brite[®] type A very fine)
- Clean aged primer or epoxy / polyurethane finishes and sand with Scotch-Brite[®] type A very fine to a uniform and matt surface.
- Remove dust with e.g. tack rags.



Instruction for Use



Mixing Ratio
(volume)

100 parts Aerodur[®] Primer S 15/90
50 parts Hardener S 66/14 or S 66/22 R

Reduce to spraying viscosity with:

50 - 100 parts Thinner C 25/90 S, Thinner 98064 or Thinner 96184

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur[®] Primer S 15/90 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.
- For application on structural parts use approximately 50 parts thinner C25/90S, for aircraft exterior use approximately 100 parts thinner.
- For warm conditions (temperature >26°C) Thinner 98064 or 96184 are recommended.



Induction Time

15 – 30 minutes after mixing



Initial Spraying
Viscosity
(21°C/70°F)

24 – 32 seconds ISO-Cup 3.
23 – 26 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)

4 hours for Hardener S 66/14.
6 hours for Hardener S 66/22 R



Dry Film
Thickness
(DFT)

15 – 20 µm for exterior scheme; 20 – 30 µm for structural parts
0.6 – 0.8 mil for exterior scheme 0.8 – 1.2 mil for structural parts.

Application Recommendations



Conditions

Temperature: 15 – 35°C
59 – 95°F
Relative Humidity: 35 – 75%



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

Recoat minimum

2 hours for S 66/14
4 hours for S 66/22 R

Recoat 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.



Dry Film Weight

+/- 1.8 g/m²/μm
+/- 0.0094 lbs/ft²/mil



Theoretical Coverage

37 m² per liter base material at 15 μm dry film thickness
1484 ft² per US gallon base material at 0.6 mil dry film thickness



Gloss (60°)

Maximum 20 GU



Color

Yellow
Green BAC 452



Flash-point

Aerodur® Primer S 15/90	<21°C / 70°F
Hardener S 66/14	>21°C / 70°F
Hardener S 66/22 R	>21°C / 70°F
Thinner C 25/90S	<21°C / 70°F
Thinner 98064	>21°C / 70°F
Thinner 96184	<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.

Aerodur® Primer S 15/90	24 months
Hardener S 66/14	24 months
Hardener S 66/22 R	24 months
Thinner C 25/90S	36 months
Thinner 98064	36 months
Thinner 96184	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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