

PG-21 SERIES / PH-63

HIGH-HIDE, AIRCRAFT PART INTERIOR POLYURETHANE TOPCOAT

December 2022

Technical Data

Product Description

This polyurethane gloss topcoat is designed for use on aircraft interior parts and equipment. Fully cured films have skydrol resistance and result in a hard mar resistant coating. Additionally, the PG-21 series exhibits excellent sag resistance and hiding at low dry film thickness. Depending on color, a .95% contrast ratio can be achieved at thickness between 0.5 to 1.5 mils.

Meets or Exceeds the Performance Requirements of the Following Specification

BAMS 565-002, **Rev. E** Grade B, Class 20 and Class 33, A2MS 565-002, **Rev. A**, Grade B, Class 20.

Surface Preparation

To be applied over BAMS 565-001 Epoxy primer.

Mixing / Application

Shake or stir color base component well. To one part PG-21 series base, slowly add one part PH-63 hardener by volume. This mixing order must be followed to obtain best results. Agitate to insure complete mixing. Allow to stand for 15 minutes prior to application. Pot life is four hours. Spray apply in wet uniform coats to a dry film thickness of 0.5 to 1.5 mils using siphon cups, pressure pot, electrostatic or HVLP spray equipment. Adding up to 6% of SR-12 reducer will improve flow and aid in thickness control. Coating will dry to touch in 2-3 hours and dry to tape in 7-8 hours at 77°F. Full properties are achieved after seven days cure. Paint films can be fully forced cured by exposing them to 160° F for 6 to 8 hours after a flash off time of 1 hour at room temperature.

Physical Properties

Appearance:	Gloss, various colors
Gloss:	85 + @ 60 degrees
Admixed Solids by Weight:	57.8 +/- 2 degrees
Admixed Solids by Volume:	42.8 +/- 2 degrees
Coverage:	650-750 sq. Ft /mil/gal @ 100% transfer depending on color
Admixed Viscosity:	16-21" Ford #4 / 22-27" EZ Zahn Cup #2
Pot Life:	4 hours @ 77 °F, Less If accelerate
Dry to Tape:	7-8 @ 77 °F, 50% R.H. Can be accelerated by the use of AX-10 or AX-17 Accelerator.
Shelf Life:	2 years from date of manufacture
Storage Temperature:	40-95 °F (4-35 °C)
VOC:	Varies, depending on color, all colors are VOC compliant; PG-21-W1/PH-63 = 384 grams/liter admixed
Admixed Weight per Gal:	10.42 +/- 0.2 lbs. /gal
Dry Film Density:	Varies, depending on color: PG-21-W1 / PH-63 (FS17875) = 8.70 pounds/ 1000 SQ FT· MIL

Precautions

Use with adequate ventilation and proper respiratory protection. See MSDS for complete details of composition and precautions.

