

Aerocron™ 2200 Anionic Epoxy Primer

TECHNICAL DATA SHEET

Product Description

Aerocron™ 2200 is an anionic epoxy electrocoat primer technology designed to provide optimal corrosion protection over aircraft substrates. It is a chrome-free, waterbased technology that is applied via an immersion process which uses electrical current to deposit the coating onto a conductive substrate.

The electrocoat process also provides advantages over spray technology with increased productivity, increased capture rate on parts, full automation capabilities, lower waste disposal costs, and uniform film thickness which results in an overall weight reduction.

- >95% Material Usage
- Total paint coverage on complex parts
- Easy mil thickness control
- Lower VOC
- Easy application in any environmental condition
- Waterbased technology
- No chrome or other heavy metals
- Full line automation (increased productivity)

Components



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- ACRS2200 (resin component)
- ACPP2220 (pigment paste for initial tank charge)
- ACPP2220R (optional pigment paste replenishment)
- ACCP2240 (anticorrosion paste)

Note: Please consult the Aerocron 2200 Process Control Document for blend ratio

Specifications



Aerocron 2200 Anodic epoxy primer is qualified to:

- AMS3144 Type I Class N

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

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Product Compatibility

Aerocron 2200 primer is compatible with the following topcoat specifications:

- MIL-PRF-85285 Type 1 Class H
- DMS2115
- BS2X34B
- MMS420
- AIMS 04-04-36
- BAMS 565-002

Note: If a topcoat is required, Aerocron 2200 has been tested and is compatible with most solventborne and waterborne primers and topcoats. Contact PPG Aerospace Coatings Platform regarding surface preparation prior to application of primer or topcoat.

Surface Preparation and Pretreatments



Aerocron 2200 primer can be applied over clean, properly prepared aluminum surfaces. Aluminum surfaces should be treated with an alkaline degreasing step followed by an acid deoxidization. Additional pretreatment processing steps, including materials conforming to MIL-DTL-5541 or equivalent can be utilized.

Contact the PPG Aerospace coatings platform team regarding procedures for surface preparation and subsequent pretreatment.

Instructions for Use



Mixing Instructions

For mixing instructions consult the Aerocron 2200 Process Control (manual).



Induction Time:

Not Required

Application Guidelines

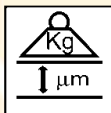
Consult the Aerocron 2200 Process Control Document for application guidelines.



Theoretical Coverage:

12.5 square meters/liter at 25 microns dry film (510 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 15 to 30 microns (0.6 to 1.2 mils)

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Dry Film Density:

1.28 grams/cubic centimeter (10.6 pounds/gallon)

Dry Film Weight:

32 grams/square meter at 25 microns dry film (0.007 pounds/square foot at 1 mil dry film)

Note: Value based on a bath composition of 20% solids and 0.2 p/b ratio

Physical Properties (product)



Color Gray



Gloss Medium / Not Controlled



Bake Condition

Minimum 60 minutes at 110°C (230°F) metal temperature

After thermal bake, parts are fully cured and can be handled without any dry-to-touch/-tape or -fly restrictions.

VOC

VOC – EPA Method 24 (minus water)

ACRS2200	265 grams/liter (2.21 lbs/gal)
ACPP2220	150 grams/liter (1.25 lbs/gal)
ACPP2220R	152 grams/liter (1.27 lbs/gal)
ACCP2240	310 grams/liter (2.58 lbs/gal)

Actual ready for use VOC (including water) **116 grams/liter (0.97 lbs/gal)**



Flash point closed cup:

ACRS2200	>93°C (>200°F)
ACPP2220/R	64°C (147°F)
ACCP2240	61°C (141°F)

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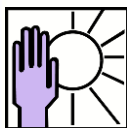
Shelf Life:

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

Note: 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 7-32°C (45-90°F) to ensure shelf life.

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

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.



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For industrial use only. Keep away from children.

Additional information can be found at: www.ppg.com/aerospace

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

Asia Pacific

ASC-Australia

Tel: 61 (3) 9335 1557

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ASC-Japan

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Fax : 81 569 24 8913

ASC-Singapore

Tel: 65 6861 1119

Fax: 65 6861 6162

ASC- Suzhou

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Fax: (86-512) 6661 6868

ASC-Tianjin

Tel: (86-022) 5882 1848

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Europe and Middle East

ASC – Central Europe

Tel 49 (40) 742 193 10

Fax 49 (40) 742 139 69

ASC – Middle East & India

Tel (971) 4 883 9666

Fax (971) 4 883 9665

ASC – North Europe

Tel 44 (0) 1388 770222

Fax 44 (0) 1388 770288

South Africa

Tel 27 (0) 11 389 4600

Fax 27 (0) 11 389 4755

ASC - South Europe

Tel 33 (0) 235 53 43 71

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Americas

1 (818) 362-6711 or 1-800-AEROMIX

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