## Characteristics

### Product Information
- 420 g/l polyurethane coating
- Intended for the protection of aircraft integral fuel tanks against corrosion from fuel contaminants
- Lead-free and EE-acetate free

## Components

### Curing Solution, Thinner/Reducer
- Curing Solution PC-235
- Thinner TR-117 (DMS 1850 only)

## Specifications

### Qualified Product List
- Boeing Long Beach: DMS 1850, Ty I, Comp B
- Bombardier/Canadair: BAMS 565-010, Gr B
- Bombardier/deHavilland: DHMS C4.06, Amend 1
- US Military/Naval: MIL-C-27725, Type II, Class A & B
- US Military/SAE: AMS-C-27725, Ty I

The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: [www.akzonobel.com/aerospace](http://www.akzonobel.com/aerospace)

## Surface Conditions

### Cleaning
- Surface pretreatment is an essential part of the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

## Instruction for Use

### Mixing Ratio

<table>
<thead>
<tr>
<th>Volume</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 parts</td>
<td>20P1-21 base</td>
</tr>
<tr>
<td>1 part</td>
<td>PC-235 curing solution</td>
</tr>
</tbody>
</table>

### By volume

<table>
<thead>
<tr>
<th>Volume</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 parts</td>
<td>20P1-21 base</td>
</tr>
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<td>1 part</td>
<td>PC-235 curing solution</td>
</tr>
</tbody>
</table>

### DMS 1850

<table>
<thead>
<tr>
<th>Volume</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 parts</td>
<td>20P1-21 base</td>
</tr>
<tr>
<td>1 part</td>
<td>PC-235 curing solution</td>
</tr>
<tr>
<td>0.5 part</td>
<td>TR-117 thinner</td>
</tr>
</tbody>
</table>

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.
Induction Time

15 minutes.

Initial Spraying Viscosity (25°C/77°F)

32 – 44 seconds 4 mm ISO Cup.
19 – 24 seconds #2 Signature Zahn Cup.
18 – 22 seconds # 4 Ford Cup.
13 – 18 seconds # 4 Ford Cup for DMS 1850 only

The uses of Ford and Zahn Cups for viscosity are requirements of the referenced specifications, and the ISO Cup measurement is provided only as a reference for field application. They are not provided as quality control values. Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.

Note

Pot Life (25°C/77°F)

4 hours.

Dry Film Thickness (DFT)

20 – 30 micron (μm)
0.8 – 1.2 mils

Application Recommendations

Conditions

Temperature: 15 – 35°C
59 – 95°F
Relative Humidity: 35 – 75%

Note

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Equipment

Conventional Air
HVLP
1.4 mm (.055 inch) nozzle orifice
1.4 mm (.055 inch) nozzle orifice
**Number of coats**

Spray apply one or two uniform wet coats to recommended dry film thickness.

**Cleaning of Equipment**

Use MEK or similar solvent.

## Physical Properties

### Drying Times

<table>
<thead>
<tr>
<th>Description</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tack free</td>
<td>3 hours max</td>
</tr>
<tr>
<td>Dry hard</td>
<td>12 hours max</td>
</tr>
<tr>
<td>Full cure</td>
<td>14 days</td>
</tr>
</tbody>
</table>

- The ambient cure schedule is affected by relative humidity. 14-day room temperature cure requires a minimum 50 % RH.

- The following accelerated cure schedule generally results in maximum chemical resistance properties for this coating: 24 hrs @ 25°C/77°F and 50% RH, followed by 24 hours at 60°C/140°F with 50% RH.

### Theoretical Coverage

<table>
<thead>
<tr>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>m²/m³</td>
<td>19.4 m²/liter</td>
</tr>
<tr>
<td>ft²/gal</td>
<td>791 ft²/gal</td>
</tr>
</tbody>
</table>

### Dry Film Weight

<table>
<thead>
<tr>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>g/m²</td>
<td>44.08 g/m²</td>
</tr>
<tr>
<td>lbs/ft²</td>
<td>.0090 lbs/ft²</td>
</tr>
</tbody>
</table>

### Volatile Organic Compounds

Max. 420 g/l
Max. 3.5 lb/gal

### Gloss (60°)

25 GU

### Color

Yellow

### Flash-point

<table>
<thead>
<tr>
<th>Code</th>
<th>Temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td>20P1-21</td>
<td>8°C / 46°F</td>
</tr>
<tr>
<td>PC-235</td>
<td>7°C / 45°F</td>
</tr>
<tr>
<td>TR-117</td>
<td>-13°C / 9°F</td>
</tr>
</tbody>
</table>
Storage

Store the product dry and at a temperature between 5 and 38°C / 40 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

24 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDSs are available on request.