
Product Name:

Low VOC 2pk Epoxy Primer Surfacer

Product Number:

IP3-00015 Series

IP3-00015WHT: White

IP3-00015GRY: Grey

IP3-00015BLK-R1: Black

Product Description:

High solids low VOC primer-surfacer designed for application to composite and other surfaces. Use is similar to filler DTD5555 and DTD5580 where the filling and smoothing of a fine surface defect or profile is required. Designed for use in conjunction with a wide range of finishing systems including: BS2X34 A/B, air dry acrylic systems, Def Stan 80-161; Def Stan 80-227.

Approvals/Specifications:

- Def Standard 80-216
 - Dowty Propellers: PS-5618-9 (P999465) (IP3-00015BLK only)
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Performance:

High build primer-surfacer with excellent sanding properties for use post moulding of components as part of a spray applied coating system. Dries to a hard smooth finish that can be flatted with wet or dry abrasive paper to provide the required finish.

Suitable for over painting with epoxy systems such as Def Stan 80-161, PU systems such as BSX34 A/B and a variety of other twin pack or single part systems.

Typical uses are composite panels for airframe application such as helicopter, Hindustan DHRUV or more technical applications such as the air flow surface of propeller blades.

When used with a suitable primer and topcoat the coating forms part of an aerospace compatible anti-corrosive system.

Components:

Product: IP3-00015 Series

Catalyst: IP3 -CAT or IP3-CAT-S

Thinner: IP3-Reducer

Application:

Surface Preparation:	Ensure surfaces are clean and dust/grease free. Pre-primed or fresh composite surfaces should be lightly abraded and cleaned/degreased before coating.
Paint Preparation:	Mix 8 parts base to 1 part IP3-CAT by volume Mix 5 parts base to 1 part IP3-CAT-S by volume Induction time: 15 minutes at room temperature Mixed pot life: 4 hours with IP3-CAT: 1 hour with IP3-CAT-S IP3-Reducer may be added to a maximum 5% by volume
Application Method:	Designed for Spray application. May be brush or roller applied if required.
Drying Curing:	Touch dry: 2-3 hours (film thickness dependent) Hard Dry: 16 hours (IP3-CAT); 4-5 hours (CAT-S) Heat Curing: 20 minute flash off Cure; 25-45 minutes @ 125°C (250°F) component temperature (cure time variable with film thickness)

Technical Properties:

Supply Viscosity:	10 – 10.5 Poise @ 23 +/- 2°C
Flash Point:	≥22°C; ≤ 32°C
VOC Content:	Base 330 – 370 g/l Cat: 132 – 150 g/l
Colour:	Grey, Black, White
Pack Size:	5 litre
Density:	1.36 – 1.39kg/l
Volume Solids:	65% (mixed)
Gloss:	Matt Primer finish
Thinner:	IP3-Reducer
Solvent/Clean Up:	40006 Gun Cleaner
Catalyst:	IP3-CAT or IP3-CAT-S
Theoretical Coverage:	20 - 7 sq m per litre (30 – 90 microns dry)
Recommended Film:	30 – 90 microns dry film thickness

Technical Data Sheet



Storage:

Highly flammable liquid: store and use in accordance with the flammable liquid regulations

Shelf Life: 12 months temperate; 6 months tropical

Before use, refer to Product Safety Data Sheet

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Safety Data Sheets:

For Safety Data Sheets please contact our Sales Department:

Tel: +44(0)121 702 2485

Email: sales@indestructible.co.uk