

TOPCOAT A1500-M

FINISHES FOR AIRCRAFT EXTERIORS

AkzoNobel

Product information



Three-component polyurethane topcoat with high chemical resistance for aircraft exterior. The topcoat has good UV resistance.

Components



Base A1500-M
Hardener / Catalyst A1500-M or FRS Hardener (textured application)
Thinner P2

Specifications



Qualified in accordance with:

Airbus Helicopters : ECS 2018, ECS 2149, ECS 2139, ECS 2460 and ECS 2230

Product information mentioned in the technical datasheet is given for information purposes and can differ from requirements of specifications above. In that case, customer requirements are valid for your application.

Physical properties



THEORETICAL COVERAGE

9 m²/kg for 40 µm (1.6 mils) dry (base and hardener undiluted)

DRY FILM WEIGHT

1.5

VOC

580 g/L (ISO 11890-1 and ASTM 3960)

COLOR

All colors references and color matching

SHELF LIFE / STORAGE

48 months for the base and the thinner, stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.
24 months for the hardener, stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

GLOSS LEVEL

>90 GU (gloss)/10 GU - 90 GU (semi-gloss)/3 GU - 10 GU (matt)/3 GU (extra matt)

NOTES

Gloss levels have been determined using glossmeter with an angle of incidence of 60°.

The theoretical consumption value doesn't take into account the transfer efficiency for spray application.

Surface preparation



Apply preferably on anticorrosion primer previously sanded with the orbital sander using abrasive paper grade 240 to 400. The substrate must be blown and then cleaned with a lint-free cloth wet with isopropyl alcohol.

All recommendations mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

Base
Hardener / Catalyst
Thinner

Mixing ratio by volume
1 V
1 V (for A1500-M Hardener)
0 V to 0.5 V

MIXING PROCEDURE

Ideally, the unmixed products should be stored between 18°C and 25°C (64°F and 77°F) for 24 hours before use.

The A1500-M base should be mixed for 10 minutes in a pneumatic or oscillating mixer before use.

Mix the base and hardener and possibly hardener until complete homogenization.

The mixture must be made at a temperature between 15°C and 35°C (59°F and 95°F).

Remark : It is recommended to sieve the paint through a 80-150 µm (3.1-6 mils) filter.

For a textured application, FRS Hardener has to be used with the following mixing ratios : 100%wt A1500-M Base + 28%Wt FRS Hardener.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

CA 4		CA 2.5	
White	Colors	White	Colors
14 to 20 s	14 to 20 s	50 to 60 s	40 to 50 s

POT LIFE

6 hours

NOTE

Semi-gloss and matt bases should be homogenized using a stirring device for homogeneisation them before adding the hardener.

The hardener must be incorporated in two steps (in case of matt and semi-gloss paints). The dilution rate depends on the shades and the rate of the gloss of the hue.

Viscosities mentioned above are corresponding to the recommended range of viscosity to ensure compliant application. The range of dilution must be used to adjust viscosity to reach the recommended one.

CA 4 cup is the reference cup. The others are given for information purposes.

Instructions for use



BRUSH APPLICATION

Base
Hardener / Catalyst

Mixing ratio by volume
2 V
1 V

NOTE

For an application with a brush, use preferably hardener A1000 BRUSH, specific to this application.

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Application recommendations



CONDITIONS

Temperature 15°C (59°F) to 35°C (95°F)
Relative humidity 30 % to 75 %

EQUIPMENT

Gravity compressed air gun Nozzle 1.5 mm to 1.8 mm

DRY / WET FILM THICKNESS

20 µm to 100 µm (0.8 mils to 4 mils) dry (according to shades)

NUMBER OF COATS

Apply one crossed coat, let it dry for 20 minutes to 1h30 until flash off. Then apply one or more crossed coats well wet to get 20 µm to 100 µm (0.8 to 4 mils) dry thickness.

For a textured application, recommended Dynamic Air Pressure is between 0.04 to 0.05 bars.

EQUIPMENT CLEANING

Clean equipment with polyurethane paint cleaning solvent.

NOTE

Spray with dry, oil-free air.

Drying times



Recoatable Fully Cured

23°C (73°F)
2 hours to 72 hours
7 days

60°C (140°F)
1 hour to 8 hours
12 hours

NOTE

Drying times have been determined using tests pieces of a thickness < 2mm for 60µm (2.4mils) of dry film.

*N.A. : Not applicable

Defects & corrections



In the event of a defect, contact your Quality Department.

Health & Safety



See the product Safety Data Sheet.

The MSDS are available through our website www.mapaero.com

Packing



The base A1500-M is available in 1 L and 5 L.
The A1500-M hardener is available in 1 L and 5 L.
The thinner P2 is available in 1 L and 5 L.

WARRANTY : We guarantee our products against hidden defaults over material and preparation. Our Responsibility is limited to the obligation of freely replacing the defective material without there being a claim for any compensation. The advice we give is based on our experience but it might not be absolutely right. Consequently this does not imply our responsibility in case of inefficiency. Furthermore our company cannot be responsible for any material or corporal damages caused due to a misuse or mishandling of our products. Any concession to these clauses, to be valid, must be an official document issued by our offices and signed by our direction.