



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 <21°C)

Thinner 98064 (warm conditions, flashpoint >21°C)

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



Initial Spraying
Viscosity
(21°C/70°F)

36 – 40 seconds ISO-Cup 3
27 – 28 seconds Gardner Signature Zahn-Cup #1.



Pot Life
(21°C/70°F)

6 hours.



Dry Film
Thickness
(DFT)

30 – 40 micron (µm)
1.2 – 1.6 mils

Application Recommendations



Conditions

Temperature: 15 – 35°C
59 – 95°F
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 60°



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.



Physical Properties



Drying Times
(21°C/70°F)

Dust free
Dry to tape
Recoat minimum
Recoat maximum

2 – 3 hours
6 – 8 hours
6 hours for decoration colors
72 hours
If a drying time of 72 hours is exceeded,
condition surface with e.g. Scotch-Brite® type A
very fine.
30 minutes flash-off followed by 1 hour at 80°C,
2 hours at 60°C or 4 hours at 50°C

Forced drying



Theoretical
Coverage

24 m² per liter base material at 30 µm dry film thickness
963 ft² per US gallon base material at 1.2 mil dry film thickness



Gloss (60°)

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	>21°C / 70°F
Hardener S 66/22 R	>21°C / 70°F
Thinner C 25/90 S	<21°C / 70°F
Thinner 98064	>21°C / 70°F



Storage

Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F.
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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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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