

473-13

Integral Fuel Tank Coating

Technical Data Sheet

Product Group

Fuel tank coating

Characteristics



Product
Information

- A two-component coating developed as a secondary fuel vapor barrier coating for integral fuel tanks. May be applied by brush or spray.

Components



Curing Solution
Thinner

Curing Solution C-31
Thinner TL-29

Specifications



Qualified
Product List

Avic Aviation	AMMS2522
Bombardier/deHavilland	DHMS C4.20
Bombardier	RAM-BA700-900
Boeing Long Beach	DPM 3430-1, DPM 3430-2

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.
- On aluminum surfaces: degrease thoroughly and pre-treat metal surfaces chemically (chromic acid, anodize, acid chromate pickling, Alodine 1200, Alochrome or Iridite). Maximum adhesion and performance is obtained when the coating is applied over 454-4-1 integral fuel tank coating.
- Note: To recoat after dry hard, surface should be scuff sanded to reactivate the coating surface.

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Instruction for Use



Mixing Ratio
(volume)

100 parts
7.1 parts
25%

Base 473-13
Curing Solution C-31
Thinner TL-29 (for spray application per DPM 3430-2)

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.
- If spray application per DPM 3430-2 is required add 25% by volume of TL-29 mixture and stir thoroughly.



Induction Time

Not Required



Initial Spraying
Viscosity
(25°C/77°F)

Not Applicable



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.

Viscosity measurements for this product vary according to OEM specifications. Please refer to the relevant specification.



Pot life
(25°C/77°F)

1 hour



Dry Film
Thickness
(DFT)

250 – 500 micron (µm)
10 – 20 mils

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Application Recommendations



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

Airless nozzle orifice 0.279 mm (0.011 inch), 60°
0.330 mm (0.013 inch), 80°
Air nozzle orifice 1.4 mm (0.055")



Number of
Coats

Spray or brush multiple wet coats to recommended dry film thickness
Note: To recoat after dry hard, surface should be scuff sanded to reactivate the coating surface.



Cleaning of
Equipment

Use a VOC compliant solvent blend.

Physical Properties



Drying Times
(25 +/- 2°C / 77
+/- 2°F, 55 +/-
5% RH)

Dry to touch 2 ½ hours
Dry to recoat 5 hours
Dry hard 24 hours

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Theoretical
Coverage

31 m² per liter ready to apply at 25 µm dry film thickness
1247 ft² per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

28 g/m² at 25 microns
.006 lbs/ft² at 1 mil



Volatile Organic
Compounds

Max 188 g/l
Max 1.6 lb/gal



Gloss (60°)

80 maximum GU



Color

Clear



Flash-point

473-13	-5°C / 23°F
C-31	102°C / 215°F
TL-29	-4.1°C / 25°F



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)

24 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.

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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.

Issue date: June 2021 (supersedes October 2020) - FOR PROFESSIONAL USE ONLY

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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