



**Technical Data**

<b><u>Product Name</u></b>	<b>5478/...</b>
<b><u>Product Description</u></b>	<b>CELOFLEX 95 series</b> Polyurethane elastomeric bi-component paint, designed to ensure the antierosion protection of the leading edge and radomes.
<b><u>Key Features</u></b>	Excellent resistance to UV and erosion
<b><u>Specifications – Approval</u></b>	AIRBUS PQ 10050-117 (according to AIMS 04-04-006 and AIMS 04-04-016)
<b><u>Specifications – Performance</u></b>	The system P99 + PAC 33 + Celoflex 95 on 2024 aluminium alloy (sulfochromic pre-treatment) meets the requirements of the above specification. Cross-cut adhesion (ISO 2049) → grade 0 Flexibility @ 23°C (ISO 1519) → total (180°) Distilled water, immersion 14 days @ 23°C (ISO 1521) → Grade ≤1, Q+S (ISO 2049) Skydrol type IV, 14 days @ 70°C (ISO 2812) → Scratch Resistance (ISO 1518) >1200 g
<b><u>Catalyst/Hardener/Activator</u></b>	0778/9000
<b><u>Thinner/Reducer</u></b>	X) 0470/9000 (X
<b><u>Pack Size</u></b>	Base : 1 L and 5 L
<b><u>Mix Ratio</u></b>	Base 1 Volume Hardener 1 Volume Thinner 0,5 to 1 Volume
<b><u>Recommended Schemes</u></b>	Applicable on the following systems: - P99 (ref. 7641/3600) and anti-corrosive primer PAC 33 (ref. 4355/3600) - 5014 polyurethane primer-surfacer (ref. 5425/0000) - anti-static type II polyurethane primer (ref. 0986/2620)

**Product Application Parameters**

<b>Surface Preparation</b>	Apply over suitably prepared primer-surfacer, or anticorrosion primer.
<b>Preparation Mixing</b>	Before mixing and paint, the material should be allowed to reach room temperature. Be sure all mixing and measuring containers are clean and free from contamination. Shake the base or stir it thoroughly until there is no solid material left on the bottom of the can. Always add the curing solution slowly while stirring the base. Then add the thinner (while stirring).
<b>Viscosity</b>	16 to 18 seconds AFNOR 4 @ 23°C
<b>Induction Time</b>	Not Required
<b>Pot Life</b>	3 hours
<b>Application Method</b>	Apply 2 or 3 coats. Wait for 30 minutes between 2 coats.
<b><u>Recommended Application Conditions</u></b>	From 18°C to 23°C / 40% to 70% R.H. Possibility: from 15°C to 30°C / 30% to 80% R.H.
<b><u>Application Equipment</u></b>	

Equipment Type	Tip Size	Pressure (Bar)
Pneumatic application	1,5/1,8 mm	3 – 5 bars

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PPG Aerospace Germany +49(0)4074219310  
PPG Aerospace Dubai +971 4 883 9666

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**Equipment Cleaning**

The coating is a chemically reacting system. It is no longer soluble in solvents after it has cured. For this reason, clean equipment as soon as possible after the coating has been applied and always before the material has cured. Note that even a fresh coating deposits a film on the equipment that does not dissolve easily. Agitation with a brush or cloth will help to remove these deposits.  
For further information, please contact the Technical Service.

**Dry Film Thickness**

80 to 100 microns

**Drying Times @ 23°C ± 1°C and 55% R.H. ± 5%**

Dry to Handle	4 Hrs
Dry to Tape	12-14 Hrs
Drying before using	≥ 48 Hrs
Full Cure	7 days

**Cover time**

Minimum : 4 H  
Maximum : 24 H

**Accelerated Cure**  
**Flash Off Time**

30 to 45 minutes @ 60°C  
15 minutes @ 23°C

**Special Notes**

The cleaners for the Celoflex (dry film) are exclusively Isopropylalkohol and Petrol F. DO NOT USE METHYL ETHYL KETONE after reactivation of the film (which must be done with Scotch Brite).

**Physical Characteristics**

**Colour**  
**Gloss**

white, grey or black are currently available  
≥ 90% @ 60°

**Coverage**

3 to 4 m<sup>2</sup>/L

**Dry Film Density**

1,2 to 1,3 according tones

**VOC Content (Ready for use)**

from 485 g/l to 550 g/l (following the dilution)

**Flash Point**

Base: 21°C  
Hardener: 23°C  
Thinner: 6°C

**Shelf Life**

12 months from the date of manufacture when products are stored to the original unopened containers.  
X | The thinner is without any shelf life. | X  
5°C to 30°C

**Storage Conditions**

**Health & Safety**

This product is safe to use and apply when recommended precautions are observed. Before using this product it is important to read and understand the Material Safety Data Sheet. This provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. Material Safety DataSheets are available on request.  
In case of overexposure, wash with soap and water and seek medical advice.

All recommendations, statements and technical data contained herein are based on tests we reasonably believe to be reliable and correct, but the accuracy and completeness of such tests are not guaranteed and are not to be construed as a warranty, either express or implied. The User shall rely on its own information and tests to determine the suitability of any product for its intended use and the User agrees to assume all risks and liability arising in relation to its use of such product (other than death or injury resulting from our negligence) and accordingly we shall not assume any such risks or liability unless we specifically agree to the contrary in writing. If we specifically agree to assume any such risks or liability then (except for death or injury resulting from our negligence) our sole responsibility if any product supplied to the User by us is defective shall be to replace that portion of such product which is defective. Recommendations or statements other than those specifically agreed in writing by us shall not be legally binding on us.