Aerodur® Finish C 21/100 UVR

Product Group

Polyurethane Topcoats

Characteristics

Product Information

Aerodur® Finish C 21/100 UVR is an universal 3-component, high gloss very durable polyurethane finish for interior and exterior use.

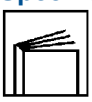
- Highly resistance to ultra-violet radiation and weathering.
- Excellent durability and flexibility
- Resistant to aircraft hydraulic fluids and chemicals
- Available in lead free colors
- Tinters are available in very accurate color and strength controlled versions
- Color mixing machines available for Aerodur® Finish C 21/100 UVR tinters.

Components

Hardener Thinner or Activator

Hardener S 66/22 R
Thinner C 25/90 S (normal conditions, flashpoint <21ºC)
Thinner 98064 (warm conditions, flashpoint >21ºC)
Thinner 96184 (warm conditions, flashpoint <21ºC)

Specifications



Qualified Product List

Airbus	AIMS 04.04.012
Boeing	BMS 10-72 type 5 (performance)
Embraer	MEP 10-061
British Aerospace	BAEP 3545
Fairchild Dornier	DOL 256
Air France	SMI 70089-1

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

Surface Conditions

Cleaning

- Observe the recoatability limits of the relevant primer.
- Remove oil, grease and other contaminants prior to 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 C 21/100 UVR
100 parts	Hardener S 66/22 R

Reduce to spraying viscosity with:

50 – 75 parts	Thinner C 25/90S, Thinner 98064 or Thinner 96184

- Allow products to acclimatize to room temperature before use
- Stir or shake Aerodur® Finish C 21/100 UVR 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.

AkzoNobel Aerospace Coatings
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Internet: www.akzonobel.com/aerospace

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Induction Time	15 – 30 minutes after mixing
Initial Spraying Viscosity (21ºC/70ºF)	36 – 40 seconds ISO-Cup 3 27 – 28 seconds Gardner Signature Zahn-Cup #1.
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 (21ºC/70ºF)	8 hours.

Dry Film Thickness (DFT)	**off-white and grey colors**	**non-tinted white and BAC 7067**
	50 – 75 micron (µm)	75 – 100 micron (µm)
	2 – 3 mils	3 – 4 mils

Application Recommendations

Conditions	Temperature:	15 – 35ºC 59 – 95ºF
	Relative Humidity:	35 – 75%
Note	Aerodur® C21/100 UVR topcoat may be applied in conditions outside of the the limits shown above. Care must be excercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques and choice of thinner when environmental conditions fall outside of the recommended range.	
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 60º
Number of Coats	Apply two cross coats with 45 – 60 minutes solvent flash-off time in between to obtain the advised dry film thickness. When industrial hiding is not achieved after the second layer, additional layers may be necessary.	
Note	When bright transparent colors (e.g. bright orange, yellow) are applied, it is advisable to apply Aerodur® Finish C21/100 UVR in an off-white color (e.g. M8001) before application of the color. This to reduce the number of coats necessary for industrial hiding.	
Cleaning of Equipment	Solvent Cleaning C 28/15 or Solvent Cleaning 98068	
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.	

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Physical Properties

Drying Times (21ºC/70ºF)

Dust free	2 hours
Dry to tape	6 - 9 hours
Recoatable minimum	6 hours for decoration colors
Recoatable 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 followed by 1 hour at 80ºC or 2 hours at 60ºC.

Theoretical Coverage

16 m^2 per liter base material at 50 µm dry film thickness
642 ft^2 per US gallon base material at 1.8 mil dry film thickness

Gloss (60º)

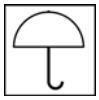
Minimum 90 GU

Color

Available according to e.g. BAC, AFNOR, RAL, BS 381 C and FS 595. New designs and special colors on request.

Flash-point

Aerodur® Finish C 21/100 UVR	>21ºC / 70ºF
Hardener S 66/22 R	>21ºC / 70ºF
Thinner C 25/90 S	<21ºC / 70ºF
Thinner 98064	>21ºC / 70ºF
Thinner 96184	<21ºC / 70ºF



Storage

Store the product dry and at a temperature between 5 and 25ºC / 41 and 77ºF. Stored in the original unopened containers.

Aerodur® Finish C 21/100 UVR	24 months
Hardener S 66/22 R	24 months
Thinner C 25/90 S	36 months
Thinner 98064	36 months
Thinner 96184	36 months

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.

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