



Product Group

Primer surfacer

Characteristics



Product
Information

- Chemically cured two-component epoxy filler putty
- Provides a durable smooth surface on composite and fiberglass substrates.
- Contains no chromates or lead bearing compounds.

Components



Curing Solution

CA-41B

Specifications



Qualified Product
List

Airbus UK	ABP 4-3135
AvCRAFT (Fairchild Dornier)	OS 00 CD2 007 004
BAE Systems (Regional Aircraft)	AVP 3-003
	BAEP 3527
	MAT 010
	PS 23-8-30
Boeing	DPM 5765
Cessna	CMFS010

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.
- Light abrasion of the composite or fiberglass surface is recommended to enhance surface reactivity to bonding. This also helps to promote good cleansing and increases the surface area available for bonding. Following abrasion, surfaces should be thoroughly cleaned or degreased with naphtha, minerals spirits, heptane, or other suitable solvent. Allow solvents from the cleansing method to completely evaporate before application of the filler putty.

Instruction for Use



Mixing Ratio
(Weight)

Parts by weight:
100.0 parts 467-9 / Base component
2.9 parts CA-41B / Curing Solution



Instruction for Use



Mixing Ratio
(Weight)
Continued

- Stir or shake base till all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly. The blue color ensures complete incorporation when a uniform colored mixture is obtained.



Induction Time

30 minutes



Pot Life
(25°C/77°F)

4 hours.



Dry Film
Thickness
(DFT)

127 – 203 microns (μm)
5 – 8 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 equipment chosen and the temperature, humidity, and air flow of the coating 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

Spread filler over substrate with a squeegee or putty knife.



Number of coats

Not applicable



Cleaning of
Equipment

MEK



Physical Properties



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

Dry to touch 2 hrs
Dry to sand 6 hrs

After a 15 minute flash, product may be force cured at 65°C (150°F) for 1 hour.

When using force cure schedule with composites, it is recommended that the composite be degassed prior to application of the filler putty.

	Theoretical Coverage	19.9 m ² per liter ready to apply at 25 µm dry film thickness 819 ft ² per US gallon ready to apply at 1 mil dry film thickness	
	Dry Film Weight	55.4 g/m ² at 25.4 microns .00114 lbs/ft ² at 1 mil	
	Volatile Organic Compounds	Max 428 g/l Max. 3.6 lb/gal	
	Gloss (60°)	10 maximum GU	
	Color	White	
	Flash-point	467-9 -5°C / 23°F CA-41B -5°C / 23°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. 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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