



Product Group

Wash Primers

Characteristics



Product
Information

Metaflex[®] FCR Primer is a 3-component filiform corrosion resistance washprimer which has been designed:

- As an alternative pretreatment to chemical conversion coatings.
 - For reactivation of aged anodized or chromated alloys and sealed anodized surfaces.
 - For strip ability of polyurethane systems with alkaline paint removers.
 - To provide adhesion of subsequent polyurethane or epoxy / isocyanate primers.
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Components



Hardener
Thinner or
Activator

Metaflex[®] FCR Hardener

Thinner C 25/90 S (normal conditions, flashpoint <21°C)

Thinner 96184 (warm conditions, flashpoint <21°C)

Thinner 98056 (for Aerospatiale)

Specifications



Qualified
Product List

Boeing
Airbus
FFV

BMS 10-72 type 5
AIMS 04.04.012 (TN 10.113)
FSD 7065

For most recent up-date or missing specifications please check the qualified product list (QPL) on www.akzonobel.com/aerospace

Surface Conditions



Cleaning

- Treat new and paint stripped aluminium with Scotch-Brite[®] type A very fine to a uniform matt surface.
 - Clean and degrease thoroughly with Solvent Cleaning C 28/15 (normal conditions) or Solvent Cleaning 98068 (warm conditions).
 - Treat previously polished substrates with acid type of brighteners first.
 - Metaflex[®] FCR Primer cannot be used in combination with freshly applied CCC, e.g. Alodine 1200.
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Instruction for Use



Mixing Ratio
(volume)






100 parts Metaflex[®] FCR Primer
200 parts Metaflex[®] FCR Hardener

Reduce to spraying viscosity with:






Max 25 parts Thinner C 25/90 S, Thinner 98056 or Thinner 96184

- Allow products to acclimatize to room temperature before use.
 - Stir or Shake Metaflex[®] FCR Primer till all pigment is uniformly dispersed before adding hardener.
 - Add Metaflex[®] FCR Hardener and stir the catalyzed mixture thoroughly.
 - If necessary, add maximum 25 parts thinner and stir again till a homogeneous mixture.
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	Induction Time	15 – 30 minutes after mixing
	Initial Spraying Viscosity (21°C/70°F)	56 – 65 seconds ISO-Cup 3. 33 – 34½ seconds Gardner Signature Zahn-Cup #1.
	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)	6 hours.
	Dry Film Thickness (DFT)	6 – 10 micron (µm) 0.25 – 0.4 mils

Application Recommendations

	Conditions	<p>Temperature: 15 – 35°C 59 – 95°F</p> <p>Relative Humidity: 35 – 75%</p>
	Equipment	<p>Air 1.4 mm nozzle orifice</p> <p>HVLP 1.4 mm nozzle orifice</p> <p>Air Electrostatic 1.2 mm nozzle orifice</p> <p>Airless Electrostatic 6.11 – 6.13, (.011 - .013 inch) angle 60°</p>
	Number of Coats	Spray an even wet cross coat or a cross coat directly followed by a single 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)	Dry to dust	15 minutes
		Recoat minimum	2 hours
		Recoat maximum	8 hours
	Theoretical Coverage	25 m ² per liter base material at 6 µm dry film thickness 1018 ft ² per US gallon base at 0.25 mil dry film thickness	
	Gloss (60°)	Matt	
	Color	Translucent brownish yellow	
	Flash-point	Metaflex® FCR Primer	<21°C / 70°F
		Metaflex® FCR Hardener	<21°C / 70°F
		Thinner C 25/90 S	<21°C / 70°F
		Thinner 96184	<21°C / 70°F
		Thinner 98056	>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.	
		Metaflex® FCR Primer	24 months
		Metaflex® FCR Hardener	24 months
		Thinner C 25/90 S	36 months
		Thinner 96184	36 months
		Thinner 98056	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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