

Eco-Prime™ EEAE154 Military Epoxy Primer

TECHNICAL DATA SHEET

Product Description

Eco-Prime™ EEAE154 military epoxy primer is a high solids coating. For use on aluminum and composite surfaces prior to top coating.

- Excellent adhesion and corrosion resistance
- Compatible with Desothane® HS topcoats
- Excellent fluid resistance
- Service temperature -54 °C to 177 °C (-65 °F to 350 °F)

Components



Mix ratio (by volume):

- EEAE154A (base component) 3 parts
- EEAC083B (activator component) 1 part

Specifications



EEAE154 epoxy primer is qualified to:

- MIL-PRF-23377 Type I Class C2

Note: PPG Aerospace recommends you check the most recent specification QPL for updated information.

Product Compatibility:

EEAE154 epoxy primer is compatible with the following topcoat specifications:

- DMS 2115
- MIL-DTL-53039
- MIL-DTL-65419
- MIL-PRF-22750
- MIL-PRF-85285 Type I & Type II
- MMS 420

Surface Preparation and Pretreatments



Eco-Prime™ EEAE154 high solids primer can be applied over clean, dry, intact aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.

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Instructions for Use



Mixing Instructions:

Prior to mixing, thoroughly shake the base component. Add the activator component to the base component and stir well. Maintain constant agitation for 10 minutes to ensure proper mixing.

Note: It is important to condition the paint for 24 hours prior to mixing by placing all materials in the shop or hangar, with ambient temperatures between 13 ° and 35 °C (55 ° to 95 °F). The minimum temperature of the paint components should be 13 °C (55 °F) prior to mixing.



Induction Time:

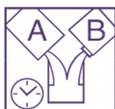
Temperature	13 - 21 °C (55 - 70 °F)	22 - 28 °C (71 - 84 °F)	>29 °C (>85 °F)
Induction Time Required	40 minutes	30 minutes	20 minutes



Viscosity: (23 °C/73 °F)

- #2 Signature Zahn cup 26 to 41 seconds
- #4 Ford cup 20 to 30 seconds
- ISO 4mm cup 40 to 68 seconds
- BSB3 cup 42 to 66 seconds
- BSB4 cup 23 to 35 seconds
- AFNOR #4 cup 22 to 34 seconds

Note: Viscosities quoted are the typical ranges obtained when using specified mix ratio.



Pot Life:

4 hours @ 21 - 25 °C (70 - 77 °F)



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Application Guidelines

Recommended Application conditions:

Temperature	15 - 30 °C (59 - 86 °F)
Relative Humidity	20 - 90%

Application:

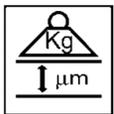
Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 12 to 23 microns (0.5 to 0.9 mils). This can be accomplished with one medium coat with a 50% overlap.

These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.



Theoretical Coverage:

23 square meters/liter at 25 microns dry film (950 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 12 to 23 microns (0.5 to 0.9 mils)



Dry Film Density:

1.76 grams/cubic centimeter (14.66 pounds/gallon)

Dry Film Weight:

44.0 grams/square meter at 25 microns dry film (0.0090 pounds/square feet at 1 mil dry film)

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Equipment:

EEAE154 primer is compatible with all current forms of spray equipment.

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
Electrostatic Air Spray Gun	1.2 mm or 1.5 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
Electrostatic Air Assisted Airless Spray Gun	#611 or #613 (Graco Nomenclature)	700 to 1200 psi (48 to 82 bar)	40 to 60 psi (2.8 to 4.1 bar)
High Volume Low Pressure Spray Gun (HVLP)	1.0 mm to 1.4 mm	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray Gun	1.2 mm to 1.8 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)

Equipment Cleaning:

Clean spray equipment as soon as possible after use. Flush spray equipment with DeSoto® CN20, DeSoto® CN44, or Desoclean™ 45 high performance solvent cleaner.

Physical Properties (product)



Color: Dark Green



Gloss: Not Applicable



Dry Times	13 - 21 °C (55 - 70 °F)	22 - 28 °C (71 - 84 °F)	>29 °C (>85 °F)
Tack Free	7 hours	5 hours	3 hours
Dry Through	10 hours	8 hours	6 hours
Dry to Topcoat	7 - 24 hours	5 - 24 hours	3 - 24 hours
Full Cure	14 days	14 days	14 days

Accelerated cure to dry hard:

Allow 15 minutes flash off at 24 °C ± 3 °C (75 °F ± 10 °F) followed by 60 minutes at 60 °C (140 °F)



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VOC (EPA method 24):

Mixed, ready for use VOC	340 grams/liter
Base Component	338 grams/liter
Activator Component	299 grams/liter



Flash point:

Base Component	26 °C (78 °F)
Activator Component	32 °C (89 °F)

Shelf Life:

12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

24 months from date of manufacture for PRC-DeSoto Standard.

Note: The coating shelf life is provided for original, unopened containers.

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Storage Recommendations



Inspect the condition of the container to ensure compliance. The material should be stored at temperatures between 5 °C to 35 °C (41 °F to 95 °F) to ensure shelf life.

Note: When procuring to a qualified material specification, follow those storage instructions.



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Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call the local PPG office at the numbers listed below:

Asia Pacific

ASC – Australia

Tel 61 (3) 9335 1557
Fax 61 (3) 9335 3490

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PRC-DeSoto International, Inc.

12780 San Fernando Road
Sylmar, CA 91342

www.ppgaerospace.com

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