

Approvals and conformities

NPO SATURN	DMR 74-070
SAFRAN AIRCRAFT ENGINES (formerly SNECMA)	DMR 74-070 (PCE 215 grey Ral 7001 + LBY 216 yellow green 3389)
SAFRAN HELICOPTER ENGINES (formerly TURBOMECA)	LB 544 (PCE 215/ finishes LBY 216/ LRY 023), 6010 (PCE 215/ finishes LBY 216/ LRY 024), CTT 568 (PCE 215/ finishes LBY 216/ LRY 023)

Zinc chromate free two component anti-corrosion epoxy primer. PRIAM CE 215 can be used on reactor parts (crankcase, blades, OGV).

Benefits:

- Excellent adhesion on a wide variety of metal substrates.
- Excellent anti-corrosion properties.
- Aviation fluid resistant.

USES

PRIAM CE 215 is suitable for use on ferrous and non-ferrous metals.

Substrate	Preparation
Steel	Cleaning
Aluminium	Anodisation

Possible Schemes		
	1st scheme	2nd scheme
Substrate	Steel	Aluminium
Primer	PRIAM CE 215 GREY RAL 7001	PRIAM CE 215 GREY RAL 7001
Finish	LBY 216	LBY 216

Please, consult us regarding SOCOMORE solutions for:

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



DIRECTIONS FOR USE

Two Component Product

Name	Pot-Life (hh:mm)
PCE 215 PART B	08:00

Preparation & Application

During application, the following requirements must be adhered to:

- $15^{\circ}\text{C} < T^{\circ} < 35^{\circ}\text{C}$
- $20\% < \text{Hy} < 80\%$

1 - PNEUMATIC SPRAYING <i>Viscosity 25 s +/- 5 AFNOR 4</i>		Volume	Weight	Tol +/- %
Base	PRIAM CE 215 GREY RAL 7001	3.3	84	
Hardener	PCE 215 PART B	1	16	
Thinner	DL 162	1.7	25	10

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.

AIR DRYING	
Characteristic	Value
Dust dry	00:10 hour
Touch dry	00:30 hour
Hard dry	48:00 hours
Overcoating	12:00 hours

FORCED DRYING	
Characteristic	Value
Flash off	00:30 hour
Force dry	00:30 hour
Temperature	60°C

TECHNICAL CHARACTERISTICS

Technical Data - Product Ready For Use	
Characteristic	Value
Weight solids	51% +/-3
Volume solids	31% +/-3
Recommended wet film thickness	50 µm +/-15
Recommended dry film thickness	15 µm +/-5

Theoretical coverage	17 m ² /kg for 15 µm
Dry coating volumic ratio	
Shade	GREY RAL7001
Appearance	Satin-matt
Gloss	

Data for mixture n°1

Other Data		
Characteristic	Value	Note
Adhesion	Class 0	
SKYDROL resistance	24H (Hour)	Immersion at 20°C
Engine oil resistance	24H (Hour)	Immersion at 20°C
Kerosene resistance	24H (Hour)	Immersion at 20°C
Salt spray	500H (Hour)	at 50 µm minimum

PRECAUTIONS FOR USE AND STORAGE

Storage: 1 year between 5°C and 25°C in original, unopened packaging.

Shelf life after opening: 3 months.

For further information, please refer to the product safety data sheet.

This technical data sheet replaces and cancels the previous one.

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