

24T3 Series

Abrasion Resistant Fast Dry Polyurethane Coating

Technical Data Sheet

Product Group

Abrasion resistant coating

Characteristics



Product
Information

This two-component, fluoropolymers filled polyurethane coating is inherently light stable with excellent abrasion resistance and surface lubricity. Designed for use on aircraft control surfaces, this coating is resistant to hydraulic fluids, aircraft fuel, engine oil, solvents, water and cleaning compounds. It is available in various colors.

Components



Curing Solution
Thinner

Curing solution: PC-216
Thinner: TR-114, only if required HAPS 7 VOC free reducer

Specifications



Qualified
Product List

Boeing	BAC 5710, Type 27
Boeing	BMS 10-86, Type II, Grade D
Boeing Long Beach	DPM 5066, Comp C
Bombardier/Shorts	SMS 93, Ty 2
Lockheed Martin	5PTMRL40-13, LMA-MR008

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

Surface Conditions



Cleaning

- Surface pretreatment is an essential part of the painting process
- Follow the specification requirements for cleaning and pretreatment application.
- Primed surface should be coated within 2-48 hours.

If the primed surface dries longer than 48 hours, it should be lightly sanded with #400 grit or equivalent sandpaper followed by a solvent wash using a clean cotton cloth dampened with MEK before topcoat.

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Instruction for Use



Mixing Ratio
(volume)

3 parts
1 part
Only if required

Base: 24T3-XXX
Curing Solution: PC-216
Thinner: TR-114

- 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)

16-24 seconds ISO Cup 6
15-27 seconds Signature Zahn Cup 3

The uses of Signature Zahn Cups for viscosity are requirements of the referenced specifications, and the ISO Cup measurement is provided only as a reference for field application. They are not provided as quality control values.



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)

30 minutes.



Dry Film
Thickness
(DFT)

203 – 254 micron (μm)
8 – 10 mils

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Application Recommendations

Standard suction or pressure spray equipment or brush. Satisfactory atomization is easily accomplished at a line pressure of 50-60 psi on a suction gun, to a line pressure of 65-70 psi on a pressure pot gun with 9-15 psi fluid line pressure.



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 1.8 mm nozzle orifice
HVLP 1.4 mm nozzle orifice
Air Assisted, Electrostatic .33 mm nozzle orifice



Number of Coats

Apply wet cross coats, allowing 15 minutes to flash off between coats, to achieve 2-3 mils (50-75 microns) dry per coat.











Cleaning of Equipment

MEK, TR-19 or C28/15

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Physical Properties

	Drying Times (25 +/- 2°C / 77 +/- 2°F, 55 +/- 5% RH)	Dry to dust 45 minutes Tack free 2 hours Dry through 3 hours Full cure 7 days
	Note	An accelerated cure schedule may be used. Once the required film thickness has been achieved, flash dry the applied coating a minimum of one hour at 75°F (24°C), 50%RH. Cure for two hours at 150°F (66°C), with good air movement.
	Theoretical Coverage	20.57 m² per liter ready to apply at 25 micron dry film thickness 802 ft² per US gallon ready to apply at 1 mil dry film thickness
	Dry Film Weight	44.07 g/m² per 25 micron 0.009 lbs/ft² per mil
	Volatile Organic Compounds	Max 420 g/l Max. 3.5 lb/gal
	Gloss (60°)	25 maximum GU
	Color	Various
	Flash-point	24T3-XXX 25 □ 27°C / 77 □ 81°F (See MSDS for specific flash-point) PC-216 25°C / 78°F

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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)

12 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 MSDS's are available on request.

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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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