

Technical Data

<u>Product Name</u>	PR 143
<u>Product Description</u>	PR 143 Epoxy Primer
<u>Key Features</u>	PR143 is a two-pack, ambient curing, epoxy primer developed for the internal and external protection of aircraft. The base component contains strontium chromate for long-term corrosion inhibition. Fully cured PR143 possess excellent resistance to aircraft fluids such as phosphate ester hydraulic oils and, combined with its superior water resistance and adhesion characteristics, offers a significant advantage over conventional epoxy primers.
<u>Specifications – Approval</u>	AVN 7-003 PPG - AFS 1806, PPG -AFS 1835, BS2X33B PPG-DTD900/6064 ABR 7-0133
<u>Specifications – Performance</u>	Meets the performance requirements of Mil-P-23377 type 1 and 2 (black)
<u>Catalyst/Hardener/Activator</u>	ACT143
<u>Thinner/Reducer</u>	T187 or T17
<u>Pack Size</u>	5 litre base, 2.5 hardener, 5 litre thinner
<u>Mix Ratio</u>	2:1:1
<u>Recommended Schemes</u>	Can be applied over chemically pre-treated surfaces, wash primer PR30B or over flatted / abraded painted surfaces

Product Application Parameters

Surface Preparation	Ensure correct surface pre-treatment has been carried out and that drying and overcoat times within the process are adhered to.								
Preparation	Ensure the surface is clean, dry, free of contaminants and that temperature and humidity are within acceptable limit.								
Mixing	Hand stir or mechanically shake the base material until all the pigment is uniformly dispersed. By volume add one part Activator 143 to two parts base and mix thoroughly before adding solvent T187 (approx 1 volume) to the recommended viscosity.								
Viscosity	<table> <tr> <td>BS B3</td> <td>26-30 seconds</td> </tr> <tr> <td>DIN 4</td> <td>13-14 seconds</td> </tr> <tr> <td>FORD 4</td> <td>15-17 seconds</td> </tr> <tr> <td>AFNOR 2.5</td> <td>45-55 seconds</td> </tr> </table>	BS B3	26-30 seconds	DIN 4	13-14 seconds	FORD 4	15-17 seconds	AFNOR 2.5	45-55 seconds
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FORD 4	15-17 seconds								
AFNOR 2.5	45-55 seconds								
Induction Time	None required								
Pot Life	8 hours								
Application Method	Apply one wet even cross-coat to achieve a dry film thickness 15 – 25µm								
Recommended Application Conditions	<table> <tr> <td>Temperature</td> <td>15 – 30°C</td> </tr> <tr> <td>Relative Humidity</td> <td>20 – 80%</td> </tr> </table>	Temperature	15 – 30°C	Relative Humidity	20 – 80%				
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Application Equipment

PR 143 is compatible with all types of spray equipment.

Equipment Type	Tip Size	Pressure (Bar)
Airmix	9 – 11 thou	50-60
HVLP Air Spray	1.2mm	1.5 - 2
Conventional	1.5mm	3 - 4
Airless	9 – 11 thou	4 - 6
Air-assisted Airless	609 – 611	50 - 60
Low Pressure Electrostatic	1.2 – 1.5mm	5-6

Equipment Cleaning Dry Film Thickness

CN20
15 – 25µm

Drying Times

	23°C	70°C	125°C
Dry to Handle	40 min		
Dry To Tape	4 hrs		
Dry To Mask	4 hrs		
Hard dry	6 hrs		
Re-coat with self	30 min		
Dry to Overcoat	4-48 hrs		
Full Cure	24 hrs	3 hours	1 hour

Flash-Off Time

15 minutes before force dry

Physical Characteristics

Colour	Yellow, green and black		
Gloss	N/A		
Coverage	12-16 m ² / litre @ 15-20µm		
Dry Film Density	1.72 yellow, black 2.2g/cm ³		
VOC Content (Ready for use)	675g/litre		
Flash Point	PR 143	23°C ACT 143	23°C
	T 187	30°C	
Shelf Life	24 Months. Once opened, ACT143 must be used within two months.		
Storage Conditions	5° to 35°C in the original unopened containers. Partly sealed containers must be re-sealed immediately after use.		

Health & Safety

This product is safe to use and apply when recommended precautions are observed. Before using this product it is important to read and understand the Material Safety Data Sheet. This provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. Material Safety Data Sheets are available on request.

All recommendations, statements and technical data contained herein are based on tests we reasonably believe to be reliable and correct, but the accuracy and completeness of such tests are not guaranteed and are not to be construed as a warranty, either express or implied. The User shall rely on its own information and tests to determine the suitability of any product for its intended use and the User agrees to assume all risks and liability arising in relation to its use of such product (other than death or injury resulting from our negligence) and accordingly we shall not assume any such risks or liability unless we specifically agree to the contrary in writing. If we specifically agree to assume any such risks or liability then (except for death or injury resulting from our negligence) our sole responsibility if any product supplied to the User by us is defective shall be to replace that portion of such product which is defective. Recommendations or statements other than those specifically agreed in writing by us shall not be legally binding on us.