

## TECHNICAL DATA

### EP-14-SERIES / EH-59 NON-STRIPPABLE AIRCRAFT COMPOSITE PRIMER

June 2011

#### PRODUCT DESCRIPTION

This two-component epoxy primer is intended for use on aircraft composite surfaces and is the base primer for Axon's SSS. It is designed to protect the composite structure and withstand methylene chloride-free paint strippers.

#### SURFACE PREPARATION

Optimum adhesion results when applied over a substrate activated with the proper scotch-brite pads and solvent cleaning. For aircraft composites, thoroughly clean the tool side with an accepted cleaning solvent and clean absorbent wiper before application.

#### MIXING / APPLICATION

After EP-14-G1 base component is thoroughly shaken such that there is no material left on the bottom or sides of the cans, mix 3 parts EP-14-G1 base with 1 part EH-59 catalyst by volume. Allow an induction period of approximately 30 min under constant agitation before application. A 10-15% reduction of the admixed primer with SR-350 (VOC compliant blend) is recommended for proper application and film thickness control. Apply a dry film thickness of 1.0 - 1.4 mil for optimum performance. Pot life is 6 hours at 75° +/- 5 °F. The primer will dry tack free in 30 - 45 minutes. Apply subsequent coatings no less than 1 hour and no longer than 12 hours after application for proper performance. For proper inter-coat adhesion, this product is not to be baked if subsequent coatings are to be applied.

#### PHYSICAL PROPERTIES

Appearance:		Light Gray
Admixed Viscosity:		21-28 sec. Zahn #2 (EZ)
Weight per Gallon:	A) Admixed	8.62 lbs/gal
	B) Base (EP-14-G1)	8.85 lbs/gal
	C) Hardener (EH-59)	7.89 lbs/gal
Volume Solids:	A) Admixed	50.44%
	B) Base (EP-14-G1)	51.75%
	C) Hardener (EH-59)	46.50%
Weight Solids:	A) Admixed	55.65%
Pot life:		6 hours at 75° +/- 5 °F
Coverage @ 1 mil (no loss):		800-850 sq. ft/gal
Fineness of grind:		4 Hegman
VOC Admixed:		<350 g/l
Dry Film Density:		5.93 lbs/1000ft <sup>2</sup> @ 1 mil

#### PRECAUTIONS

Use with adequate ventilation and proper respiratory protection. See MSDS for complete details of composition and precautions.