



### Product Group

Epoxy Primers

### Characteristics



Product Information

Epoxy Primer 37076 is a 2 or 3-component epoxy primer designed for application on ferrous and non-ferrous metals

- Corrosion inhibiting, contains no lead or chromates
- Resistant to aircraft hydraulic fluids and chemicals.
- Can be used to replace chromated epoxy primers on chromic acid anodized aluminium.

### Components



Hardener  
Thinner or  
Activator

Hardener 92133 (standard hardener)  
Hardener 92161 (for two component systems)  
Thinner 98064  
Thinner C25/90S

### Specifications



Qualified Product List

Leonardo Helicopters	BM210I0042
AvCRAFT (Fairchild Dornier)	DON 460
BAE Systems(Regional Aircraft)	AVN 7-005 / AVP 3-003
Eurofighter	SP-J-513-A-0013 Type I, Class A
Airbus	AIMS 04-04-002

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



Cleaning

- Prime chemical conversion coatings and anodized parts in a fresh condition.
- 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.

### Instruction for Use



Mixing Ratio  
3 component  
version  
(volume)

100 parts      Epoxy Primer 37076  
50 parts      Hardener 92133

Reduce to spraying viscosity with:

50 - 100 parts      Thinner 98064 or Thinner C25/90S

- Allow products to acclimatize to room temperature before use
- Stir or shake Epoxy Primer 37076 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92133 and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.



Mixing Ratio  
2 component  
version  
(volume)

100 parts      Epoxy Primer 37076  
70              Hardener 92161

- Allow products to acclimatize to room temperature before use
- Stir or shake Epoxy Primer 37076 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 92161 and stir the catalyzed mixture thoroughly.



	Induction Time	Not applicable, product can be used directly after mixing.
	Initial Spraying Viscosity (21°C/70°F)	<p><i>3 component version:</i> 20 – 26 seconds ISO-Cup 4 17 – 21 seconds Zahn-Cup #2</p> <p><i>2 component version:</i> 31 – 38 seconds ISO Cup 4 21 – 25 seconds Zahn-Cup #2</p>
	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 (21°C/70°F)	<p>3 component version: 8 hours 2 component version: 2 hours</p>
	Dry Film Thickness (DFT)	<p>15 – 30 micron (µm) 0.6 – 1.2 mils</p>

## Application Recommendations

	Conditions	<p>Temperature: 15 – 35°C 59 – 95°F</p> <p>Relative Humidity: 35 – 75%</p>
	Note	Epoxy Primer 37076 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	<p>Air 1.4 mm nozzle orifice HVLV 1.4 mm nozzle orifice Airless / Air Assist 6.11 – 6.13, (.011 - .013 inch) angle 60°</p>
	Application Scheme	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.

## Physical Properties



Drying Times  
(21°C/70°F, 55%  
RH)

Set to touch 15 minutes  
Dry hard 90 minutes

Recoat min. 4 hours  
Recoat max. 72 hours.

If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.



Theoretical Coverage

35 m<sup>2</sup> per liter base at 15 µm dry film thickness  
1404 ft<sup>2</sup> per US gallon base at 0.6 mil dry film thickness



Dry film weight

1.8 g/m<sup>2</sup>/µm  
0.0094 lbs/ft<sup>2</sup>/mil



Gloss (60°)

10 – 45 GU



Color

White  
Beige RAL1014  
Tan FSB30257



Flash-point

Epoxy Primer 37076 >21°C / 70°F  
Hardener 92133 >21°C / 70°F  
Hardener 92161 >21°C / 70°F  
Thinner 98064 >21°C / 70°F  
Thinner C25/90S <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.

Epoxy Primer 37076 24 months  
Hardener 92133 24 months  
Hardener 92161 24 months  
Thinner 98064 36 months  
Thinner C25/90S 36 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.

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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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