



Product Group

Epoxy Primers

Characteristics



Product
Information

Epoxy Primer 37076 is a 2 or 3-component epoxy primer designed for application on ferrous and non-ferrous metals

- Corrosion inhibiting, contains no lead or chromates
- Resistant to aircraft hydraulic fluids and chemicals.
- Can be used to replace chromated epoxy primers on chromic acid anodized aluminium.

Components



Hardener
Thinner or
Activator

Hardener 92133 (standard hardener)
Hardener 92161 (for two component systems)
Thinner 98064
Thinner C25/90S

Specifications



Qualified
Product List

Agusta	199-28-001 Type I, Class 1
AvCRAFT (Fairchild Dornier)	DON 460
BAE Systems(Regional Aircraft)	AVN 7-005 / AVP 3-003
Eurofigther	SP-J-513-A-0013 Type I, Class A

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

Surface Conditions



Cleaning

- Prime chemical conversion coatings and anodized parts in a fresh condition.
- 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
3 component
version
(volume)

100 parts Epoxy Primer 37076
50 parts Hardener 92133

Reduce to spraying viscosity with:

50 - 100 parts Thinner 98064 or Thinner C25/90S

- Allow products to acclimatize to room temperature before use
- Stir or shake Epoxy Primer 37076 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92133 and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.



Mixing Ratio
2 component
version
(volume)

100 parts Epoxy Primer 37076
70 Hardener 92161

- Allow products to acclimatize to room temperature before use
- Stir or shake Epoxy Primer 37076 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92161 and stir the catalyzed mixture thoroughly.



Induction Time

Not applicable, product can be used directly after mixing.



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

3 component version:
20 – 26 seconds ISO-Cup 4
17 – 21 seconds Zahn-Cup #2
2 component version:
31 – 38 seconds ISO Cup 4
21 – 25 seconds Zahn-Cup #2



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)

3 component version: 8 hours
2 component version: 2 hours



Dry Film
Thickness
(DFT)

15 – 30 micron (μm)
0.6 – 1.2 mils

Application Recommendations



Conditions

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



Note

Epoxy Primer 37076 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 / Air Assist 6.11 – 6.13, (.011 - .013 inch) angle 60°



Application
Scheme

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, 55%
RH)Set to touch
Dry hard15 minutes
90 minutesRecoat min.
Recoat max.4 hours
72 hours.
If a drying time of 72 hours is exceeded,
condition surface with e.g. Scotch-Brite®
type A very fine.Theoretical
Coverage35 m² per liter base at 15 µm dry film thickness
1404 ft² per US gallon base at 0.6 mil dry film thickness

Dry film weight

1.8 g/m²/µm
0.0094 lbs/ft²/mil

Gloss (60°)

10 – 45 GU



Color

White
Beige RAL1014
Tan FSB30257

Flash-point

Epoxy Primer 37076	>21°C / 70°F
Hardener 92133	>21°C / 70°F
Hardener 92161	>21°C / 70°F
Thinner 98064	>21°C / 70°F
Thinner C25/90S	<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 37076	24 months
Hardener 92133	24 months
Hardener 92161	24 months
Thinner 98064	36 months
Thinner C25/90S	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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