24T3 Series Abrasion Resistant Fast Dry Polyurethane Coating

Product Group

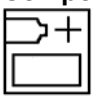
Abrasion resistant coating

Characteristics

Product Information

This two-component, fluoropolymers filled polyurethane coating is inherently light stable with excellent abrasion resistance and surface lubricity. Designed for use on aircraft control surfaces, this coating is resistant to hydraulic fluids, aircraft fuel, engine oil, solvents, water and cleaning compounds. It is available in various colors.

Components



Curing Solution, Thinner

Curing solution: PC-216
Thinner: TR-114, only if required HAPS 7 VOC free reducer

Specifications

Qualified Product List

Boeing	BAC 5710, Type 27
Boeing	BMS 10-86, Type II, Grade D
Boeing Long Beach	DPM 5066, Comp C
Bombardier/Shorts	SMS 93, Ty 2
Lockheed Martin	5PTMRL40-13

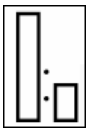
The complete Akzo Nobel Aerospace Coatings qualified product list (QPL) can be found at: www.anac.com

Surface Conditions

Cleaning

- Surface pretreatment is an essential part of the painting process
- Follow the specification requirements for cleaning and pretreatment application.
- Primed surface should be coated within 2-48 hours.
- If the primed surface dries longer than 48 hours, it should be lightly sanded with #400 grit or equivalent sandpaper followed by a solvent wash using a clean cotton cloth dampened with MEK before topcoat.

Instruction for Use



Mixing Ratio (volume)

3 parts	Base: 24T3-XXX
1 part	Curing Solution: PC-216
Only if required	Thinner: TR-114

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- Stir or Shake till all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly

Induction Time

None

Initial Spraying Viscosity (21ºC/70ºF)

16-24 seconds ISO Cup 6
15-27 seconds Signature Zahn Cup 3

The uses of Signature Zahn Cups for viscosity are requirements of the referenced specifications, and the ISO Cup measurement is provided only as a reference for field application. They are not provided as quality control values.

Pot Life (21ºC/70ºF)

30 minutes

Dry Film Thickness (DFT)

203-254 micron (µm)
8-10 mils

Application Recommendations

Standard suction or pressure spray equipment or brush. Satisfactory atomization is easily accomplished at a line pressure of 50-60 psi on a suction gun, to a line pressure of 65-70 psi on a pressure pot gun with 9-15 psi fluid line pressure.

Conditions

Temperature:	15 – 35°C 59 – 95°F
Relative Humidity:	35 – 75%

Equipment

Air	1.8 mm nozzle orifice
HVLP	1.4 mm nozzle orifice
Air Assisted, Electrostatic	.33 mm nozzle orifice

Number of Coats

Apply wet cross coats, allowing 15 minutes to flash off between coats, to achieve 2-3 mils (50-75 microns) dry per coat.

Cleaning of Equipment

MEK, TR-19 or C28/15

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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 (21ºC/70ºF)	Dry to dust	45 minutes
	Tack free	2 hours
	Dry through	3 hours
	Full cure	7 days
	An accelerated cure schedule may be used. Once the required film thickness has been achieved, flash dry the applied coating a minimum of one hour at 75°F (24°C), 50%RH. Cure for two hours at 150°F (66°C), with good air movement.	
Theoretical Coverage	20.57 m^2 per liter ready to apply at 25 micron dry film thickness 802 ft^2 per US gallon ready to apply at 1 mil dry film thickness	
Dry Film Weight	44.07 g/m^2 per 25 micron 0.009 lbs/ft^2 per mil	
Volatile Organic Compounds	Max 420 g/l Max. 3.5 lb/gal	
Gloss (60º)	25 maximum	
Color	Various	
Flash-point	24T3 Series	See MSDS for specific flash-point
	PC-216	78°F (25°C)
Storage	Store product under dry conditions and at a temperature between 5-38°C (41-100°F).	

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Shelf life 5 - 38°C (41 - 100°F)	12 months per ANAC commercial specification Shelf life may vary due to OEM specification requirements

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 MSDSs are available on request.

FOR PROFESSIONAL USE ONLY

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