



Alumigrip® (GXXXX) Application Procedure

Characteristics



Product
Information

- The Alumigrip® topcoat is a three-component polyurethane finish which provides a rich, high gloss finish with excellent D.O.I. Formulated to the demanding requirements of the aerospace market, this product will provide superior color and gloss retention, along with excellent chemical, and abrasion resistance.

Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process.

Mixing Instruction



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.

- 1 part Base GXXXX
- 1 part Curing Solution G3010P
- .5 part Thinner T000XP (25% of mixed material, plus curing solution)
 - Thinner T0001P fast evaporating
 - Thinner T0002P fast evaporating cold weather thinner
 - Thinner T0003P standard reducer
 - Thinner T0005P hot weather (greater than 30°C/85°F)

- 1 oz. Optional accelerator 73015 (X-138)
(1 oz. per 2 gallons of mixed Base and Curing Solution)
 1. Store material at room temperature for a minimum of 24 hours prior to mixing.
 2. Store material at room temperature for a minimum of 24 hours prior to mixing.
 3. Prior to mixing put the base portion (GXXXX) on a shaker and agitate for ten minutes.
 4. The base component should be uniform and free of lumps, skins or hard settling.
 5. The curing solution should be clear. Do not use if the curing solution has gelled, is cloudy or milky.
 6. **Do not use** if the unopened can shows signs of swelling since this indicates moisture contamination.
 7. Viscosity should be 16-20 seconds (#2 Zahn) and dry film thickness 2.5 – 3.5 mils.
 8. Slowly add the base and curing solution components together while stirring. Use the T-XXXX 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

Overcoat Time 45-60 minutes



Pot Life
(25°C/77°F)

| | 77°F (25°) | 77°F (25°C) | 90°F (32°C) | 120°F (48°C) |
|----------------|-----------------|---------------|--------------|--------------|
| Thinner | Pot Life | 50% RH | 40%RH | 10%RH |
| 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 T0005, contact your AkzoNobel Aerospace Coatings Technical Service Consultant.

Note: T0005P has a very slow evaporation rate. Using T0005 at temperatures below 75°F / 24°C may result in very long dry and tape times. Large amounts of T0005 in flat or semi-gloss products may result in higher loss levels. Use care when adding T0005 to these products.

Application Recommendations



Conditions

Do not apply paint materials to surfaces warmer than 105°F (41°C) or colder than 55°F (13°C). Do not attempt to cure products at temperatures below 55°F (13°C).

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



Equipment

Conventional air spray:

Atomizing air pressure: 45 to 65 psi
Pot pressure (if applicable): 6 to 12 psi
Tip size: 1.2 to 1.4 mm

HVLP:

Input air: up to 45 psi
Fluid/pot pressure: 6 to 12 psi
Tip size: 1.2 to 1.4 mm

High pressure air assist airless electrostatic spray equipment:

Fluid pressure: 1800 to 2500 psi (pump ratio 30:1)
Atomizing air pressure: 55 to 65 psi
Tip size: .009 to .011 inch (0.23 - 0.28 mm)



Number of coats

Two to three coats are recommended for spray applications.

Spray a uniform coat of approximately 2.0 mils wet (50microns). Allow the coat to flash for 30-45 minutes. Apply a second, uniform coat of approximately 3.0 mils wet (75 microns).



Note

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.



Cleaning of Equipment

Use TR-15 or C28/15 for clean up

Physical Properties



Accelerated Dry Time
1oz. 73015
(X-138)

| Thinner | Temp. | Dry Time | Pot Life |
|-----------|-----------|----------------|----------|
| T0003P | 21°C/70°F | 12 hrs | 6-7 hrs |
| T0003P | 27°C/80°F | 4 – 5 hrs | 4 hrs |
| T0003P | 32°C/90°F | 3 – 4 hrs | 2 hrs |
| Full cure | | 7 days air dry | |

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.

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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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