



Product Group

Epoxy topcoat

Characteristics



Product Information

- The 22/23 Series product is a chemically cured two-component epoxy topcoat designed to provide maximum protection from various chemicals, hydraulic fluids, aviation fuels, phosphate ester (Skydrol®) fluids and corrosion causing media. This high solids technology meets VOC requirements of SCAQMD Rule 1124.

Components



Curing Solution

Gloss Curing Solution X-530
Semi-gloss Curing Solution EC-263
Flat Curing Solution EC-264

Specifications



Qualified Product List

Boeing	BMS 10-11, Ty II, CI B, Gr D
EADS (CASA)	Z-12.361/BMS 10-11, Ty II, CI B
Goodrich	EMS 93284 C CI A (AiResearch Los Angeles Div.) (22 series / color specific)

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.
- Follow the specification requirements for cleaning and pretreatment application.

Instruction for Use








Mixing Ratio (volume)





	<u>Gloss</u>
3 parts	Base 446-22 Series
1 part	Curing Solution X-530
	<u>Semi-gloss</u>
1 part	Base 456-23 Series
1 part	Curing Solution EC-263
	<u>Flat</u>
1 part	Base 466-23 Series
1 part	Curing Solution EC-264

- 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)	17 – 35 seconds Zahn-Cup #2
	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.
	Dry Film Thickness (DFT)	25-37 microns (µm) 1.0-1.5 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	Airless .279 mm 0.011 inch 60° angle .330 mm 0.013 inch 80° angle Air Fluid tip 1.4 mm (0.055 inch) Atomizing air pressure 45-65 psi Fluid pressure 6-8 psi
	Number of coats	Spray a single wet coat. Allow a 15 minute solvent flash and apply a second wet coat.



Cleaning of Equipment

Use TR-19 for cleanup. This balanced thinner will minimize the possibility of residue remaining on the equipment.

Physical Properties



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

Dry to touch 3 hours
Dry to tape 7 hours



Theoretical Coverage

250-400 ft²/gal based on 50% transfer efficiency
6-10 m²/l based on 50% transfer efficiency



Dry Film Weight

3.5 lbs/gal (420 g/l) max. per US calculations



Volatile Organic Compounds

Max 420 g/l
Max 3.5 lb/gal per US calculations



Gloss (60°)

446-22 Series 90 gloss units minimum
456-23 Series 20–40 gloss units
466-23 Series 14 gloss units maximum



Color

As required



Flash-point

See MSDS for specific component flash-point.



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)

12 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.

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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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