

Aerodur HS Primer 37092

Technical Data Sheet

Product Group

Epoxy Primers

Characteristics



Product
Information

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



Curing Solution
Thinner /
Activator

Base material	Aerodur HS Primer 37092
Curing Solution	Hardener 92217
.	
Do not add any thinner.	

Specifications



Qualified
Product List

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

Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products

Surface Conditions



Cleaning

- 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.

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Instruction for Use



Mixing Ratio
(volume)

100 parts
40 parts

Aerodur HS Primer 37092
Hardener 92217

- 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.
- The Hardener 92217 color can vary from pale yellow to red.



Induction Time

Not applicable. Product can be used directly after mixing.



Initial Spraying
Viscosity
(25°C/77°F)

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
(25°C/77°F)

2 hours



Dry Film
Thickness
(DFT)

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 to build up.

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Application Recommendations



Conditions

Temperature: 20 – 35°C
68 – 95°F

Relative Humidity: 35 – 75%



Note

Aerodur HS Primer 37092 may be applied in conditions outside of the 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

Air 1.4 mm nozzle orifice
HVLP 1.4 mm nozzle orifice
Airless Electrostatic 6.11 – 6.13, (.011 - .013 inch) angle 60°



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.

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Physical Properties



Drying Times
(25 +/- 2°C / 77
+/- 2°F, 55 +/- 5%
RH)

Set to touch
Dry hard
Recoat minimum

1 hrs
2½ hrs
20 minutes if overcoated with the Airbus
approved refresh primer, e.g. Aviox CF Primer
37124 or Aerodur HS 2121
2½ hrs for all other products
48 hours*.

Recoat maximum

*) 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 liter 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
Hardener 92217

< 21°C /70°F
< 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

Shelf life
(21°C/70°F and
55% RH)

Aerodur HS Primer 37092
Hardener 92217

24 months
24 months

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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.

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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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