
Product Name:

2 Pack Low VOC Epoxy Primer

Product Number:

- MPC-50015-R3-Grey
 - MPC-50015-R3-White
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Product Description:

Low VOC primer-surfacers designed for application to composites. Used similarly to the filler in DTD 5555 and DTD 5580. For use in conjunction with a range of finishing systems including: BSX / BS2X33; BSX / BS2X34 and Def Stan 80-208 / 80-209

Available with standard cure and fast set up catalysts; the fast set up gives benefits in through cure in an air drying system.

Typically used as a post-mould primer-surfacer, but have been successfully tested as 'in-mould' primers in both aerospace and automotive applications.

Approvals/Specifications:

- Def Stan 80-216
 - Dowty Propellers: P999465
 - Meets the performance data requirements of MIL-P-23377
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Performance:

Designed for application both post mould and in-mould on carbon fibre and other composites. Dries to a hard smooth coating that is readily flatted with 260-320 grit wet or dry paper.

Suitable for over-coating with 2 pack epoxy systems to Def Stan 80-161 or 2 pack polyurethane systems to BSX / BS2X34

Typically used on composite airframe helicopters (Hindustan DHRUV); composite propeller blades and various aerospace composite applications.

Inclusion of 500 hours salt spray performance on aluminium over chromated primer.

Technical Data Sheet



Components:

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|------------------|---|
| Base: | MPC-50001-R3-Grey or MPC-50001-R3-White |
| Catalyst: | MPC-50001-R3 |
| Thinner: | MPC-250-Thinner |

Application:

Surface Preparation: Ensure surfaces to be coated are clean and dust / dirt free
Lightly sand as necessary. Pre-wipe with a proprietary cleaner / degreaser or IPA.

Paint Preparation: Mix 8 parts base to 1 part MPC-50001-R3 catalyst by volume
Induction time: 15 minutes
Mixed Pot Life: 4 hours

Application Method: Apply by spray: compliant spray gun recommended.

Drying Curing:

Air Dry:

- *Flash Off:* 2-3 hours
- *Hard Dry:* 16 hours

Heat Cure:

- *Flash Off:* 10 minutes
- *Cure:* 25 minutes @ 125°C (250°F) component temperature

Technical Properties:

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|--------------------------|--|
| Supply Viscosity: | 10.0-10.5 poise @ 23±2°C |
| Flash Point: | ≥22≤32°C |
| VOC Content: | <i>Base:</i> 330-370gm / litre <i>Catalyst:</i> 132-150gm / litre |
| Colour: | Grey; White |
| Pack Size: | 5 Litre |
| Density: | 1.380 ± 0.015kg/l |
| Gloss: | Matt |
| Thinner: | MPC-250-Thinner |
| Solvent/Clean Up: | MPC-250-Thinner |

Technical Data Sheet



Catalyst: MPC-50001-R3

Theoretical Coverage: 12-15m² / litre

Storage:

Highly flammable liquid: store and use in accordance with the flammable liquid regulations

Shelf Life: 12 months temperate; 6 months tropical

Before use, refer to Product Safety Data Sheet

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Safety Data Sheets:

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