Aerodur® Finish HF A 133

AkzoNobel
Tomorrow's Answers Today

Product Group

Polyurethane Topcoats

Characteristics

Product Information

Aerodur® Finish HF A 133 is a 3-component flexible, semi-gloss polyurethane camouflage finish for interior and exterior use.

- Excellent durability and flexibility
- 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 (normal conditions, flashpoint <21°C)
Thinner 98064 (warm conditions, flashpoint >21°C)

Specifications

Qualified Product List

German Army	TL 8010-0312
US Air Force	MIL-C-83286
Belgian A.F.	BA-CP-4610
French Air Force	Approval nr. 035141

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 HF A 133
100 parts	Hardener S 66/22 R

Reduce to spraying viscosity with:

Max. 125 parts	Thinner C 25/90S or Thinner 98064

- Allow products to acclimatize to room temperature before use
- Stir or shake Aerodur® Finish HF A 133 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

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Aerodur® Finish HF A 133

Initial Spraying Viscosity (21ºC/70ºF)	38 – 43 seconds ISO-Cup 3 27 – 29 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)	6 hours.
Dry Film Thickness (DFT)	45 – 60 micron (µm) 1.8 – 2.4 mils

Application Recommendations

Conditions	Temperature:	15 – 35ºC 59 – 95ºF
	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 60º

Number of Coats	Apply a single coat followed after 20 – 30 minutes solvent flash off time by a full cross coat.
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)

Set to touch	2 hours
Dry hard	4 hours
Dry to tape	6 - 8 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.

Theoretical Coverage

17 m^2 per liter base material at 45 µm dry film thickness
682 ft^2 per US gallon base material at 1.8 mils dry film thickness

Gloss (60º)

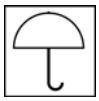
15 – 45 GU

Color

Fed. Stan. 595.

Flash-point

Aerodur® Finish HF A 133	<21ºC / 70ºF
Hardener S 66/22 R	>21ºC / 70ºF
Thinner C 25/90 S	<21ºC / 70ºF
Thinner 98064	>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 HF A 133	24 months
Hardener S 66/22 R	24 months
Thinner C 25/90 S	36 months
Thinner 98064	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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