

## 463-12-8 Interior Epoxy Primer

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|------------------------------------|---|---------------|---------------------|-------------------|------------|------------------------|-------------|
| <b>Product Group</b>               | Epoxy primer  |               |                     |                   |            |                        |             |
| <b>Characteristics</b>             | A chemically cured, two-component epoxy primer designed to provide maximum protection from various chemicals, hydraulic fluids, aviation fuels, phosphate ester (Skydrol) fluids and corrosion causing media.   |               |                     |                   |            |                        |             |
| <b>Hardener</b>                    | CA-116  |               |                     |                   |            |                        |             |
| <b>Specifications</b>              | Boeing Long Beach DMS 1786 Comp A<br>General Electric A50TF107-S5   |               |                     |                   |            |                        |             |
| <b>Instructions for Use</b>        |   |               |                     |                   |            |                        |             |
| Mixing ratio (by volume)           | <table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">Base 463-12-8</td> <td style="width: 50%;">1 part</td> </tr> <tr> <td>Hardener CA-116</td> <td>1 part</td> </tr> <tr> <td>Thinner TR-19 or TR-49</td> <td>0-0.25 part</td> </tr> </table> | Base 463-12-8 | 1 part              | Hardener CA-116   | 1 part     | Thinner TR-19 or TR-49 | 0-0.25 part |
| Base 463-12-8                      | 1 part  |               |                     |                   |            |                        |             |
| Hardener CA-116                    | 1 part  |               |                     |                   |            |                        |             |
| Thinner TR-19 or TR-49             | 0-0.25 part   |               |                     |                   |            |                        |             |
| Induction time                     | 30 minutes  |               |                     |                   |            |                        |             |
| Spraying viscosity                 | 25-35 seconds (#1 Zahn)   |               |                     |                   |            |                        |             |
| Potlife                            | 8 hours   |               |                     |                   |            |                        |             |
| Dry film thickness                 | 1.0-1.3 mils (25-33 microns)  |               |                     |                   |            |                        |             |
| <b>Application recommendations</b> |   |               |                     |                   |            |                        |             |
| Conditions                         | <table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">Temperature</td> <td style="width: 50%;">60°-85°F (15°-29°C)</td> </tr> <tr> <td>Relative Humidity</td> <td>35-75%</td> </tr> </table>  | Temperature   | 60°-85°F (15°-29°C) | Relative Humidity | 35-75%     |                        |             |
| Temperature                        | 60°-85°F (15°-29°C)   |               |                     |                   |            |                        |             |
| Relative Humidity                  | 35-75%  |               |                     |                   |            |                        |             |
| Equipment                          | Airless: Nozzle orifice<br>0.279 mm (0.011 inch) 60°<br>0.330 mm (0.013 inch) 80°<br>Air: Fluid tip 1.4 mm (0.055 inch)<br>Atomizing air pressure: 45-65 psi<br>Fluid pressure: 6-8 psi   |               |                     |                   |            |                        |             |
| Application                        | Spray a single wet crosscoat.   |               |                     |                   |            |                        |             |
| <b>Physical Properties</b>         |   |               |                     |                   |            |                        |             |
| Drying times                       | <table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">Dry to touch</td> <td style="width: 50%;">15 minutes</td> </tr> <tr> <td>Dry to recoat</td> <td>1-24 hours</td> </tr> </table>  | Dry to touch  | 15 minutes          | Dry to recoat     | 1-24 hours |                        |             |
| Dry to touch                       | 15 minutes  |               |                     |                   |            |                        |             |
| Dry to recoat                      | 1-24 hours  |               |                     |                   |            |                        |             |

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| Theoretical coverage                                 | 135-175 ft <sup>2</sup> /gal (3-4 m <sup>2</sup> /l) based on 50% transfer efficiency   |
| Gloss 60 Gardner                                     | 20 gloss units maximum  |
| Color  | DN 9295 Green   |
| Admixed VOC  | 5.4 lbs/gal (650 g/l)   |
| Packaging  | 2 quart and 2 gallon kits   |
| Storage<br>(closed container)<br>40°-100°F (5°-38°C) | Base 463-12-8                      2 years<br>Hardener CA-116                  2 years<br>Thinner TR-19 or TR-49        2 years |

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### **Precautions**

See Material Safety Data Sheet before use.