

21 Series

High Solids Epoxy Topcoat

Technical Data Sheet

Product Group

Epoxy topcoat

Characteristics



Product
Information

- This chemically cured two-component topcoat is designed to provide maximum protection from various chemicals, hydraulic fluids, aviation fuels, phosphate ester (Skydrol®) fluids and corrosion causing media. This high solids technology meets the VOC requirements of SCAQMD Rule 1124 and is available in gloss, semi-gloss and flat finishes.

Components



Curing Solution

Gloss Curing Solution X-530
Semi-gloss Curing Solution X-462
Flat Curing Solution X-541

Specifications



Qualified
Product List

Air France	SMI 70 084-1
Allied Signal Aerospace	EMS 93284 C CI A (AiResearch Los Angeles Div.) (color specific)
Boeing Long Beach	DMS 2433, Type I, Comp C

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

Surface Conditions









Cleaning

- Surface pretreatment is an essential part of the painting process
- Apply only over fresh or reactivated primer surfaces. Review recommended primer products for substrate to be coated.

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Instruction for Use

	<p>Mixing Ratio (volume)</p>	<p>3 parts 1 part</p>	<p><u>Gloss</u> Base 446-21 Series Curing Solution X-530</p>
		<p>3 parts 1 part</p>	<p><u>Semi-gloss</u> Base 456-21 Series Curing Solution X-462</p>
		<p>3 parts 1 part</p>	<p><u>Flat</u> Base 466-21 Series Curing Solution X-541</p>
<ul style="list-style-type: none"> - Stir or Shake until all pigment is uniformly dispersed before adding curing solution. - Stir the catalyzed mixture thoroughly. 			
	<p>Induction Time</p>	<p>15 minutes</p>	
	<p>Initial Spraying Viscosity (25°C/77°F)</p>	<p>17 □ 30 seconds Zahn-Cup #2</p>	
	<p>Note</p>	<p>Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.</p>	
	<p>Pot life (25°C/77°F)</p>	<p>4 hours</p>	
	<p>Dry Film Thickness (DFT)</p>	<p>1.0-1.5 mils 25-37 microns</p>	

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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 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.



Equipment

Airless, air assisted airless, conventional spray or HVLP spray



Number of
Coats

Spray a single wet coat. Allow 15 minute solvent flash and apply a second wet coat.









Cleaning of
Equipment

MEK or TR-19

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Physical Properties

	Drying Times (25 +/- 2°C / 77 +/- 2°F, 55 +/- 5% RH)	Tack free Dry through	4 hours 9 hours
	Theoretical Coverage	250-400 ft ² /gal based on 50% transfer efficiency 6-10 m ² /l based on 50% transfer efficiency Varies with color	
	Dry Film Weight	Gloss	44.5 g/m ² /25.4 micron 0.0091/lbs/ft ² /1.0 mil
		Semi gloss	47.6 g/m ² /25.4 micron 0.0098/lbs/ft ² /1.0 mil
		Flat	46.8 g/m ² /25.4 micron 0.0096/lbs/ft ² /1.0 mil
	Volatile Organic Compounds	Max 420 g/l (per US Calculations) Max 3.5 lb/gal	
	Gloss (60°)	446-21 Series	90 gloss units minimum
		456-21 Series	15-30 gloss units
		466-21 Series	6 gloss units maximum
	Color	As required	

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Flash-point

446-21	-4°C / 25°F
456-21	-4°C / 25°F
466-21	-4°C / 25°F
X-530	7°C / 45°F
X-462	7°C / 45°F
X-541	7°C / 45°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)

12 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 MSDS's are available on request.

Issue date: January 2015 (supersedes July 2009) - FOR PROFESSIONAL USE ONLY

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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