Aerodur HS Primer 37092

Technical Data Sheet

<table>
<thead>
<tr>
<th>Product Group</th>
<th>Epoxy Primers</th>
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</table>

### Characteristics

- Aerodur HS Primer 37092 is a 2 component amine cured epoxy primer with improved adhesion properties for interior and exterior use.
- Adheres sealed and non-sealed anodized and alodined substrates.
- Resistance to aircraft hydraulic fluids and chemicals.
- Compatible with polyurethane, epoxy and acrylic topcoats.
- Corrosion inhibiting.
- High solid product, max. VOC 350 g/L.

### Components

- Hardener 92217.
- Do not add any thinner.

### Specifications

- Airbus: AIMS 04-04-001 / 003 / 004 / 038 / 040 / 041 / 042
- Bae Systems: AVN 7-003
- Bombardier / Canadair: BAMS 565-001 Grade B
- Hawker Beechcraft: BAEP 3527-4PSD5 REV 1
- MOD: BS2X33
- Bombardier/deHavilland: DHMS C4.01

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

### Surface Conditions

- Prime chemical conversion coatings and anodized parts in a fresh condition.
- When Aerodur HS Primer 37092 is applied on non-chemically pretreated aluminum, the substrate should be thoroughly cleaned and degreased with Solvent Cleaning C 28/15 (normal conditions) or Solvent Cleaning 98068 (warm conditions).
- Treat new aluminum with Scotch-Brite® type A very fine to a uniform matt surface.
- 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.
Aerodur HS Primer 37092

**Instruction for Use**

**Mixing Ratio**

<table>
<thead>
<tr>
<th>Volume</th>
<th>Aerodur HS Primer 37092</th>
<th>Hardener 92217</th>
</tr>
</thead>
<tbody>
<tr>
<td>100 parts</td>
<td>Aerodur HS Primer 37092</td>
<td>Hardener 92217</td>
</tr>
<tr>
<td>40 parts</td>
<td>Hardener 92217</td>
<td></td>
</tr>
</tbody>
</table>

- Allow products to acclimatize to room temperature before use
- Stir or shake Aerodur HS Primer 37092 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92217, and stir the catalyzed mixture thoroughly.

**Induction Time**

Not applicable. Product can be used directly after mixing.

**Initial Spraying Viscosity**

- 28 – 38 seconds ISO-Cup 4.
- 17 – 21 seconds Gardner Signature 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**

2 hours

**Dry Film Thickness**

- 20 – 30 µm
- 0.8 – 1.2 mil

**Note**

The application and mixing characteristics of High Solid products differ from conventional products. Mix base and hardener for at least 2 minutes thoroughly. The high solid content causes a rapid film build up.
## Aerodur HS Primer 37092

### Application Recommendations

<table>
<thead>
<tr>
<th>Conditions</th>
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</thead>
<tbody>
<tr>
<td>Temperature:</td>
<td>20 – 35°C</td>
</tr>
<tr>
<td></td>
<td>68 – 95°F</td>
</tr>
<tr>
<td>Relative Humidity:</td>
<td>35 – 75%</td>
</tr>
</tbody>
</table>

**Note**

Aerodur HS Primer 37092 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

<table>
<thead>
<tr>
<th>Equipment</th>
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<tbody>
<tr>
<td>Air</td>
<td>1.4 mm nozzle orifice</td>
</tr>
<tr>
<td>HVLP</td>
<td>1.4 mm nozzle orifice</td>
</tr>
<tr>
<td>Airless Electrostatic</td>
<td>6.11 – 6.13, (.011 - .013 inch) angle 60º</td>
</tr>
</tbody>
</table>

### Number of Coats

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.
## Aerodur HS Primer 37092

### Physical Properties

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<table>
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<tr>
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<tbody>
<tr>
<td><strong>Drying Times</strong></td>
<td></td>
</tr>
<tr>
<td>(25 +/- 2°C / 77 +/− 2°F, 55 +/- 5% RH)</td>
<td></td>
</tr>
<tr>
<td>Set to touch</td>
<td>1 hrs</td>
</tr>
<tr>
<td>Dry hard</td>
<td>2½ hrs</td>
</tr>
<tr>
<td>Recotatable minimum</td>
<td>2½ hrs</td>
</tr>
<tr>
<td>Recotatable maximum</td>
<td>48 hours*</td>
</tr>
</tbody>
</table>

*) If a drying time of 48 hours is exceeded, condition the surface with e.g. Scotch-Brite® type A very fine.

### Theoretical Coverage

- 40 m² per base material at 20 µm dry film thickness.
- 1600 ft² per US gallon base material at 0.8 mil dry film thickness.

### Dry Film Weight

- 1.8 g/m²/µm

### Gloss (60°)

- Maximum 20 GU

### Color

- Green/Yellow
- BAC 452

### Flash-point

- Aerodur HS Primer 37092 < 21°C / 70°F
- Hardener 92217 < 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

- Aerodur HS Primer 37092 24 months
- Hardener 92217 24 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.

Issue date: November 2017 (supersedes August 2017) - FOR PROFESSIONAL USE ONLY

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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