

FINISH F 69

1- DESCRIPTION: Chromate free semi gloss water based epoxydic topcoat. This product offers an efficient anticorrosive protection and is designed for touch up on aircraft structures. Available in grey, green and blue colours.

2- SPECIFICATIONS: Airbus AIMS 04-04-009 (for fixings)
Airbus AIMS 04-04-018 (for sealants)
ABP 4-2128 (Airbus UK)

3- PROPERTIES/USE:

		Spray Gun	Brush
Mixing ratio in weight	Base F69	100	100
	Hardener F69	37	37
	Water (AIMS 09-00-003 all grades)	90 to 110	0 to 30
Mixing ratio in volume	Base F69	2V	2V
	Hardener F69	1V	1V
	Water (AIMS 09-00-003 all grades)	2.7 to 3.3V	0 to 0.9V
Mixing procedure	Mix base and hardener then add water while stirring, in two times.		
Induction time	None		
Pot life (once mixed)	8 hours @ 23°C for spray application 2 hours @ 23°C for brush application		
Spraying visc. @ 23°C	17± 3s cup CA 4 (for a dilution of 3.3 V) 28 ± 4s cup ISO 4		



4- RECOMMENDATIONS FOR APPLICATIONS:

Dry thickness	15 to 25 µm	
Conditions	Temperature	15 to 35°C
	Relative humidity	30 to 75%
Equipment	Spray gun	Such as Kremlin M21
	Nozzle	1.2 to 1.5 mm
	Electrostatic gun	
Cleaning	Nozzle	0.8 to 1.2 mm
	Clean the equipment with a suitable thinner such as D760 or D770-B from MAPAERO	



5- METHOD:

- Spray several coats to obtain a thickness between 15 and 25µm dry.

6- DRYING: (for 20 µm dry)

	23°C	45°C	60°C	80°C	IR drying
Dry to touch	15 min	N.A.*	N.A.*	N.A.*	N.A.*
Handlable	1 hour	30 min	20 min	10 min	5 min
Tot. Polym.	1 day	3 h 30	2 h	35 min	12 min

N.A*: Not applicable

NB: Prior to operating an accelerated drying superior to 60°C, allow to flash off at least 15 minutes at room temperature.

7- PHYSICAL CHARACTERISTICS:

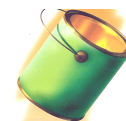
Theoretical consumption : 25 m²/L for 20µm dry (base and hardener not diluted)
Density of dry film : 1.7 (approx)

8- STORAGE:

18 months for base and hardener between 5 and 35°C
(in original full and sealed cans)

9- PACKING:

	Packing (in L)	Part Number
Base	1.4	21069XXXB014L
	4	21069XXXB004L
	200	21069XXXB200L
Hardener	0.7	21069000D700M
	2	21069000D002L
	200	21069000D200L



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. Further more 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.