



Product Group

Primer surfacer

Characteristics



Product
Information

- A chemically cured high build polyurethane surfacer designed for use as an intermediate primer with good filling properties and easy sanding characteristics.

Components



Curing Solution,
Thinner/Reducer

Curing Solution PC-232
TR-102 or TR-114 (optional)

Specifications



Qualified Product
List

American Airlines	P5-54
Cessna	CMFS039
Embraer	MEP 10-070
Lear Fan Corp.	LMS 5002A

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

Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process.

Instruction for Use



Mixing Ratio
(volume)

3 parts	Base 20P20-3
1 part	Curing Solution PC-232

OPTIONAL: Up to 1 part TR-102 or TR-114 may be added to improve flow.

One ounce of IM-253 may be added to one gallon kit for faster cure

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



	Induction Time	See Number of Coats below
	Initial Spraying Viscosity (25°C/77°F)	19-27 seconds Ford #4 (without thinner)
	Note	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.
	Pot Life (25°C/77°F)	4 hours (50 seconds max. Ford #4) Pot life will be shortened with the addition of IM-253, relative to ambient temperature and humidity.
	Dry Film Thickness (DFT)	38 – 76 microns (µm) 1.5 – 3 mils
Application Recommendations		Can be sprayed by siphon cup, pressure pot, HVLP, air-assist airless or airless equipment.
	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	Air 1.2 – 1.4 mm nozzle orifice HVLP 1.2 – 1.4 mm nozzle orifice
	Number of Coats	If ambient temperature is above 90°F (32°C), add 1 pint of TR-114 to every mixed gallon, to increase pot life and flow-ability. Apply one full wet coat (3 mils WFT) and flash 15 minutes. Apply second full wet coat (3 mils WFT). Wait 2 hours to sand or apply topcoat. Continuous coats can be applied until desired film thickness has been achieved. Do not bake this coating as solvent pop will appear.



Cleaning of
Equipment

Use TR-19 or MEK

Physical Properties



Drying Times
according to
AITM 2-0011
(25 +/- 2°C / 77
+/- 2°F, 55 +/- 5%
RH)

Dry to handle
Dry to sand
Dry to overcoat

1 hour
2 hours (depending on film thickness)
2 hours min, 24 hours max.



Note

Dry time will be shortened with the addition of IM-253, relative to ambient temperature and humidity.



Theoretical
Coverage

19.5 m² per liter ready to apply at 25 µm dry film thickness
795 ft² per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

51.5 g/m²/25 micron
.01 lbs/ft²/1 mil



Volatile Organic
Compounds

Max 420 g/l
Max 3.5 lb/gal



Gloss (60°)

10 – 20 GU



Color

Cream / Off White



Flash-point

20P20-3	- 4°C / 25°F
PC-232	16°C / 60°F
TR-102	7°C / 45°F
TR-114	34°C / 1°F
IM-253	43°C / 109°F



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.

Shelf life
5 - 38°C
(40 - 100°F)

24 months per AkzoNobel Aerospace Coatings commercial specification for 20P20-3, PC-232, TR-102, IM-253 and TR-114. 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.

Issue date: January 2010 (supersedes December 2009) - FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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