Aerodur® Finish SGL Aluminium

Product Group

Polyurethane Topcoats

Characteristics

Product Information

Aerodur® Finish SGL Aluminium is a universal 3-component polyurethane finish for interior and exterior use.

- Resistance to staining
- Resistant to aircraft hydraulic fluids and chemicals
- Well balanced pot life / drying characteristics

Components

Hardener Thinner or Activator

Hardener S 66/22 R
Thinner C 25/90 S (normal conditions, flashpoint <21ºC)
Thinner 98064 (warm conditions, flashpoint >21ºC)

Specifications

Qualified Product List

Fokker	TH 33.0150
BAe	S 26.3529

For most recent up-date or missing specifications please check the qualified product list (QPL) on **www.akzonobel.com/aerospace**

Surface Conditions

Cleaning

- Observe the recoatability limits of the relevant primer.
- Remove oil, grease and other contaminants prior to application of the finish.
- Recondition aged primers or topcoats with e.g. Scotch-Brite® type A very fine till a uniform matt surface.
- Remove dust with e.g. tack rags prior to application of the finish.

Instruction for Use

Mixing Ratio (volume)

100 parts	Aerodur® Finish SGL Aluminium
100 parts	Hardener S 66/22 R

Reduce to spraying viscosity with:

50 – 75 parts	Thinner C 25/90S or Thinner 98064

- Allow products to acclimatize to room temperature before use
- Stir or shake Aerodur® Finish SGL Aluminium till all pigment is uniformly dispersed before adding hardener.
- Add Hardener S 66/22 R and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.

Induction Time

15 – 30 minutes after mixing

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Internet: www.akzonobel.com/aerospace

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Initial Spraying Viscosity (21ºC/70ºF)	36 – 40 seconds ISO-Cup 3 27 – 28 seconds Gardner Signature Zahn-Cup #1.
Pot Life (21ºC/70ºF)	6 hours.
Dry Film Thickness (DFT)	30 – 40 micron (µm) 1.2 – 1.6 mils

Application Recommendations

Conditions

Temperature:	15 – 35ºC 59 – 95ºF
Relative Humidity:	35 – 75%

Equipment

Air	1.4 mm nozzle orifice
HVLP	1.4 mm nozzle orifice
Air Electrostatic	1.2 mm nozzle orifice
Airless Electrostatic	6.11 – 6.13, (.011 - .013 inch) angle 60º

Number of Coats

Apply an even and uniform coat of Aerodur® Finish SGL Aluminium followed after 30 – 60 minutes solvent flash-off time by a cross coat.

Note

To obtain an even and uniform appearance dilute the admixed pain with an extra 100% Thinner. Apply after 30 – 60 minutes a mist coat by using a cup gun or pressure pot spray gun.

Cleaning of Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068

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.

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Physical Properties

Drying Times (21ºC/70ºF)

Dust free	2 – 3 hours
Dry to tape	6 – 8 hours
Recoatable minimum	6 hours for decoration colors
Recoatable maximum	72 hours If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.
Forced drying	30 minutes flash-off followed by 1 hour at 80ºC, 2 hours at 60ºC or 4 hours at 50ºC

Theoretical Coverage

24 m^2 per liter base material at 30 µm dry film thickness
963 ft^2 per US gallon base material at 1.2 mil dry film thickness

Gloss (60º)

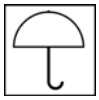
15 – 70 GU
For permanent high gloss an additional cross-coat of Aerodur® Clearcoat UVR can be applied.

Color

Aluminium.

Flash-point

Aerodur® Finish SGL Aluminium	>21ºC / 70ºF
Hardener S 66/22 R	>21ºC / 70ºF
Thinner C 25/90 S	<21ºC / 70ºF
Thinner 98064	>21ºC / 70ºF



Storage

Store the product dry and at a temperature between 5 and 25ºC / 41 and 77ºF. Stored in the original unopened containers.

Aerodur® Finish SGL Aluminium	12 months
Hardener S 66/22 R	24 months
Thinner C 25/90 S	36 months
Thinner 98064	36 months

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 MSDS's are available on request.

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