Aerodur® HS 67348

AkzoNobel
Tomorrow's Answers Today

Product Group

Polyurethane Topcoats

Characteristics

Product Information

Aerodur® HS 67348 is a 3-component, semi gloss polyurethane finish for interior use.

- Resistant to aircraft hydraulic fluids and chemicals.
- High Solids.
- Compatible with Aerodur® HS Primer 37092 and Epoxy Primer 37035A.

Components

Hardener Thinner or Activator

Hardener 90150
Activator 99302

Specifications

Qualified Product List

Airbus UK	ABP 4-2130
Airbus	AIMS 04-04-003 / 040 / 041
Hawker Beechcraft	BAEP3528-4PSD2

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® HS 67348
33 parts	Hardener 90150
33 parts	Activator 99302

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur® HS 67348 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 90150 and stir the catalyzed mixture thoroughly.
- Add Activator 99302 and stir again till a homogeneous mixture.

Induction Time

Not applicable. Product can be used directly after mixing.

Initial Spraying Viscosity (21ºC/70ºF)

30 – 40 seconds ISO-Cup 4
15 – 17 seconds Gardner Signature Zahn-Cup #2.

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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)	3 hours.
Dry Film Thickness (DFT)	25 – 30 µm 1.0 – 1.2 mils
Note	The application and mixing characteristics of High Solid products differ from conventional products. Mix base and hardener for at least 2 minutes thoroughly. The high solid content causes a rapid film build up.

Application Recommendations

Conditions	Temperature:	15 – 35ºC 59 – 95ºF
	Relative Humidity:	35 – 75%
Note	Aerodur® HS 67348 topcoat may be applied in conditions outside of the the limits shown above. Care must be excerciesed to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.	
Equipment	Air HVLP Airless / Air assist	1.4 – 1.8 mm nozzle orifice 1.4 – 1.8 mm nozzle orifice 6.11 – 6.13, (.011 - .013 inch) angle 60º
Number of Coats	Apply one 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)	Dust free	2 – 3 hours
	Dry to tape	6 – 8 hours
	Dry to handle	12 minutes flash off time, followed by 40 minutes at 75°C.
	Forced cure	30 minutes flash off time, followed by 2 hrs at 60°C.
	Recoatable minimum	7 hours
	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		33 m^2 per liter base material at 25 µm dry film thickness 1325 ft^2 per US gallon base material at 1.0 mils dry film thickness
Dry Film Weight		1.60 g/m^2/µm
Semi-Gloss (60º)		15 – 50 GU.
Color		Grey color 054569 (M9001)
Flash-point	Aerodur® HS 67348	<21ºC / 70ºF
	Hardener 90150	<21ºC / 70ºF
	Activator 99302	<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® HS 67348	24 months
	Hardener 90150	24 months
	Activator 99302	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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