

Approvals and conformities

CFM INTERNATIONAL

CP 2724

SAFRAN AIRCRAFT ENGINES (formerly SNECMA)

DMP 16-030 / DMR 74-035 / 74-072

Description:

PCEH 100 V2 is a two-part water-based epoxy primer.

It is an anti-corrosion/ adhesion chromate free primer, overcoatable with polyurethane paints.

Benefits:

- Excellent resistance to water immersion.
- Good resistance to corrosion and cleaning agents.
- Good adhesion on several substrates.

USES

| Substrate | Preparation |
|-----------------|------------------------|
| Aluminium alloy | Anodisation |
| Steel | Sand blasting, sanding |
| Composites | Sand blasting, sanding |

Please, consult us regarding SOCOMORE solutions for:

- Surface preparation (SOCOCLEAN, DIESTONE & DS ranges),
- Functionalized coatings (SOCOGLAZE, AEROGLAZE, CHEMGLAZE, PRIAM, LBYH ranges),
- Surface treatment (SOCOCLEAN & SOCOSURF ranges),
- Adhesion promotion (SOCOGEL & PREKOTE ranges)
- Chemical stripping (SOCOSTRIP & SPC ranges).
- Non destructive testing products & services (BABBCO range)

socomore The Surface Company



DIRECTIONS FOR USE

Two Component Product

| Name | Pot-Life (hh:mm) |
|-----------------------|------------------|
| PCEH 100 PART B BEIGE | 03:00 |

Preparation & Application

During application, the following requirements must be adhered to:

- $15^{\circ}\text{C} < T^{\circ} < 35^{\circ}\text{C}$
- $30\% < \text{Hy} < 70\%$

| 1 - PNEUMATIC SPRAYING : Viscosity AFNOR 4 : 55 s +/- 15 | | Volume | Weight | Tol +/- |
|--|---------------------------------|--------|--------|---------|
| Base | PCEH 100 V2 BEIGE 1907 SAT P.A. | 30.3 | 47.6 | |
| Hardener | PCEH 100 PART B BEIGE | 27.2 | 52.4 | 1 |
| Adhesion promoter | LED 348 | 1 | 1.5 | 0.1 |
| Thinner | DL 1511 | 5.4 | 7.5 | 2.5 |

Table: Application method determines thinner ratio. Viscosity measurements provided are intended to be guidelines only and not parameters for quality control. Verified information is provided in certification documents, which are available from the technical department on request.

Mixing and viscosity measurements:

- Stir part A for at least 2 minutes.
- Stir part B for at least 2 minutes.
- Add the hardener (part B) into the base (part A) and mix for at least 2 minutes.
- Add 1.5% (in weight) of adhesion promoter to the A+B mixture, and mix for 1 minute.
- Add 7.5% (in weight) of thinner to the A+B+promoter mixture, and mix for 1 minute.
- Perform a viscosity measurement: CA4 Cup
- If the viscosity conforms to 40-70s for CA4 Cup, the product can be applied.
- If the viscosity does not conform, adjust the viscosity with an extra 2.5% thinner (max).
- If the viscosity now conforms to 40-70s for CA4 Cup, the product can be applied.
- Do not dilute more than 10%.

| AIR DRYING | |
|----------------|-----------------------------|
| Characteristic | Value |
| Dust dry | 01:30 h |
| Touch dry | 03:00 h |
| Hard dry | 12:00 h |
| Overcoating | Min: 03:00 h / Max: 72:00 h |

| FORCED DRYING | | |
|----------------|---------|---------|
| Characteristic | Value | Value |
| Flash off | 00:30 h | 00:30 h |
| Force dry | 02:00 h | 01:00 h |
| Temperature | 60°C | 80°C |

Recoat time and process:

- Recoat window: 3h to 72h.
- If cured at 60°C or 80°C: recoating is possible after cooling (up to 72h).
- After 72h:
 - Reactivate the surface using an abrasive paper (grade P220 to P320).
 - Remove the dust and clean the surface using an approved cleaning solvent.

- Apply a thin layer of primer.
- Dry the thin layer: 3h at room temperature or 1h at 60°C or 30 mins at 80°C.
- Apply the topcoat.

TECHNICAL CHARACTERISTICS

| Technical Data - Product Ready For Use | |
|--|-----------------------------|
| Characteristic | Value |
| Weight solids | 50% +/-3 |
| Volume solids | 37% +/-3 |
| Recommended wet film thickness | 68μ +/-10 |
| Recommended dry film thickness | 25μ +/-5 |
| Theoretical coverage | 90 g/m ² for 25μ |
| Shade | Beige 1907 |
| Appearance | Satin |
| VOC (g/L) Part A + Part B + thinner | 23 |

Data for mixture n°1

PRECAUTIONS FOR USE AND STORAGE

Storage

Can be stored for 12 months between 5°C and 35°C in original, unopened containers. Keep away from frost.

Shelf life after first opening:

- PART A: 3 months
- PART B: 3 months

For more information regarding the danger of the product, please consult the product safety data sheet according to local regulation.

For professional use only.

This technical data sheet replaces and cancels the previous one.

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as SOCOMORE deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Pictures are not contractual. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.