



## Alumigrip® AP Application Procedure

### Characteristics



Product  
Information

- A two-component acrylic urethane enamel ideal for accent colors and special markings on GA aircraft
- Provides a rich, high gloss finish with excellent DOI.

### Mixing Instructions



Mixing Ratio  
(volume)

It is extremely important to maintain an accurate mix ratio of 2:1:1/4 as any deviation can adversely affect application and performance properties.

2 parts	Alumigrip® AP Series FXXXXP
1 parts	G3010P
¼ parts	T0001P, T0003P, or T0005P

Thinner T0001P fast evaporating  
Thinner T0003P standard reducer  
Thinner T0005P hot weather (greater than 30°C/85°F)

1. Store material at room temperature for a minimum of 24 hours prior to mixing.
2. Prior to mixing put the base portion (FXXXXP) on a shaker and agitate for ten minutes.
3. The base component should be uniform and free of lumps, skins or hard settling.
4. The curing solution should be clear. Do not use if the curing solution has gelled, is cloudy or milky.
5. **Do not use** if the unopened can shows signs of swelling since this indicates moisture contamination.
6. Viscosity should be 16-19 seconds (#2 Zahn) and dry film thickness 2-3 mils.
7. Slowly add the base and curing solution components together while stirring. Use the TXXXXP to rinse residual material from the base and curing solution containers to ensure an accurate mix. Pot life is dependant upon the selected thinner and temperature.



**Note:**  
Overcoat Time

45-60 minutes



Equipment

Type	Tip Size	Spray Gun Air Pressure	Pot Air Pressure	Other
Conventional	.040-.065 inch	50-65 psi	8-12 psi	Low transfer efficiency
HVLP	.040-.065 inch	40-55 psi	8-12 psi	Iwata, Sata, Binks Mach 1
Low Pres. Electrostatic	1.2-1.5mm	35-45 psi	12-100 psi	PRO3500, 4500SC
Air Assist Electrostatic	.009-.013 inch	55-65 psi	1800-2500 psi	PRO4000AA Ransburg (tips 1.2-1.5mm)
Conventional	.040-.065 inch	50-65 psi	8-12 psi	Low transfer efficiency
HVLP	.040-.065 inch	40-55 psi	8-12 psi	Iwata, Sata, Binks Mach 1



Number of coats

Spray a uniform first coat of approximately 2 mils (50 microns) wet. Allow the coat to flash for 30-45 minutes. Apply a second, uniform coat of 2 mils wet (50 microns).

Some colors will require three coats to achieve sufficient hide. If a third coat is applied, allow 45 minutes flash time between the second and third application. Gradually build the film thickness with the third application being a full wet coat to hide.

Flash time 15-30 minutes

Recoat window 15-60 minutes (will vary with choice of reducer)

Use TR-15 or C28/15



Cleaning of Equipment



Pot Life  
(25°C/77°F)

	77°F (25°)	77°F (25°C)	90°F (32°C)	120°F (48°C)
<b>Thinner</b>	<b>Pot Life</b>	<b>50% RH</b>	<b>40%RH</b>	<b>10%RH</b>
T0001P	8 – 10 hrs	14 – 16 hrs	8 – 10 hrs	6 – 8 hrs
T0005P	X – X hrs	X – X hrs	X – X hrs	X – X hrs
T0003P	12 – 14 hrs	18 – 20 hrs	6 – 8 hrs	2 – 4 hrs



Note

**Note:** Reducer options may be blended to achieve the desired combination of dry time, buffing time, pot life, and wet edge characteristics

For instruction to use T0005P, contact your AkzoNobel Aerospace Coatings Technical Service Consultant.

**Note:** T0005P is used as an additive. T0005P blended with T0001P or T0003P to improve flow. T0005P has a very slow evaporation rate. Using T0005P at temperatures below 75°F / 24°C may result in very long dry and tape times. Large amounts of T0005P in flat or semi-gloss products may result in higher loss levels. Use care when adding T0005P to products.

## 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.

### Issue date: June 2010 (supersedes December 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.

Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.