

BASE COAT F14

FINISHES FOR AIRCRAFT EXTERIORS

AkzoNobel

Product information



Fast drying three components solvent based polyurethane base coat with a matt finish.

Components



Base F14
Hardener / Catalyst F14
Thinner 713, 714 or 715

Specifications



Qualified in accordance with :
Daher - Socata

Product information mentioned in the technical datasheet is given for information purposes and can differ from requirements of specifications above. In that case, customer requirements are valid for your application.

Physical properties



THEORETICAL COVERAGE
7m²/kg for 50µm dry (2mils), base and hardener not reduced

DRY FILM WEIGHT
1.75

VOC
480 g/L (ISO 11890-1 et ASTM 3960)

SHELF LIFE / STORAGE
24 months for base and hardener stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

NOTES
Gloss levels have been determined using glossmeter with an angle of incidence of 60°.
The theoretical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation



All recommendations mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	8V
Hardener / Catalyst	10	1V
Thinner	30 to 50	3 to 5V

MIXING PROCEDURE

Ideally, the unmixed products should be stored between 18°C and 25°C (64°F and 77°F) for 24 hours before use. The mixture by weight is recommended. Mix the base and the hardener until the material is homogeneous. Then add the thinner and mix. The mixture must be made at a temperature between 15°C and 35°C (59-95°F). For temperature between 15°C and 25°C (59-77°F), use the 713 thinner. For temperature between 25°C and 30°C (77-86°F), use the 714 thinner. For large surfaces, the 715 thinner could be used.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

Taux de dilution en masse	AFNOR 4
40%	18 +/- 4s

POT LIFE

1 hour at 23°C (73°F)

NOTE

Viscosities mentioned above are corresponding to the recommended range of viscosity to ensure compliant application. The range of dilution must be used to adjust viscosity to reach the recommended one.

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Application recommendations



CONDITIONS

Temperature 15 to 25°C (59 to 77°F) for thinner 713; 25 to 35°C (77 to 95°F) for thinner 714 or 715
Relative humidity 30 to 70%

EQUIPMENT

Pneumatic spray gun nozzle 1.5 to 1.8mm (59 to 70 mils).

DRY / WET FILM THICKNESS

30 to 70 µm (1.18 to 2.75 mils) dry.

NUMBER OF COATS

Apply three or four crossed coats with 5 to 10 minutes between each coat.

EQUIPMENT CLEANING

Clean the material with an appropriate thinner as PU from MAPAERO.

NOTE

Spray with dry oil-free air.

Drying times



NOTE

	23°C (73°F) Thinner 713	23°C (73°F) Thinner 714	23°C (73°F) Thinner 715
Dust free	5 to 10 minutes	10 to 15 minutes	15 to 20 minutes
Dry to handle	1 hour	1 hour 30 minutes	1 hour 3 minutes
Recoat able	3 hours	4 hours	4 hours 30 minutes
Fully cured	7 days	7 days	7 days

Drying times have been determined using tests pieces of a thickness < 2mm for 50µm (2mils).

The base coat F14 can be overcoated by itself or by the varnish A1500-UVR within 72 hours.

Defects & corrections



In the event of a defect, contact your Quality Department.

Health & Safety



See the product Safety Data Sheets.

The MSDS are available through our website www.mapaero.com.

Packing



The F14 base is available in 1 L and 5 L.

The F14 hardener is available in 1 L and 5L.

Thinners are available in 1L and 5 L. 713 thinner is available in 30L.

WARRANTY : We guarantee our products against hidden defaults over material and preparation. Our Responsibility is limited to the obligation of freely replacing the defective material without there being a claim for any compensation. The advice we give is based on our experience but it might not be absolutely right. Consequently this does not imply our responsibility in case of inefficiency. Furthermore our company cannot be responsible for any material or corporal damages caused due to a misuse or mishandling of our products. Any concession to these clauses, to be valid, must be an official document issued by our offices and signed by our direction.