

Product Group

Polyurethane Topcoats

Characteristics



Product Information

Aerodur® Finish HF is a 3-component flexible, high gloss polyurethane finish for interior and exterior use.

- Excellent gloss retention and durability
- Impact and erosion resistant
- Resistant to aircraft hydraulic fluids and chemicals

Components



Hardener Thinner or Activator

Hardener S 66/22 R
Thinner C 25/90 S
Thinner 96184 (warm conditions)

Specifications



Qualified Product List

Airbus	TN.A.007.10113
Boeing	BMS 10-72 Type 5

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

Surface Conditions



Cleaning

- Observe the recoatability limits of the relevant primer.
- Remove oil, grease and other contaminants prior to the application of the finish.
- Recondition aged primers or topcoats with e.g. Scotch-Brite™ type A very fine till a uniform matt surface.
- Remove dust with e.g. tack rags prior to application of the finish.

Instruction for Use



Mixing Ratio (volume)

100 parts	Aerodur® Finish HF
100 parts	Hardener S 66/22 R

Reduce to spraying viscosity with:

50 – 75 parts Thinner C 25/90S or Thinner 98184

- Allow products to acclimatize to room temperature before use
- Stir or shake Aerodur® Finish HF till all pigment is uniformly dispersed before adding hardener.
- Add Hardener S 66/22 R and stir the catalyzed mixture thoroughly.
- Add thinner and stir again till a homogeneous mixture.



Induction Time

15 – 30 minutes after mixing



Initial Spraying Viscosity (21°C/70°F)

31 – 34 seconds ISO-Cup 3
25 – 27 seconds Gardner Signature Zahn-Cup #1.



Potlife
(21°C/70°F)

4 hours.



Dry Film
Thickness
(DFT)

50 – 75 micron (µm)
2 – 3 mils

**Application
Recommendations**



Conditions

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



Equipment

Air 1.4 mm nozzle orifice
HVLP 1.4 mm nozzle orifice
Air Electrostatic 1.2 mm nozzle orifice
Airless Electrostatic 6.11 – 6.13, (.011 - .013 inch) angle 60°



Number of Coats

Apply an even wet closed coat, followed after 45 minutes flash-off time by a cross-coat or by two even wet coats with 30 minutes flash-off time between coats.



Cleaning of
Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068



Note

The way of application, skills and experiences of the painter and surrounding conditions (temperature, relative humidity, airspeed) significantly affect the final appearance and dry film thickness. When using the product for the first time it is strongly recommended to apply some test panels first.

Physical Properties



Drying Times
(21°C/70°F)

Set to touch 2 hours
Dry to tape 6 - 8 hours
Recoat minimum 6 hours for decoration colors
Recoat maximum 72 hours,
If a drying time of 72 hours is exceeded,
condition surface with e.g. Scotch-Brite™
type A very fine.
Forced drying 30 minutes flash-off time, followed by 1
hour at 80°C or 2 hours at 60°C.







Theoretical
Coverage

15 m² per liter base material at 50 µm dry film thickness
602 ft² per US gallon base material at 2 mils dry film thickness



Dry film weight

1.7 g/m²/µm
0.0088 lbs/ft²/mil

	Gloss (60°)	Minimal 90 GU								
	Color	Available according to e.g. BAC, AFNOR, RAL, BS381C and FS595. New designs and special colors on request.								
	Flash-point	<table border="0"> <tr> <td>Aerodur® Finish HF</td> <td><21°C / 70°F</td> </tr> <tr> <td>Hardener S 66/22 R</td> <td>>21°C / 70°F</td> </tr> <tr> <td>Thinner C 25/90 S</td> <td><21°C / 70°F</td> </tr> <tr> <td>Thinner 96184</td> <td><21°C / 70°F</td> </tr> </table>	Aerodur® Finish HF	<21°C / 70°F	Hardener S 66/22 R	>21°C / 70°F	Thinner C 25/90 S	<21°C / 70°F	Thinner 96184	<21°C / 70°F
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	Storage	<p>Store the product dry and at a temperature between 5 and 25°C/ 41 and 77°F.</p> <table border="0"> <tr> <td>Aerodur® Finish HF</td> <td>24 months</td> </tr> <tr> <td>Hardener S 66/22 R</td> <td>12 months</td> </tr> <tr> <td>Thinner C 25/90 S</td> <td>36 months</td> </tr> <tr> <td>Thinner 96184</td> <td>36 months</td> </tr> </table>	Aerodur® Finish HF	24 months	Hardener S 66/22 R	12 months	Thinner C 25/90 S	36 months	Thinner 96184	36 months
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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.

Warranty

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