



Product Group

Polyurethane Topcoat

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.

Components



Curing Solution,
Thinner/Reducer
or
Activator

Curing Solution G3010P
T0001P Fast evaporating thinner
T0002 Fast evaporating, cold weather thinner
T0003P Standard thinner
T0005P Hot weather thinner (greater than 85°F/30°C)
73015 (X-138) Optional accelerator

Specifications



Qualified Product
List

AkzoNobel Aerospace Coatings Certification

The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: www.akzonobel.com/aerospace

Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process.
- Alumigrip® Topcoats are compatible with all AkzoNobel Aerospace Coatings primer options. Please consult the technical data sheet for the primer application instruction and information.

Instruction for Use








Mixing Ratio
(volume)

1 part	Base GXXXX or HXXXX
1 part	Curing Solution G3010P
.5 part	Thinner T000X (25% of mixed material, plus curing solution)
1 oz.	Optional accelerator 73015 (X-138) (1 oz. per gallon of Base)





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



	Induction Time	None
	Initial Spraying Viscosity (25°C/77°F)	28 – 38 seconds ISO-Cup 4 16 – 20 seconds Zahn-Cup #2, 50% RH
	Note	Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.
	Pot Life (25°C/77°F)	12 hours (no accelerator)
	Dry Film Thickness (DFT)	63 – 88 micron (µm) 2.5 – 3.5 mils

Application Recommendations

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).

	Conditions	Temperature: 15 – 35°C 59 – 95°F Relative Humidity: 35 – 75%
	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.
	Equipment	Air 1.2 – 1.4 mm nozzle orifice HVLP 1.2 – 1.4 mm nozzle orifice Air Electrostatic 0.23 – .028 mm nozzle orifice
	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).



Number of Coats
Continued
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



Drying Times
according to
AITM 2-0011
(25 +/- 2°C / 77
+/- 2°F, 55 +/- 5%
RH)

Dry to tape T0001P	18 – 24 hrs
Dry to tape T0002	10 – 12 hrs
Dry to tape T0003P	24 hrs
Dry to tape T0005P	24+ hrs
Dry to tape T0005P	18 – 24 hrs @ 30°C/85°F

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

<u>Thinner</u>	<u>Temp.</u>	<u>Dry Time</u>	<u>Pot Life</u>
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



Theoretical
Coverage

13.5 m² per liter ready to apply at 25 µm dry film thickness
550 ft² per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

38.7 g/m²/25 micron
0.008 lbs/ft²/1 mil



Volatile Organic
Compounds
mixed 1:1:0.5
(25%)

Approximately 630-660 g/l
Approximately 5.25-5.5 lbs/gal

Note: VOC will vary depending on color and the amount of reducer added.



Gloss (60°)

90 minimum GU



Color

As specified



Flash-point

GXXXX / HXXXX (base component)	27°C / 80°F
G3010P	-4°C / 25°F
T0001P	-5°C / 23°F
T0003P	-4°C / 25°F
T0005P	34°C / 94°F
73015	36°C / 96°F



Storage

Store the product dry and at a temperature between 5 and 38°C / 40 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life
5 - 38°C
(40 - 100°F)

24 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

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: September 2009 (supersedes August 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.

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