

SEEVENAX[®] CF H/S Primer 113-44

Technical Datasheet 113-44

Characteristics



- Chromate free high solid epoxy primer especially developed for aircraft exterior applications
- Outstanding corrosion protection
- Excellent resistance to chemical and mechanical influences
- Complies with the aviation requirements regarding VOC (VOC value \leq 350 g/L / 2.9 lb/gal)

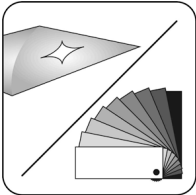
Range of Application



Qualified according to:

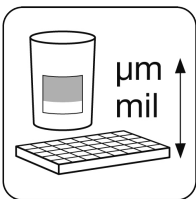
- AMS 3095
- AIMS 04.04.031 (Airbus)
- AIMS 04.04.032 (Airbus)
- AIMS 04.04.033 (Airbus)
- AIMS 04.04.037 (Airbus)
- BAMS 565-018 (Bombardier)
- DHMS C4.30 (de Havilland)
- AVN 7.004 (BAe)
- RPS13-97-15 Apd. A (Goodrich)

Color and Gloss



Color: ivory

Theoretical Coverage



Area	Quantity	Film thickness
27 m ²	1 L	20 µm
540 m ²	1 L	1 µm
880 ft ²	1 Gal	1 mil



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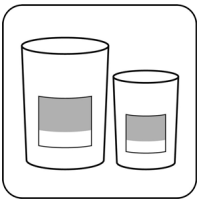
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Surface Pre-treatment



- **AMS 3095**
 - Aluminum surfaces
Conversion coatings e.g.
 - Bonderite M-CR 1200S,
 - SOCOGEL B0202,
 - SOCOGEL A0203 or
 - any pre-treatment in accordance with BMS10-128 Type 1 Grade A Class A/B
 - Non-metal surfaces (composites)
appropriately sanding and cleaning
- **AIMS 04.04.31 / -32 / -33 / -37**
Remove oil, grease and other contaminations. Subsequently, prepare aluminium substrates according to AIMS 04.04.001 and non-metal composites according to AIMS 04.04.002. Afterwards, sand and clean the surface with a solvent such as ALEXIT BC/CC Surface Cleaner 904-55. Remove dust with a tack rag.

Trade Names and Packaging



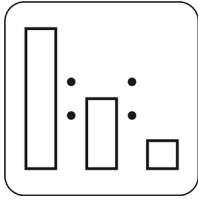
Material	Trade name	Container size [net]
Base material	SEEVENAX CF H/S Primer 113-44	5 L 1 US gal, 1 US quart
Hardener	SEEVENAX Hardener 135-44	2.5 L 1 US gal, 1 US quart
Thinner	SEEVENAX Thinner 902-44	1.25 L 1 US quart, 1 US pint
Thinner	SEEVENAX Thinner 902-66	2.5 L 1 US gal, 1 US quart



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Mixing



	Base	Hardener	Thinner
Trade name	SEEVENAX CF H/S Primer 113-44	SEEVENAX Hardener 135-44	SEEVENAX Thinner 902-44
By volume	2	1	0.5
Trade name	SEEVENAX CF H/S Primer 113-44	SEEVENAX Hardener 135-44	SEEVENAX Thinner 902-66
By volume	2	1	1

Prior to mixing shake or stir the base material to uniform consistency without any solid particles on the bottom of the container.

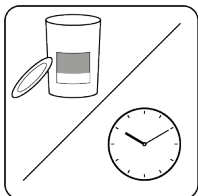
Recommendation

The use of SEEVENAX Thinner 902-66 is recommended if VOC regulations are specified according to ASTM D 3960 (allowance of exempt solvents)

SEEVENAX Thinner 902-44	VOC < 350 g/l (2.9 lb/gal)	acc. to ISO 11890-1 and ASTM D 3960
SEEVENAX Thinner 902-66	VOC < 350 g/l (2.9 lb/gal)	acc. to ASTM D 3960 (excluding exempt solvents)

Mix the three materials mentioned above in the proper mixing ratio and stir to uniform consistency. No induction time is required.

Pot Life



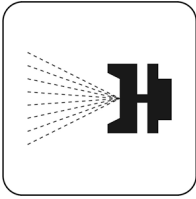
4 h at 23 °C / 73 °F / 50 % RH



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Application



	Compressed Air Spraying	Electrostatic Application	Air Assisted Airless Application
Spray Gun Type	Cup Gun	e.g. GRACO PRO XS 4 / XS 3	e.g. GRACO PRO XS 4 AA
Nozzle Size / Nozzle Type	1.2 - 1.6 mm	1.2 or 1.5 mm	509 / 511 / 609 / 611
Air Pressure/ Atomising Pressure	2 - 4 bar 30 - 60 psi	5 - 6 bar 75 - 90 psi	3 - 4 bar 45 - 60 psi
Air Cap		197 480 24A 438	
Material Flow		260 - 320 ml/min 9 - 10 oz/min	
Material Pressure			60 - 100 bar 850 - 1400 psi

Please observe the technical recommendations of the equipment manufacturers.

Flow time

Flow time of the ready-to-use-mixture at 23 °C / 73 °F / 50 % RH

ISO / 4 mm	23 - 40 s
ZAHN 2 SIG	14 - 20 s

Climatic conditions

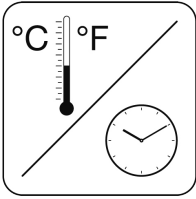
Object temperature	15 - 30 °C (60 - 85 °F)
Relative humidity	30 - 75 %

Equipment Cleaning

The equipment has to be cleaned thoroughly with an appropriate cleaner such as SEEVENAX Thinner 75 or methyl ethyl ketone (MEK) before and after use.



Drying



	23 °C / 73 °F / 50 % RH
Dust free	2 h
Dry to tape	6 h
Sandable	6 h
Recoatible	4 - 72 h
Fully cured	7 d

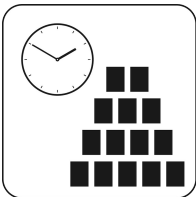
The temperature specified is the object temperature.

The drying behaviour of SEEVENAX CF H/S Primer 113-44 strongly depends on the object temperature.

Note:

The maximum recoating time of SEEVENAX CF H/S Primer 113-44 should not be exceeded. If it is exceeded, the surface has to be reactivated with 3M Scotch-Brite™ (fine grade) and cleaned with a suitable cleaning agent, such as ALEXIT BC/CC Surface Cleaner 904-55.

Shelf Life



Material	Shelf life
SEEVENAX CF H/S Primer 113-44	24 months
SEEVENAX Hardener 135-44	12 months
SEEVENAX Thinner 902-44	18 months
SEEVENAX Thinner 902-66	18 months

The storage data specified relates to unopened original containers.

Storage temperature: 5 - 35 °C / 40 - 100 °F



Additional Details



- **Dry film weight**
approx. 25 g/m² at 15 µm
approx. 1.65 g/m² at 1 µm
approx. 0,0086 lb/ft² at 1 mil
- **Dry film thickness**
15 - 30 µm
0.6 - 1.2 mil
- **Compatible coatings**
SEEVENAX Primer 113-82
SEEVENAX Primer 113-22
CELEROL Intermediate Coat 990-09
ALEXIT H/S BaseCoat 411-22
ALEXIT H/S TopCoat 411-77

For additional application information refer to the respective application recommendation or contact your local Mankiewicz support center.

The information contained in this document is based on our current state of research and development. Revisal by the user with regard to the intended purpose is necessary due to the variety of processing options and fields of application – please refer to the General Terms and Conditions of Sale.

