
Product Name:

2 Pack Low VOC Epoxy Primer

Product Number:

- MPC-50015-R3-Grey
 - MPC-50015-R3-White
 - MPC-50015-R3-Black
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Product Description:

Low VOC primer-surfacers designed for application to composites. Used similarly to the filler in DTD 5555 and DTD 5580. For use in conjunction with a range of finishing systems including: BSX / BS2X33; BSX / BS2X34 and Def Stan 80-208 / 80-209

Available with standard cure and fast set up catalysts; the fast set up gives benefits in through cure in an air drying system.

Typically used as a post-mould primer-surfacer, but have been successfully tested as 'in-mould' primers in both aerospace and automotive applications.

Approvals/Specifications:

- Def Stan 80-216
 - Dowty Propellers: P999465
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Performance:

Designed for application both post mould and in-mould on carbon fibre and other composites. Dries to a hard smooth coating that is readily flatted with 260-320 grit wet or dry paper.

Suitable for over-coating with 2 pack epoxy systems to Def Stan 80-161 or 2 pack polyurethane systems to BSX / BS2X34

Typically used on composite airframe helicopters (Hindustan DHRUV); composite propeller blades and various aerospace composite applications.

Inclusion of 500 hours salt spray performance on aluminium over chromated primer.

Technical Data Sheet



Components:

Base:	MPC-50015-R3-Grey; MPC-50015-R3-White MPC-50015-R3-Black
Catalyst:	MPC-50001-R3
Thinner:	MPC-250-Thinner

Application:

Surface Preparation:	Ensure surfaces to be coated are clean and dust / dirt free Lightly sand as necessary. Pre-wipe with a proprietary cleaner / degreaser or IPA.
Paint Preparation:	Mix 8 parts base to 1 part MPC-50001-R3 catalyst by volume Induction time: 15 minutes Mixed Pot Life: 4 hours
Application Method:	Apply by spray: compliant spray gun recommended.
Drying Curing:	Air Dry: <ul style="list-style-type: none">- <i>Flash Off:</i> 2-3 hours- <i>Hard Dry:</i> 16 hours Heat Cure: <ul style="list-style-type: none">- <i>Flash Off:</i> 10 minutes- <i>Cure:</i> 25 minutes @ 125°C (250°F) component temperature

Technical Properties:

Supply Viscosity:	10.0-10.5 poise @ 23±2°C
Flash Point:	≥22≤32°C
VOC Content:	<i>Base:</i> 330-370gm / litre <i>Catalyst:</i> 132-150gm / litre
Colour:	Grey; White; black
Pack Size:	5 Litre
Density:	1.380 ± 0.015kg/l
Gloss:	Matt
Thinner:	MPC-250-Thinner

Technical Data Sheet



Solvent/Clean Up:	MPC-250-Thinner
Catalyst:	MPC-50001-R3
Theoretical Coverage:	12-15m ² / litre

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:

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