



Epoxy Finish P2003

Product group	Epoxy Topcoats
Characteristics	Chemical resistant 2 component epoxy topcoat. Available in a full range of colours and gloss levels. Suitable for aerospace and defence equipment where epoxy finish is prescribed.
Hardener / Thinners	Hardeners P2004 and/or P2005 Thinner P2006
Specifications	Def Stan 80-161, DTD5555a, similar to Mil-C-22750
Surface condition	Apply over a suitably primed surface, primers such as BSX33 and Mil-P-23377 are typically used. Apply within the overcoat time specified for the primer. If the overcoat time is exceeded sand the primer to a matt finish using red non-woven abrasive pads or abrasive paper/discs \geq P320 grit.
Instructions for use	<p>- Mixing ratio (by volume)</p> <p>Usually 100 Parts Epoxy Finish P2003 50 Parts Hardener P2004 (for gloss finishes) 50 parts Hardener P2005 (for matt finishes)</p> <p>Read label of base material to verify mix ratio before use as certain colours and gloss levels may require a different ratio</p> <p>Thin to spraying viscosity with thinners T2006 (approx 10 parts)</p> <ul style="list-style-type: none">- Allow products to acclimatize to room temperature before use- Stir or shake Epoxy Finish P2003 till all pigment is uniformly dispersed before adding hardener.- Add hardener and stir the catalyzed mixture thoroughly.- Add thinner and stir again until a homogeneous mixture. <p>- Spraying Viscosity</p> <p>30-40 seconds ISO 5 35-45 seconds B4</p> <p>- Induction time</p> <p>15 Minutes</p> <p>- Potlife</p> <p>8 hours</p>



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| - Dry film thickness | 20-32 μ . |
| - Theoretical coverage | 16M ² per mixed litre @ 25 μ dft. |
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Application recommendations

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| - Conditions | Temperature 15 - 35°C |
| - Relative humidity | 35 - 75% |
| - Equipment | Apply by conventional, HVLP or airless spray. |
| - Number of coats | Apply one full cross-coat. |
| - Cleaning of equipment | Solvent Cleaning C 28/15 or Solvent Cleaning 98068. |
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Physical properties

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| - Drying time 20 \pm 2°C | Firm Dry | 4 hours |
| | Hard Dry | 8 hours |
| - Force drying | Flash off for 30 minutes then 2 hours at 60°C or 1 hour at 60-125°C | |
| - Colour (dry film) | Full range of RAL, BS, FS colours as required | |
| - Gloss | Available in full gloss, eggshell, semi-gloss and matt. Please specify gloss level with colour when ordering. | |
| - Flashpoint | 41°C | |
| - Storage (5 - 25°C) | Stored in the original unopened containers.
12 months | |
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Packing 5 litre containers

Safety precautions For full details consult the material safety data sheets prior to use (MSDS). Comply with all local safety, disposal and transportation regulations.



Warranty

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