

**Product Group**

Epoxy Primers

**Characteristics**



Product Information

Aerodur® Barrier Primer 37045 is a chromate free 3-component isocyanate cured epoxy primer for composites and plastics.

- Compatible with a wide range of composites and plastics.
- Low water permeability due to the absence of leachable, hygroscopic pigments.
- Resistance to aircraft hydraulic fluids and chemicals.

**Components**



Hardener  
Thinner or  
Activator

Hardener S 66/14 (faster cure)  
Hardener S 66/22 R  
Thinner C 25/90 S

**Specifications**



Qualified  
Product List

Airbus	AIMS 04.04.002
British Aerospace	BAEP 3529 / BAEP 3546
Fokker	TH 33.0140
AVRO	AVN 7-005 type 1 / AVP 3-003
Jetstream	PS-23-8-35 / PS 23-8-36

For most recent up-date or missing specifications please check the qualified product list (QPL) on [www.anac.com](http://www.anac.com)

**Surface Conditions**



Cleaning

- Remove release agents from the substrate carefully.
- Depending on surface conditions use e.g. Scotch-Brite™ type A very fine
- Prior to painting clean with an appropriate cleaning solvent, such as degreaser C 3/41 not aggressive to the substrate.

**Instruction for Use**



Mixing Ratio  
(volume)

100 parts      Aerodur® Barrier Primer 37045  
50 parts        Hardener S 66/14 or S 66/22 R

Reduce to spraying viscosity with:

100 - 125 parts    Thinner C 25/90S

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur® Barrier Primer 37045 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener S 66/14 or S 66/22R and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.



Induction Time

15 – 30 minutes after mixing



Initial Spraying  
Viscosity  
(21°C/70°F)

33 – 43 seconds ISO-Cup 3.  
26 – 29 seconds Gardner Signature Zahn-Cup #1.



Potlife  
(21°C/70°F)

6 hours for Hardener S 66/14.  
8 hours for Hardener S 66/22 R



Dry Film  
Thickness  
(DFT)

15 – 20 μm  
0.6 – 0.8 mil.

### Application Recommendations



Conditions

Temperature: 15 – 35°C  
59 – 95°F  
Relative Humidity: 35 – 75%



Equipment

Air 1.4 mm nozzle orifice  
HVLP 1.4 mm nozzle orifice  
Air Electrostatic 1.2 mm nozzle orifice  
Airless Electrostatic 6.11 – 6.13, (.011 - .013 inch) angle 60°



Number of Coats

Spray an even wet coat



Cleaning of  
Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068



Note

The way of application, skills and experiences of the painter and surrounding conditions (temperature, relative humidity, airspeed) significantly affect the final appearance and dry film thickness. When using the product for the first time it is strongly recommended to apply some test panels first.

### Physical Properties








Drying Times  
(21°C/70°F)

Dry to tape 2 hours for S 66/14  
4 hours for S 66/22 R

Recoat minimum 2 hours for S 66/14  
4 hours for S 66/22 R

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

Forced drying 30 minutes flash-off followed by 1 hour at 80°C or 2 hours at 60°C.

	Theoretical Coverage	35 m <sup>2</sup> per liter base material at 15 µm dry film thickness 1423 ft <sup>2</sup> per US gallon base material at 0.6 mil dry film thickness	
	Gloss (60°)	Maximum 25 GU	
	Color	Off white Black RAL 1014	
	Flash-point	Aerodur® Barrier Primer 37045 Hardener S 66/14 Hardener S 66/22 R Thinner C 25/90 S	<21°C / 70°F >21°C / 70°F >21°C / 70°F <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.	
		Aerodur® Barrier Primer 37045 Hardener S 66/14 Hardener S 66/22 R Thinner C 25/90 S	24 months 12 months 24 months 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.

## FOR PROFESSIONAL USE ONLY

**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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Scotch-Brite is a trademark of 3M.

## Address

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