technical data PR-2904

PR-2904 Primer for PR-2911

Description

PR-2904 is an aircraft fuel tank primer. It is a two-part, manganese dioxide cured polysulfide compound of spray consitency designed to promote adhesion between PR-2911 and common aircraft substrates. It has a service temperature range of -65°F (-54°C) to 250°F(121°C) with intermittent excursion up to 360°F(182°C). This material is designed for spray sealing of fasteners in fuel tanks and other aircraft fuselage sealing applications. It cures at room temperature to form a resilient sealant having excellent adhesion to common aircraft substrates. Once cured it maintains excellent elastomeric properties after prolonged exposure to both jet fuel and aviation gas.

The following tests are in accordance with PRC-DeSoto specification test methods.

Application properties (typical)

Color	
Part A	Black
Part B	Beige
Mixed	Dark Gray
Mixing ratio	Part A:Part B
By weight	9.3:100
Part A viscosity (Brookfield #7 @ 10 rpm), Poise (Pa-s)	800 (80)
Part B viscosity (Brookfield 2 @ 10 rpm), Poise (Pa-s)	15 (1.5)
Mixed viscosity (Brookfield #2 @ 10 rpm), Poise (Pa-s)	20 (2)

Application life and cure time @ 77°F (25°C), 50% RH

	Application life (hours)	Tack free time (hours)	Cure time to 30 A Durometer (days)
S-2	2	<24	3

Performance properties (typical)

Time to topcoat @ 77°F (25°C), 50% RH (hrs)	16
Film Thickness, min (mils)	20
Coverage, dry film thickness (ft^2/mil/gal)	960

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.

Surface preparation

Immediately before applying PR-2904 to substrates, the surfaces should be cleaned with solvents. Contaminants such as dirt, grease, and/or processing lubricants must be removed prior to primer application.

A progressive cleaning procedure should be employed using appropriate solvents, and a new lint free cloth conforming to AMS 3819. (reclaimed solvents or tissue paper should not be used). Always pour solvent on the cloth to avoid contaminating the solvent supply. Wash one small area at a time.

It is important that the surface is dried with a second clean cloth prior to the solvent evaporating to prevent the redeposition of contaminants on the substrate.

For a more thorough discussion of proper surface preparation, please consult the SAE Aerospace Information Report AIR 4069. This document is available through SAE, 400 Commonwealth Avenue, Warrendale, PA 15096-0001.

Mixing Instructions

PR-2904 is supplied in a two-part kit. Mix according to the ratios indicated in the application properties section. Mix Part A and Part B separately to uniformity, then thoroughly mix entire contents of both parts of the kit together taking care to avoid leaving unmixed areas around the sides or bottom of the mixing container.

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Application Instructions
For spray application, standard pressure pot, airless or air-assisted airless equipment may be used (check local EPA regulations regarding the use of spray equipment).

Apply PR-2904 Primer to a wet film thickness of 0.020 - 0.025 inch (0.51-0.64 mm) minimum, which will result in a dry film thickness of 0.015 inch (0.38mm). Allow to dry for 16 hours at 77°F (25°C) and 50% relative humidity. Lower or higher temperatures/relative humidity may require longer or shorter dry times respectively.

If PR-2904 Primer has been applied more than 48 hours before applying PR-2911, abrade surface and wipe with methyl ethyl ketone or other suitable solvent.

Packaging Options
PR-2904 is supplied in two part can kits. See container for mixing instructions.

Storage Life
The storage life of PR-2904 Primer is six months for Parts A and B when kept at temperatures below 80°F (27°C) in the original, unopened containers.

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

Safety precautions
WARNING: CONTAINS FLAMMABLE AND VOLATILE SOLVENTS
Keep away from heat, sparks, and flame. Proper safety precautions used with flammable material must be taken when applying this product. Comply with all local and safety regulations.

For industrial use only. Keep away from children.

For emergency medical information call 1-800-228-5635.

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

For sales and ordering information call 775-323-7542.

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