
Product Name: 2 Pack Low VOC Epoxy Primer-Surfacers

Product Number: IP3-00015 Series

Product Description: Low VOC primer-surfacers designed for application to composites. Used similarly to the filler in DTD 5555; and DTD5580. For use in conjunction with a range of finishing systems including: BSX / BS2X33; BSX / BS2X34 and Def Stan 80-208 / 80-209

Range available in three colours:

- IP3-00015WHT – White Matt
- IP3-00015GRY – Light Grey Matt
- IP3-00015BLK – Black Matt

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 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 (IP3-00015BLK)

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.

Components:

Normal Cure:

- IP3-00015
- IP3-CAT
- IP3-Reducer

Fast Cure:

- IP3-00015
 - IP3-FAST CAT
 - IP3 Reducer
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Application:

Surface Preparation:

Ensure surfaces to be coated are clean and dust/dirt free

Paint Preparation:

Mix 8 parts base to 1 parts IP3-CAT catalyst by volume

Mix 5 parts base to 1 part IP3-FAST CAT by volume

Induction time: 15 minutes

Mixed Pot Life: 4 hours with IP3-CAT; 1 hour with IP3-FASTCAT

Application Method:

Apply by spray: Compliant spray gun recommended

Drying Curing:

Air Dry:

- Flash off: 2-3 hours
- Hard dry: 16 hours (Std Cat); 4-5 hours (Fast Cat)

Heat Cure:

- 20 mins flash off
 - Cure: 25 mins @ 125°C (250°F) component temperature
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Technical Properties:

Supply Viscosity: 10.0-10.5 poise @ 23±2°C

Flash Point: ≥22°C≤32°C

VOC Content: Base: 330-370 gms / Litre
Cat: 132-150 gms / Litre

Colour: White; Light Grey; Black

Pack Size:	1 or 5 Litre
Density:	1.380 ± 0.015kg/l
Gloss:	Matt
Thinner:	IP3-Reducer
Solvent/Clean Up:	40006 or IP3-Reducer
Catalyst:	Normal Cure: IP3-CAT Fast Cure: IP3-FAST CAT
Theoretical Coverage:	12-15 sq.m / 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:

For Safety Data Sheets please contact our Sales Department:

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